CYCOLAC™ FXS610SK resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics Europe

Message:

CYCOLAC FXS610SK is a multi purpose ABS injection moulding grade, providing a favourable balance of engineering properties. CYCOLAC FXS610SK is suitable for those applications that require sparkle colour effects.

General Information			
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.06	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	25	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	24.0	cm³/10min	ISO 1133
Molding Shrinkage - Flow [1]	0.50 - 0.70	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	1.0	%	ISO 62
Equilibrium, 23°C, 50% RH	0.20	%	ISO 62
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	114		ISO 2039-2
Ball Indentation Hardness (H 358/30)	98.0	MPa	ISO 2039-1
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2500	MPa	ISO 527-2/1
Tensile Stress			
Yield	45.0	MPa	ISO 527-2/5
Yield	50.0	MPa	ISO 527-2/50
Fracture	35.0	MPa	ISO 527-2/5
Fracture	40.0	MPa	ISO 527-2/50
Tensile Strain			
Yield	2.0	%	ISO 527-2/5
Yield	3.0	%	ISO 527-2/50
Fracture	9.0	%	ISO 527-2/5
Fracture	8.0	%	ISO 527-2/50
Flexural Modulus [2]	2500	MPa	ISO 178
Flexural Stress	74.0	MPa	ISO 178
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	89.0	mg	Internal method
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [3]			ISO 179/1eA
-30°C	6.0	kJ/m²	ISO 179/1eA

23°C	10	kJ/m²	ISO 179/1eA
Notched Izod Impact [4]			ISO 180/1A
-30°C	7.0	kJ/m²	ISO 180/1A
23°C	10	kJ/m²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature [5]			
0.45 MPa, unannealed, 100 mm span	92.0	°C	ISO 75-2/Be
1.8 MPa, unannealed, 100 mm span	80.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	100	°C	ISO 306/B50
--	102	°C	ISO 306/B120
Ball Pressure Test (75°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 60°C	8.0E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 60°C	8.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.20	W/m/K	ISO 8302
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Dielectric Strength			IEC 60243-1
0.800mm, in oil	35	kV/mm	IEC 60243-1
1.60mm, in oil	26	kV/mm	IEC 60243-1
3.20mm, in oil	18	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
50 Hz	2.70		IEC 60250
60 Hz	2.70		IEC 60250
1 MHz	2.60		IEC 60250
Dissipation Factor			IEC 60250
50 Hz	4.0E-3		IEC 60250
60 Hz	4.0E-3		IEC 60250
1 MHz	9.0E-3		IEC 60250
Comparative Tracking Index	600	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm, Testing by SABIC)	HB		UL 94
Glow Wire Flammability Index (1.00 mm)	650	°C	IEC 60695-2-12
Injection	**Nominal Value**	**Unit**	
Drying Temperature	85.0 - 95.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Hopper Temperature	60.0 - 80.0	°C	
Rear Temperature	200 - 240	°C	
Middle Temperature	220 - 260	°C	

Front Temperature	220 - 260	°C
Nozzle Temperature	210 - 250	°C
Processing (Melt) Temp	220 - 260	°C
Mold Temperature	40.0 - 80.0	°C

NOTE	
1.	Tensile Bar
2.	2.0 mm/min
3.	80*10*4 sp=62mm
4.	80*10*4
5.	120*10*4 mm

Recommended distributors for this material

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