

Cycolac* Resin GPX3700

Americas: LIMITED USE

Extrusion grade. High flow, medium impact. Excellent processability/good sheet aesthetics. Good in applications utilizing color concentrates.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	42	MPa	ASTM D 638
Tensile Modulus, 5 mm/min	2130	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	72	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
Hardness, Rockwell R	105	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	411	J/m	ASTM D 256
Izod Impact, notched, -40°C	144	J/m	ASTM D 256
Falling Dart Imp, 23°C 3.2 mm extr sheet	44	J	SABIC Method
Falling Dart Imp, -40°C 3.2 mm extr sheet	16	J	SABIC Method
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	95	°C	ASTM D 648
CTE, -40°C to 95°C, flow	7.38E-05	1/°C	ASTM E 831
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			
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	1.2	g/10 min	ASTM D 1238
Melt Viscosity, 232°C, 100 sec-1	16000	poise	ASTM D 3825
OPTICAL			
Gloss, untextured, 60 deg (sheet)	97	-	ASTM D 523
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

Source GMD, last updated:12/29/1999

Processing

- Recommend initial lower temperatures settings to avoid material degradation/hang-up in die.

Parameter	Value	Unit
Sheet Extrusion		
Drying Temperature	80 - 95	°C
Drying Time	4	hrs
Maximum Moisture Content	0 - 0.02	%
Melt Temperature	215 - 260	°C
Barrel - Zone 1 Temperature	170 - 200	°C
Barrel - Zone 2 Temperature	180 - 220	°C
Barrel - Zone 3 Temperature	190 - 225	°C

Barrel - Zone 4 Temperature	200 - 240	°C
Adapter Temperature	205 - 250	°C
Die Temperature	205 - 250	°C
Roll Stack Temp - Top	90 - 95	°C
Roll Stack Temp - Middle	95 - 105	°C
Roll Stack Temp - Bottom	100 - 105	°C

Source GMD, last updated:12/29/1999

- Purge material from extruder prior to shutdown.

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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