



CYCOLAC™ Resin DL100
Americas: COMMERCIAL

CYCOLAC DL100 is a high heat, high impact, low emissions ABS/PC blend.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	440	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	90	%	ASTM D 638
Tensile Modulus, 5 mm/min	22800	kgf/cm ²	ASTM D 638
Hardness, Rockwell R	104	-	ASTM D 785
Tensile Stress, yield, 5 mm/min	46	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.5	%	ISO 527
Tensile Strain, break, 5 mm/min	60	%	ISO 527
Tensile Strain, yield, 50 mm/min	3.4	%	ISO 527
Tensile Strain, break, 50 mm/min	10	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	69	MPa	ISO 178
Flexural Modulus, 2 mm/min	2250	MPa	ISO 178
Hardness, H358/30	91	MPa	ISO 2039-1
IMPACT			
Izod Impact, notched, 23°C	71	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 23°C, 6.4mm	56	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	35	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	15	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	34	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	14	kJ/m ²	ISO 179/1eA
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	105	°C	ASTM D 648



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	88	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D 648
CTE, 23°C to 60°C, flow	9.8E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	9.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	105	°C	ISO 306
Vicat Softening Temp, Rate B/120	107	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	104	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	87	°C	ISO 75/Ae
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			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.7	%	SABIC Method
Density	1.08	g/cm ³	ISO 1183
Melt Flow Rate, 220°C/10.0 kg	7	g/10 min	ISO 1133
Melt Volume Rate, MVR at 260°C/5.0 kg	8	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	250 - 280	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	250 - 280	°C
Middle - Zone 2 Temperature	250 - 280	°C
Rear - Zone 1 Temperature	230 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C