

CYCOLOY™ RESIN T3RXC620W

MECHANICALLY RECYCLED ETP COMPOUND
REGION EUROPE

DESCRIPTION

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

TYPICAL PROPERTY VALUES

Revision 20260326

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 50 mm/min	48	MPa	ISO 527
Tensile Stress, break, 50 mm/min	44	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	>100	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	71	MPa	ISO 178
Flexural Modulus, 2 mm/min	2050	MPa	ISO 178
Tensile Stress, yld, Type I, 50 mm/min	47	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	44	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	>100	%	ASTM D638
Tensile Modulus, 50 mm/min	2050	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	71	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2050	MPa	ASTM D790
IMPACT			
Izod Impact, notched 80°10°4 +23°C	55	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10°4 0°C	45	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10°4 -30°C	20	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10°3 +23°C	55	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10°3 -30°C	30	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	65	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
Multi-Axial Instrumented Impact Total Energy, 23°C	80	J	ISO 6603-2
Multi-Axial Instrumented Impact Total Energy, -30°C	90	J	ISO 6603-2
Izod Impact, notched, 23°C	750	J/m	ASTM D256
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D4812
THERMAL			
Vicat Softening Temp, Rate B/50	117	°C	ISO 306
Vicat Softening Temp, Rate B/120	118	°C	ISO 306

© 2026 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	86	°C	ISO 75/Af
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	110	°C	ISO 75/Bf
CTE, 23°C to 80°C, flow	95	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	105	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASS	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	117	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	72	°C	ASTM D648
CTE, -40°C to 40°C, flow	95	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	105	1/°C	ASTM E831
PHYSICAL			
Density	1.19	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Water Absorption, (23°C/saturated)	0.6	%	ISO 62-1
Melt Volume Rate			
260°C/5.0 kg	20	cm³/10 min	ISO 1133
265°C/5.0 kg	20	cm³/10 min	ASTM D1238
Mold Shrinkage, flow	0.6 – 0.8	%	SABIC method
Mold Shrinkage, xflow	0.6 – 0.8	%	SABIC method
Specific Gravity	1.19	-	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	22	g/10 min	ASTM D1238
INJECTION MOLDING			
Drying Temperature	110 – 120	°C	
Drying Time	4 – 6	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	265 – 275	°C	
Nozzle Temperature	260 – 275	°C	
Front - Zone 3 Temperature	260 – 280	°C	
Middle - Zone 2 Temperature	250 – 275	°C	
Rear - Zone 1 Temperature	240 – 270	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 100	°C	

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NON-INFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.

