



**CYCOLOY® C1200**  
Americas: **COMMERCIAL**

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

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	61	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	2280	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
<b>IMPACT</b>			
Izod Impact, notched, 23°C	641	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
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	129	°C	ASTM D 648
HDT, 1.84 MPa, 3.2mm, unannealed	113	°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
<b>PHYSICAL</b>			
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
<b>ELECTRICAL</b>			
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
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating (3)	1.2	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 by this or any other material under actual fire conditions.  
4) Own measurement according to UL.





+ 135-3858-6433 (GuangDong)  
+ 188-1699-6168 (ShangHai)  
+ 852-6957-5415 (HongKong)

GE Plastics

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CSA (See File for complete listing)	LS88480	File No.	CSA LISTED

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
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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