



CYCOLAC™ Resin BDT6500

Americas: COMMERCIAL

AUTOMOTIVE. Low gloss, color concentratable for interior applications. Natural only.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Modulus, 5 mm/min	22400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	730	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24600	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	19	cm-kgf/cm	ASTM D 256
Falling Dart Impact (D 3029), 23°C	428	cm-kgf	ASTM D 3029
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	93	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	81	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	85	°C	ASTM D 648
CTE, -40°C to 60°C, flow	1.55E-04	1/°C	ASTM E 831
Relative Temp Index, Elec	60	°C	UL 746B
Relative Temp Index, Mech w/impact	60	°C	UL 746B
Relative Temp Index, Mech w/o impact	60	°C	UL 746B
PHYSICAL			
Specific Gravity	1.05	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	3.3	g/10 min	ASTM D 1238
Melt Viscosity, 260°C, 1000 sec-1	1550	poise	ASTM D 3825
Spiral Flow, 260°C, 10 ips, 3.175 X 1524 mm	863.6	mm	-
OPTICAL			
Gloss, untextured, 60 degrees	25	-	ASTM D 523
ELECTRICAL			
Hot Wire Ignition {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A





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ELECTRICAL Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	90 - 95	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	230 - 275	°C
Nozzle Temperature	230 - 275	°C
Front - Zone 3 Temperature	220 - 255	°C
Middle - Zone 2 Temperature	210 - 250	°C
Rear - Zone 1 Temperature	195 - 240	°C
Mold Temperature	50 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	30 - 60	rpm
Shot to Cylinder Size	50 - 70	%
Vent Depth	0.038 - 0.051	mm

