

CYCOLACT™ RESIN BDT6500

REGION AMERICAS

DESCRIPTION

Automotive. Low gloss, color concentratable for interior applications. Natural only.

TYPICAL PROPERTY VALUES

Revision 20200803

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	48	MPa	ASTM D638
Tensile Modulus, 5 mm/min	2200	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	72	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2410	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	186	J/m	ASTM D256
Falling Dart Impact (D 3029), 23°C	42	J	ASTM D3029
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	93	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	81	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	85	°C	ASTM D648
CTE, -40°C to 60°C, flow	1.55E-04	1/°C	ASTM E831
PHYSICAL			
Specific Gravity	1.05	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 230°C/3.8 kg	3.3	g/10 min	ASTM D1238
Melt Viscosity, 260°C, 1000 sec-1	1550	Poise	ASTM D3825
Spiral Flow, 260°C, 10 ips, 3.175 X 1524 mm	863.6	mm	-
OPTICAL			
Gloss, untextured, 60 degrees	25	-	ASTM D523
INJECTION MOLDING			
Drying Temperature	90 – 95	°C	
Drying Time	2 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	230 – 275	°C	
Nozzle Temperature	230 – 275	°C	
Front - Zone 3 Temperature	220 – 255	°C	
Middle - Zone 2 Temperature	210 – 250	°C	
Rear - Zone 1 Temperature	195 – 240	°C	
Mold Temperature	50 – 80	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	
Shot to Cylinder Size	50 – 70	%	
Vent Depth	0.038 – 0.051	mm	

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CHEMISTRY THAT MATTERS™



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