

CYCOLOY™ RESIN T3RXC620S

MECHANICALLY RECYCLED ETP COMPOUND
REGION EUROPE

DESCRIPTION

CYCOLOY™ T3RXC620W resin is a PC/ABS compound, which is formulated with 30% post-consumer recycled PC. The material provides a good impact-flow balance, standard black. Typical applications include automotive exterior and interior trim.

TYPICAL PROPERTY VALUES

Revision 20260305

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	82	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	56	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	4.5	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	90	%	ASTM D638
Tensile Modulus, 50 mm/min	2200	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2250	MPa	ASTM D790
IMPACT			
Izod Impact, notched 80°10°3 +23°C	50	kJ/m²	ISO 180/1A
Izod Impact, unnotched 80°10°3 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	50	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10°4 -30°C	20	kJ/m²	ISO 180/1A
Izod Impact, unnotched 80°10°4 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80°10°4 -30°C	NB	kJ/m²	ISO 180/1U
Charpy 23°C, V-notch Edgew 80°10°4 sp=62mm	55	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80°10°4 sp=62mm	25	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80°10°4 sp=62mm	NB	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80°10°4 sp=62mm	NB	kJ/m²	ISO 179/1eU
Izod Impact, notched, 23°C	550	J/m	ASTM D256
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D4812
THERMAL			
Vicat Softening Temp, Rate B/50	129	°C	ISO 306
Vicat Softening Temp, Rate B/120	130	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80°10°4 sp=64mm	126	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80°10°4 sp=64mm	106	°C	ISO 75/Af
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ISO 11359-2

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CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test			
100°C +/- 2°C	PASS	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	129	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	105	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	118	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ASTM E831
PHYSICAL			
Density	1.14	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Water Absorption, (23°C/saturated)	0.4	%	ISO 62-1
Melt Volume Rate, MVR at 260°C/5.0 kg	20	cm³/10 min	ISO 1133
Mold Shrinkage, flow	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow	0.5 – 0.7	%	SABIC method
Specific Gravity	1.14	-	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.1	%	ASTM D570
Water Absorption, (23°C/24hrs)	0.2	%	ASTM D570
Melt Flow Rate, 260°C/5.0 kgf	23	g/10 min	ASTM D1238
INJECTION MOLDING			
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	

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