

Cycolac* Resin XS712

Europe-Africa-Middle East: DEVELOPMENTAL

CYCOLAC XS712 is a high impact and low modulus ABS injection moulding grade.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	36	MPa	ISO 527
Tensile Stress, break, 50 mm/min	30	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	1800	MPa	ISO 527
IMPACT	Value	Unit	Standard
Izod Impact, notched 80*10*4 +23°C	35	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	20	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	93	°C	ISO 306
Vicat Softening Temp, Rate B/120	95	°C	ISO 306
PHYSICAL	Value	Unit	Standard
Mold Shrinkage on Tensile Bar, flow (2)	0.5 - 0.7	%	SABIC Method
Density	1.05	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Flow Rate, 220°C/10.0 kg	6	g/10 min	ISO 1133
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Compliant, 94HB Flame Class Rating (3)(4)	1.5	mm	UL 94 by GE
Glow Wire Flammability Index 650°C, passes at	1	mm	IEC 60695-2-12

Source GMD, last updated:11/02/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	85 - 95	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	220 - 260	°C
Nozzle Temperature	210 - 250	°C
Front - Zone 3 Temperature	220 - 260	°C
Middle - Zone 2 Temperature	220 - 260	°C
Rear - Zone 1 Temperature	200 - 240	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C

Source GMD, last updated:11/02/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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