

Cycoloy* Resin XCY630

Europe-Africa-Middle East: COMMERCIAL

PC+ ABS Automotive applications, High Impact and High Flow, ductility at low temperature, excellent properties retention after Hydrolytic and Heat Aging

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	54	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	53	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 5 mm/min	2300	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	89	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	53	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	120	%	ISO 527
Tensile Modulus, 1 mm/min	2250	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	82	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	590	J/m	ASTM D 256
Izod Impact, notched, -30°C	430	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	55	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	67	J	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	65	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	30	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	65	kJ/m ²	ISO 179/1eA

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA All information, recommendation or advice given SABIC INNOVATIVE PLASTICS HOLDING BV, or any of its subsidiaries, affiliates or authorized representatives, whether written or oral, is given in good faith, to the best of its knowledge and based on current procedures in effect. Each user of the products shall convince himself, through all available sources (including finished product testing in its appropriate environment) of the suitability of the products supplied for its own particular purpose. Because actual use of the products the user is beyond the control of SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates, such use is in the exclusive responsibility of the user. SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates cannot be held responsible respectively liable for any loss incurred through incorrect or faulty use of the products. Information, recommendations and/or advice are neither made to infringe on any patents, nor to grant a license under any patent or intellectual property right of SABIC INNOVATIVE PLASTICS HOLDING BV or any of its subsidiaries or affiliated companies, nor to grant the right to file for any patent protection

* Cyclooy is a trademark of SABIC Innovative Plastics IP BV

© 1997-2011 SABIC Innovative Plastics Holding BV. All rights reserved

Cycoloy* Resin XCY630

Europe-Africa-Middle East: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	30	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	126	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	107	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E 831
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	Pass	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	126	°C	ISO 306
Vicat Softening Temp, Rate B/120	127	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	126	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	105	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.14	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	26	g/10 min	ASTM D 1238
Density	1.14	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.4	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	22	cm ³ /10 min	ISO 1133
Melt Viscosity, 260°C, 1500 sec-1	170	Pa-s	ISO 11443
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176;C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA All information, recommendation or advice given SABIC INNOVATIVE PLASTICS HOLDING BV, or any of its subsidiaries, affiliates or authorized representatives, whether written or oral, is given in good faith, to the best of its knowledge and based on current procedures in effect. Each user of the products shall convince himself, through all available sources (including finished product testing in its appropriate environment) of the suitability of the products supplied for its own particular purpose. Because actual use of the products the user is beyond the control of SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates, such use is in the exclusive responsibility of the user. SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates cannot be held responsible respectively liable for any loss incurred through incorrect or faulty use of the products. Information, recommendations and/or advice are neither made to infringe on any patents, nor to grant a license under any patent or intellectual property right of SABIC INNOVATIVE PLASTICS HOLDING BV or any of its subsidiaries or affiliated companies, nor to grant the right to file for any patent protection

* Cycoloy is a trademark of SABIC Innovative Plastics IP BV

© 1997-2011 SABIC Innovative Plastics Holding BV. All rights reserved

Cycoloy* Resin XCY630

Europe-Africa-Middle East: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 0.8 mm	35	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	25	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176;C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA All information, recommendation or advice given SABIC INNOVATIVE PLASTICS HOLDING BV, or any of its subsidiaries, affiliates or authorized representatives, whether written or oral, is given in good faith, to the best of its knowledge and based on current procedures in effect. Each user of the products shall convince himself, through all available sources (including finished product testing in its appropriate environment) of the suitability of the products supplied for its own particular purpose. Because actual use of the products the user is beyond the control of SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates, such use is in the exclusive responsibility of the user. SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates cannot be held responsible respectively liable for any loss incurred through incorrect or faulty use of the products. Information, recommendations and/or advice are neither made to infringe on any patents, nor to grant a license under any patent or intellectual property right of SABIC INNOVATIVE PLASTICS HOLDING BV or any of its subsidiaries or affiliated companies, nor to grant the right to file for any patent protection

* Cycoloy is a trademark of SABIC Innovative Plastics IP BV

© 1997-2011 SABIC Innovative Plastics Holding BV. All rights reserved

Cycoloy* Resin XCY630

Europe-Africa-Middle East: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	240 - 280	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	250 - 290	°C
Rear - Zone 1 Temperature	230 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 90	°C

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176;C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

PLEASE CONTACT YOUR LOCAL SALES OFFICE FOR AVAILABILITY IN YOUR AREA All information, recommendation or advice given by SABIC INNOVATIVE PLASTICS HOLDING BV, or any of its subsidiaries, affiliates or authorized representatives, whether written or oral, is given in good faith, to the best of its knowledge and based on current procedures in effect. Each user of the products shall convince himself, through all available sources (including finished product testing in its appropriate environment) of the suitability of the products supplied for its own particular purpose. Because actual use of the products by the user is beyond the control of SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates, such use is in the exclusive responsibility of the user. SABIC INNOVATIVE PLASTICS HOLDING BV, its subsidiaries and affiliates cannot be held responsible respectively liable for any loss incurred through incorrect or faulty use of the products. Information, recommendations and/or advice are neither made to infringe on any patents, nor to grant a license under any patent or intellectual property right of SABIC INNOVATIVE PLASTICS HOLDING BV or any of its subsidiaries or affiliated companies, nor to grant the right to file for any patent protection.

* Cycoloy is a trademark of SABIC Innovative Plastics IP BV

© 1997-2011 SABIC Innovative Plastics Holding BV. All rights reserved