CYCOLOY™ FR Resin RCX7233

REGION ASIA

DESCRIPTION

Cycoloy* RCX7233 (experimental grade name EXCY0355) resin is an injection moldable impact modified PC blend with non-brominated and non-chlorinated flame retardant. It contains 30% post consumer recycle content with a UL-94 V0 rating @ 0.75 mm for all color. Developed for applications require excellent flow and impact balance with thin wall flame resistance. Limited availability and restricted color only.

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	60	%	ASTM D638
Tensile Modulus, 5 mm/min	2500	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	100	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2400	MPa	ASTM D790
IMPACT [1]			
Izod Impact, notched, 23°C	690	J/m	ASTM D256
Izod Impact, notched, -30°C	130	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	57	J	ASTM D3763
Izod Impact, notched 80*10*3 +23°C	50	kJ/m²	ISO 180/1A
THERMAL [1]			
Vicat Softening Temp, Rate B/50	107	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	87	°C	ASTM D648
HDT, 0.45 MPa, 6.4 mm, unannealed	103	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	93	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.5E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ASTM E831
Relative Temp Index, Elec [2]	80	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	80	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	80	°C	UL 746B
PHYSICAL [1]			
Specific Gravity	1.19	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm [3]	0.4 – 0.6	%	SABIC method
Melt Flow Rate, 260°C/2.16 kgf	19	g/10 min	ASTM D1238
Water Absorption, (23°C/saturated)	0.15	%	ISO 62-1
ELECTRICAL [1]			
Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E207780-101883169	-	-
UL Recognized, 94V-0 Flame Class Rating	≥0.75	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating	≥0.6	mm	UL 94

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Recognized, 94V-2 Flame Class Rating	≥0.4	mm	UL 94
INJECTION MOLDING [4]			
Drying Temperature	80 – 90	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	250 – 300	°C	
Nozzle Temperature	250 – 300	°C	
Front - Zone 3 Temperature	250 – 300	°C	
Middle - Zone 2 Temperature	240 – 290	°C	
Rear - Zone 1 Temperature	230 – 280	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 85	°C	
Vent Depth	0.03 - 0.075	mm	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

(3) 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.,The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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