

Cycolac* Resin G320

Europe-Africa-Middle East: COMMERCIAL

CYCOLAC G320 is a super high impact resistant ABS grade. It combines impact resistance with high stiffness, good temperature resistance and processability. It has a good fit in automotive interiors where impact resistance is the main criteria

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	90	mg/1000cy	GE Method
Tensile Stress, yield, 5 mm/min	40	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2	%	ISO 527
Tensile Strain, break, 5 mm/min	10	%	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	15	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	63	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, H358/30	80	MPa	ISO 2039-1
Hardness, Rockwell R	109	-	ISO 2039-2
IMPACT			
Izod Impact, notched 80*10*4 +23°C	40	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	12	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	38	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	12	kJ/m ²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 60°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	93	°C	ISO 306
Vicat Softening Temp, Rate B/120	95	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	89	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	77	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.5 - 0.7	%	GE Method
Density	1.05	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Flow Rate, 220°C/10.0 kg	7	g/10 min	ISO 1133
Melt Volume Rate, MVR at 220°C/10.0 kg	7	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
Relative Permittivity, 1 MHz	2.6	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.008	-	IEC 60250
Dissipation Factor, 1 MHz	0.009	-	IEC 60250
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating (3)(4)	3.17	mm	UL 94 by GE
Glow Wire Flammability Index 650°C, passes at	1	mm	IEC 60695-2-12
FMVSS Burning Speed, thickness 1 mm	25	mm/min	FMVSS 302



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	85 - 95	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	240 - 270	°C
Nozzle Temperature	220 - 260	°C
Front - Zone 3 Temperature	230 - 270	°C
Middle - Zone 2 Temperature	210 - 250	°C
Rear - Zone 1 Temperature	210 - 250	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C

