

CYCOLAC™ DL100LG resin

Acrylonitrile Butadiene Styrene
SABIC Innovative Plastics Europe

Message:

CYCOLAC DL100LG is a low gloss, high heat, high impact ABS/PC blend with low emission

General Information			
Features	Low volatilization		
	Gloss, low		
	Impact resistance, high		
	Heat resistance, high		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR)			ISO 1133
220°C/10.0 kg	10.0	cm³/10min	ISO 1133
260°C/5.0 kg	12.0	cm³/10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 - 0.70	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	80.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2240	MPa	ASTM D638
--	2200	MPa	ISO 527-2/1
Tensile Strength			
Yield ³	47.0	MPa	ASTM D638
Yield ⁴	51.0	MPa	ASTM D638
Yield	47.0	MPa	ISO 527-2/5
Yield	51.0	MPa	ISO 527-2/50
Fracture ⁵	40.0	MPa	ASTM D638
Fracture ⁶	38.0	MPa	ASTM D638
Fracture	36.0	MPa	ISO 527-2/5
Fracture	39.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁷	4.0	%	ASTM D638
Yield ⁸	4.0	%	ASTM D638
Yield	4.0	%	ISO 527-2/5, ISO 527-2/50

Fracture ⁹	85	%	ASTM D638
Fracture ¹⁰	12	%	ASTM D638
Fracture	50	%	ISO 527-2/5
Fracture	12	%	ISO 527-2/50
Flexural Modulus ¹¹	2200	MPa	ISO 178
Flexural Stress	74.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹²			ISO 179/1eA
-30°C	11	kJ/m ²	ISO 179/1eA
23°C	22	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	120	J/m	ASTM D256
23°C	380	J/m	ASTM D256
-30°C ¹³	11	kJ/m ²	ISO 180/1A
-30°C ¹⁴	19	kJ/m ²	ISO 180/1A
23°C ¹⁵	45	kJ/m ²	ISO 180/1A
23°C ¹⁶	28	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, unannealed, 64.0mm span ¹⁷	103	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 6.40mm	85.0	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁸	84.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	118	°C	ISO 306/A50
--	120	°C	ISO 306/A120
--	105	°C	ISO 306/B50
--	107	°C	ISO 306/B120
Linear thermal expansion coefficient			ISO 11359-2
Flow: -40 to 40°C	8.2E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	8.3E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 100	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Hopper Temperature	60.0 - 80.0	°C	
Rear Temperature	230 - 260	°C	
Middle Temperature	250 - 280	°C	
Front Temperature	250 - 280	°C	
Nozzle Temperature	245 - 275	°C	
Processing (Melt) Temp	250 - 280	°C	
Mold Temperature	40.0 - 80.0	°C	
NOTE			

1.	Tensile Bar
2.	50 mm/min
3.	Type 1, 5.0 mm/min
4.	Type 1, 50mm/min
5.	Type 1, 5.0 mm/min
6.	Type 1, 50mm/min
7.	Type 1, 5.0 mm/min
8.	Type 1, 50mm/min
9.	Type 1, 5.0 mm/min
10.	Type 1, 50mm/min
11.	2.0 mm/min
12.	80*10*3 sp=62mm
13.	80*10*4
14.	80*10*3
15.	80*10*3
16.	80*10*4
17.	80*10*4 mm
18.	80*10*4 mm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

