

Cycloloy* Resin C6802

Asia Pacific: LIMITED USE

Cycloloy* C6802 resin is an injection moldable PC/ABS blend. It is listed V1 at 2.0mm under UL-94 with non brominated and non chlorinated flame retardant systems. Good flow and all color options enable this grade to be an ideal candidate for thin wall applications.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	45	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	2950	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	2480	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	>40	%	ISO 527
Tensile Modulus, 1 mm/min	2700	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	85	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	421	J/m	ASTM D 256
Izod Impact, notched, -30°C	82	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	45	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	15	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	15	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	92	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	74	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, approximate maximum	80	°C	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	92	°C	ISO 306
Vicat Softening Temp, Rate B/120	95	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	72	°C	ISO 75/Ae
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	25	g/10 min	ASTM D 1238
	1.2	g/cm ³	ISO 1183
Absorption, (23°C/sat)	0.6	%	ISO 62

Moisture Absorption (23°C / 50% RH)		%	ISO 62
Melt Volume Rate, MVR at 260°C/2.16 kg	21	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-1 Flame Class Rating (3)	2	mm	UL 94

Source GMD, last updated:08/22/2005

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	75 - 80	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	230 - 265	°C
Nozzle Temperature	230 - 265	°C
Front - Zone 3 Temperature	230 - 265	°C
Middle - Zone 2 Temperature	225 - 260	°C
Rear - Zone 1 Temperature	220 - 250	°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

Source GMD, last updated:08/22/2005

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

(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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