

Cycolac* Resin HP20

Americas: LIMITED USE

Medical applications. Superior flow/color stability. Sterilizable. USP Class VI, FDA repeat use food contact and Tripartite (modified ISO 10993-1)

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	44	MPa	ASTM D 638
Tensile Modulus, 5 mm/min	2340	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	75	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2480	MPa	ASTM D 790
Hardness, Rockwell R	110	-	ASTM D 785
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	240	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	81	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	96	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.04	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	13	g/10 min	ASTM D 1238

Source GMD, last updated:12/29/1999

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	205 - 245	°C
Nozzle Temperature	205 - 245	°C
Front - Zone 3 Temperature	205 - 225	°C
Middle - Zone 2 Temperature	200 - 210	°C
Rear - Zone 1 Temperature	190 - 200	°C
Mold Temperature	50 - 70	°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

Source GMD, last updated:12/29/1999

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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