

Cycoloy* Resin FXC810AR
Americas: COMMERCIAL

Color Package may affect performance. Visual Fx PC+ABS in various metallic (Ares) colors. High heat/good flow characteristics.
Appliance/automotive/telecommunication uses.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	520	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	450	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	50	%	ASTM D 638
Tensile Modulus, 50 mm/min	25300	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	770	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	43	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	414	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	143	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	131	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	112	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.18	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	22	g/10 min	ASTM D 1238



Cycoloy* Resin FXC810AR

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100 - 110	°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

