



CYCOLOYTM RESIN MC8800

REGION AMERICAS

DESCRIPTION

PC/ABS, high heat, high impact, low CTE.

TYPICAL PROPERTY VALUES

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	55	MPa	ISO 527
Tensile Stress, break, 5 mm/min	58	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4.2	%	ISO 527
Tensile Strain, break, 5 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	3100	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	30	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	10	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	35	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	135	°C	ISO 306
Vicat Softening Temp, Rate B/120	137	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	118	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.6	%	SABIC method
Density	1.22	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.4	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.1	%	ISO 62
Melt Volume Rate, MVR at 265°C/5.0 kg	10	cm ³ /10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	110 – 120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 300	°C	
Nozzle Temperature	270 – 300	°C	
Front - Zone 3 Temperature	270 – 300	°C	
Middle - Zone 2 Temperature	265 – 290	°C	
Rear - Zone 1 Temperature	260 – 270	°C	
Mold Temperature	75 – 100	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	