



CYCOLOY® C1950
Americas: **COMMERCIAL**

Low viscosity injection molding resin.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	80	%	ASTM D 638
Tensile Modulus, 50 mm/min	2480	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	91	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2480	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	534	J/m	ASTM D 256
Izod Impact, notched, -30°C	107	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	54	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	41	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	116	°C	ASTM D 648
HDT, 1.84 MPa, 3.2mm, unannealed	99	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
Thermal Conductivity	0.2	W/m-°C	ASTM C 177
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	1.12	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.4	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 230°C/3.8 kgf	7	g/10 min	ASTM D 1238
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A

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.





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GE Plastics

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	245 - 275	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	245 - 275	°C
Middle - Zone 2 Temperature	220 - 265	°C
Rear - Zone 1 Temperature	220 - 255	°C
Mold Temperature	60 - 80	°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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