

## Cycolac\* Resin Z671

## Europe-Africa-Middle East: LIMITED USE

CYCOLAC Z671 is a high rubber graft ABS industrial resin. It is an impact modifier for blending with other polymers. The physical appearance is a white coloured, free-flowing powder. The bulk density is 320 kg/m<sup>3</sup>.

### Property

| TYPICAL PROPERTIES <sup>(1)</sup>            |       |                         |             |
|--|-------|-------------------------|-------------|
| IMPACT                                       | Value | Unit                    | Standard    |
| Izod Impact, notched 80*10*4 +23°C           | 26    | kJ/m <sup>2</sup>       | ISO 180/1A  |
| Izod Impact, notched 80*10*4 -30°C           | 8     | kJ/m <sup>2</sup>       | ISO 180/1A  |
| Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm   | 26    | kJ/m <sup>2</sup>       | ISO 179/1eA |
| Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm  | 8     | kJ/m <sup>2</sup>       | ISO 179/1eA |
| THERMAL                                      | Value | Unit                    | Standard    |
| Vicat Softening Temp, Rate B/50              | 96    | °C                      | ISO 306     |
| Vicat Softening Temp, Rate B/120             | 98    | °C                      | ISO 306     |
| PHYSICAL                                     | Value | Unit                    | Standard    |
| Density                                      | 1.04  | g/cm <sup>3</sup>       | ISO 1183    |
| Melt Volume Rate, MVR at 220°C/10.0 kg       | 8     | cm <sup>3</sup> /10 min | ISO 1133    |
| FLAME CHARACTERISTICS                        | Value | Unit                    | Standard    |
| UL Compliant, 94HB Flame Class Rating (3)(4) | 1.6   | mm                      | UL 94 by GE |

Source GMD, last updated:11/11/1998

### 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:11/11/1998

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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