



CYCOLOY™ Resin C6600
Americas: COMMERCIAL

Nonbrominated, nonchlorinated FR PC+ABS with balanced flow, impact and hydrolytic stability for a wide variety of applications including business equipment, monitors, enclosures, among others.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	640	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	80	%	ASTM D 638
Tensile Modulus, 50 mm/min	30500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	950	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26700	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	56	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	520	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	520	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	99	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	83	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D 648
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	70	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Water Absorption, 24 hours	0.11	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	21.5	g/10 min	ASTM D 1238





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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, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.004	-	IEC 60250
Dissipation Factor, 1 MHz	0.006	-	IEC 60250
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	0.75	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VB Rating (3)	2	mm	UL 94





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	245 - 275	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	245 - 275	°C
Middle - Zone 2 Temperature	220 - 275	°C
Rear - Zone 1 Temperature	220 - 255	°C
Mold Temperature	60 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	30 - 80	%
Vent Depth	0.038 - 0.076	mm

• NOTE: Back Pressure, Screw Speed, Shot to Cylinder Size and Vent Depth are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

