

CYCOLOY™ CX2244ME resin

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

CYCOLOY CX2244ME resin is a flame retardant PC/ABS blend featuring excellent balance of flow and impact together with UL-94 V0 rating at < 1mm. CYCOLOY CX2244ME resin also demonstrates improved chemical resistance to general hospital cleaners which can be considered for healthcare enclosure applications.

General Information			
UL YellowCard	E45329-564206		
Additive	Flame retardancy		
Features	Impact resistance, good		
	Good liquidity		
	Good chemical resistance		
	Flame retardancy		
Uses	Shell		
	Medical equipment		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.19	g/cm ³	ASTM D792
--	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	18	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (260°C/2.16 kg)	15.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.60	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.20	%	ISO 62
Equilibrium, 23°C, 50% RH	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2600	MPa	ASTM D638
--	2600	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	65.0	MPa	ASTM D638
Yield	65.0	MPa	ISO 527-2/50
Fracture ³	58.0	MPa	ASTM D638

Fracture	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	4.1	%	ASTM D638
Yield	4.0	%	ISO 527-2/50
Fracture ⁵	100	%	ASTM D638
Fracture	90	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2500	MPa	ASTM D790
-- ⁷	2500	MPa	ISO 178
Flexural Stress			
--	96.0	MPa	ISO 178
Yield, 50.0mm span ⁸	104	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	10	kJ/m ²	ISO 179/1eA
23°C	40	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	180	J/m	ASTM D256
23°C	700	J/m	ASTM D256
-30°C ¹⁰	10	kJ/m ²	ISO 180/1A
23°C ¹¹	40	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	65.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	89.0	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹²	93.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	110	°C	ASTM D1525, ISO 306/B50 ¹³
--	113	°C	ISO 306/B120
Ball Pressure Test (75°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	7.5E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	7.5E-5	cm/cm/°C	ASTM E831, ISO 11359-2
RTI Elec	90.0	°C	UL 746
RTI Imp	90.0	°C	UL 746
RTI	90.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI)	PLC 3		UL 746
High Amp Arc Ignition (HAI)	PLC 0		UL 746
Hot-wire Ignition (HWI)	PLC 3		UL 746
Flammability	Nominal Value	Unit	Test Method

Flame Rating			UL 94
0.750 mm	V-0		UL 94
1.50 mm	5VB		UL 94
Glow Wire Flammability Index (3.00 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (3.00 mm)	800	°C	IEC 60695-2-13

Injection	Nominal Value	Unit
Drying Temperature	80.0 - 90.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	60.0 - 80.0	°C
Rear Temperature	230 - 280	°C
Middle Temperature	240 - 290	°C
Front Temperature	250 - 300	°C
Nozzle Temperature	250 - 300	°C
Processing (Melt) Temp	250 - 300	°C
Mold Temperature	60.0 - 85.0	°C
Vent Depth	0.030 - 0.075	mm

NOTE		
1.	5.0 mm/min	
2.	Type 1, 50mm/min	
3.	Type 1, 50mm/min	
4.	Type 1, 50mm/min	
5.	Type 1, 50mm/min	
6.	1.3 mm/min	
7.	2.0 mm/min	
8.	1.3 mm/min	
9.	80*10*3 sp=62mm	
10.	80*10*3	
11.	80*10*3	
12.	80*10*4 mm	
13.	标准 B (120°C/h), 载荷2 (50N)	

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