



CYCOLOY™ Resin NX07353

Asia Pacific: COMMERCIAL

CYCOLOY C7230P resin is a mineral filled, flame retardant PC/ABS. Good stiffness combined with balanced flow and impact performance, makes it a good candidate for various applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	430	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Modulus, 5 mm/min	52900	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	960	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	46100	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.8	%	ISO 527
Tensile Strain, break, 50 mm/min	30	%	ISO 527
Tensile Modulus, 1 mm/min	5580	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	99	MPa	ISO 178
Flexural Modulus, 2 mm/min	4580	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	4	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	0	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	108	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	88	°C	ASTM D 648



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THERMAL			
CTE, -40°C to 40°C, flow	4.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.9E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	107	°C	ISO 306
Vicat Softening Temp, Rate B/120	110	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	89	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.25 - 0.35	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	13	g/10 min	ASTM D 1238
Density	1.3	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.09	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.04	%	ISO 62
Melt Volume Rate, MVR at 260°C/2.16 kg	9	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.2	mm	UL 94
UL Recognized, 94-5VB Rating (3)	2	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 90	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	245 - 275	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	245 - 275	°C
Middle - Zone 2 Temperature	220 - 265	°C
Rear - Zone 1 Temperature	220 - 255	°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