

CYCOLOY™ RCX7243 resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

CYCOLOY* RCX7243 is an impact modified PC blend containing 30% PCR content with non-brominated and non-chlorinated FR for thin-wall applications requiring excellent impact/flow balance performance.

General Information			
UL YellowCard	E207780-102079922		
Additive	Impact modifier		
	Flame retardancy		
Recycled Content	Yes, 30%		
Features	Chlorine Free		
	Impact modification		
	Bromine-free		
	Flame retardancy		
Uses	Thin wall parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	19	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.60	%	Internal method
Water Absorption (Saturation, 23°C)	0.15	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2400	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	58.0	MPa	ASTM D638
Fracture	53.0	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	4.0	%	ASTM D638
Fracture	60	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2350	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-30°C	130	J/m	ASTM D256
23°C	690	J/m	ASTM D256
23°C ⁶	50	kJ/m ²	ISO 180/1A

Instrumented Dart Impact (23°C, Total Energy)	57.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	101	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	86.0	°C	ASTM D648
Vicat Softening Temperature	104	°C	ASTM D1525 ⁷
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	7.5E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.5E-5	cm/cm/°C	ASTM E831
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.40 mm, Testing by SABIC	V-2		UL 94
0.60 mm, Testing by SABIC	V-1		UL 94
0.75 mm, Testing by SABIC	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80 - 90	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60 - 80	°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 - 85	°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.	1.3 mm/min		
5.	1.3 mm/min		
6.	80*10*3		
7.	标准 B (120°C/h), 载荷2 (50N)		

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