



CYCOLOY™ Resin CM8722

Americas: COMMERCIAL

High stiffness PC/ABS blend offering practical impact, low CTE, high heat resistance, with good aesthetics suitable for injection molding

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Modulus, 5 mm/min	43800	kgf/cm ²	ASTM D 638
Tensile Stress, yield, 5 mm/min	56	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.7	%	ISO 527
Tensile Strain, break, 5 mm/min	40	%	ISO 527
Tensile Modulus, 1 mm/min	4200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	100	MPa	ISO 178
Flexural Modulus, 2 mm/min	4000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	489	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	15	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	27	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -40°C to 40°C, flow	4.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	131	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	117	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Density	1.27	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg	16	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 125	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	270 - 300	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	270 - 300	°C
Middle - Zone 2 Temperature	265 - 290	°C
Rear - Zone 1 Temperature	260 - 270	°C
Mold Temperature	60 - 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



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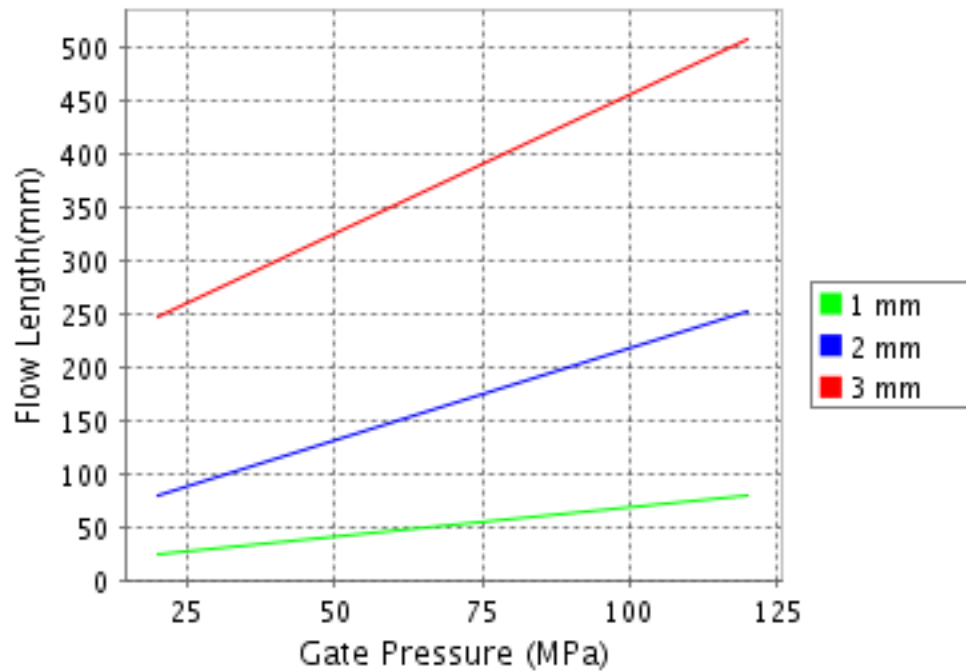
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

CYCOLOY® CM8722

Melt Temperature : 285°C

Mold Temperature : 80°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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