



CYCOLAC™ Resin DL200H
Americas: COMMERCIAL

CYCOLAC DL200H is a hydrostable high heat ABS/PC blend

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	470	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	70	%	ASTM D 638
Tensile Modulus, 5 mm/min	23700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	780	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	22400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	49	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.9	%	ISO 527
Tensile Strain, break, 50 mm/min	75	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2100	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	63	cm-kgf/cm	ASTM D 256
Izod Impact, notched, 23°C, 6.4mm	50	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	56	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	21	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	65	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	30	kJ/m ²	ISO 179/1eA
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	118	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	96	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	101	°C	ASTM D 648



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THERMAL			
Vicat Softening Temp, Rate B/50	112	°C	ISO 306
Vicat Softening Temp, Rate B/120	114	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	96	°C	ISO 75/Af
PHYSICAL			
Melt Flow Rate, 260°C/5.0 kgf	25	g/10 min	ASTM D 1238
Density	1.11	g/cm ³	ISO 1183
Melt Flow Rate, 220°C/10.0 kg	9	g/10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	255 - 290	°C
Middle - Zone 2 Temperature	255 - 290	°C
Rear - Zone 1 Temperature	250 - 280	°C
Mold Temperature	75 - 100	°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