

CYCOLOY™ CM4300 resin

Polycarbonate + ABS

SABIC Innovative Plastics Europe

Message:

CYCOLOY EXCY0372 is a 20% glass reinforced PC+ABS blend for injection molding purposes, featuring of balanced properties of high modulus, good flow and ductility. It is of Br- & Cl-free flame retardant systems.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Ductile		
	Flame Retardant		
	Good Flow		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	12.0	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	0.15	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	7000	MPa	ASTM D638
Tensile Stress (Break)	100	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ²	6700	MPa	ISO 178
Flexural Stress	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	80	J/m	ASTM D256
-30°C ³	9.0	kJ/m ²	ISO 180/1A
23°C ⁴	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁵ (23°C)	31	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy	11.0	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	90.0	°C	
1.8 MPa, Unannealed, 3.20 mm	94.0	°C	

Vicat Softening Temperature			
--	93.0	°C	ASTM D1525 ⁶
--	98.0	°C	ISO 306/B120
CLTE			ASTM E831
Flow : -40 to 40°C	2.0E-5	cm/cm/°C	
Transverse : -40 to 40°C	5.0E-5	cm/cm/°C	
Thermal Conductivity (50°C)	0.20	W/m/K	ASTM C177
Flammability	Nominal Value		Test Method
Flame Rating (3.00 mm)	V-1		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.010	%	
Rear Temperature	230 to 270	°C	
Middle Temperature	240 to 280	°C	
Front Temperature	250 to 280	°C	
Nozzle Temperature	250 to 280	°C	
Processing (Melt) Temp	250 to 280	°C	
Mold Temperature	80.0 to 100	°C	
Back Pressure	3.00 to 9.00	MPa	
Screw Speed	30 to 150	rpm	
NOTE			
1.	5.0 mm/min		
2.	2.0 mm/min		
3.	80*10*3		
4.	80*10*3		
5.	80*10*3		
6.	Rate B (120°C/h), Loading 2 (50 N)		

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