



Cycoloy* Resin C1200

Asia Pacific: COMMERCIAL

PC+ABS, excellent impact/high heat resistance. Low temperature ductility. For automotive, appliance and electrical components.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Tensile Modulus, 50 mm/min	2270	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	88	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D 256
Izod Impact, notched, -30°C	534	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	61	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	61	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	129	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	112	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
Relative Temp Index, Elec	105	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	105	°C	UL 746B
PHYSICAL			
Specific Gravity	1.15	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 260°C/5.0 kgf	11.4	g/10 min	ASTM D 1238
ELECTRICAL			
Hot Wire Ignition (PLC)	3	PLC Code	UL 746A
High Ampere Arc Ign, surface (PLC)	1	PLC Code	UL 746A
Comparative Tracking Index (UL) (PLC)	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.19	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED

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 by this or any other material under actual fire conditions.
⁴) Own measurement according to UL.

Source, GMD, Last Update: 10/29/2002

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	275 - 300	°C
Nozzle Temperature	275 - 300	°C
Front - Zone 3 Temperature	260 - 300	°C
Middle - Zone 2 Temperature	255 - 295	°C
Rear - Zone 1 Temperature	250 - 290	°C
Mold Temperature	60 - 90	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	30 - 80	%
Vent Depth	0.038 - 0.076	mm

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