

Cycolac* Resin GHT4320

Americas: COMMERCIAL

High heat resistance with good processability. UI94 HB rated.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	51	MPa	ASTM D 638
Tensile Modulus, 5 mm/min	2410	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	86	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2620	MPa	ASTM D 790
Hardness, Rockwell R	115	-	ASTM D 785
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	186	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	13	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	102	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	90	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	95	°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
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.05	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.8	%	SABIC Method
Melt Flow Rate, 220°C/10.0 kgf	8	g/10 min	ASTM D 1238
Melt Viscosity, 260°C, 1000 sec-1	2000	poise	ASTM D 3825
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

Source GMD, last updated:12/29/1999

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	95 - 100	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	245 - 275	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	245 - 255	°C
Middle - Zone 2 Temperature	225 - 240	°C
Rear - Zone 1 Temperature	200 - 210	°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

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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