

## Cyclocac\* Resin VW300

### Americas: COMMERCIAL

Flame retardant; excellent indoor UV properties. Excellent moldability. V0/5VA rated.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	37	MPa	ASTM D 638
Tensile Modulus, 5 mm/min	2200	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	60	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2130	MPa	ASTM D 790
Hardness, Rockwell R	101	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, notched, 23°C	160	J/m	ASTM D 256
Gardner, 23°C	20	J	ASTM D 3029
<b>THERMAL</b>			
HDT, 1.82 MPa, 3.2mm, unannealed	75	°C	ASTM D 648
Relative Temp Index, Elec	60	°C	UL 746B
Relative Temp Index, Mech w/impact	60	°C	UL 746B
Relative Temp Index, Mech w/o impact	60	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 230°C/3.8 kgf	5.5	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-0 Flame Class Rating (3)	1.49	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2	mm	UL 94

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

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

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

4) Own measurement according to UL.

Source, GMD, Last Update:10/31/2000

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>FLAME CHARACTERISTICS</b>			
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED
Oxygen Index (LOI)	30	%	ASTM D 2863
UV-light, water exposure/immersion	F2	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	80 - 90	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	205 - 230	°C
Nozzle Temperature	205 - 230	°C
Front - Zone 3 Temperature	205 - 220	°C
Middle - Zone 2 Temperature	200 - 210	°C
Rear - Zone 1 Temperature	170 - 180	°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

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