

CYCOLOY™ CM8722 resin

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

High stiffness PC/ABS blend offering practical impact, low CTE, high heat resistance, with good aesthetics suitable for injection molding

General Information			
Features	High Heat Resistance		
	High Stiffness		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	16.0	cm ³ /10min	ISO 1133
Molding Shrinkage	Internal Method		
Flow : 3.20 mm	0.50 to 0.70	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4300	MPa	ASTM D638
--	4200	MPa	ISO 527-2/1
Tensile Stress			
Yield	56.0	MPa	
Break	35.0	MPa	
Tensile Strain			
Yield	3.7	%	
Break	40	%	
Flexural Modulus ²	4000	MPa	ISO 178
Flexural Stress	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	27	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C	140	J/m	ASTM D256
-30°C ⁴	8.0	kJ/m ²	ISO 180/1A
23°C ⁵	15	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	48.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶			
0.45 MPa, Unannealed, 64.0 mm Span	131	°C	ISO 75-2/Bf

1.8 MPa, Unannealed, 64.0 mm Span	117	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : -40 to 40°C	4.5E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.0E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	120 to 127	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.010	%	
Suggested Shot Size	30 to 80	%	
Rear Temperature	260 to 270	°C	
Middle Temperature	265 to 290	°C	
Front Temperature	270 to 300	°C	
Nozzle Temperature	260 to 290	°C	
Processing (Melt) Temp	270 to 300	°C	
Mold Temperature	60.0 to 100	°C	
Back Pressure	0.300 to 0.700	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.038 to 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	2.0 mm/min		
3.	80*10*3 sp=62mm		
4.	80*10*3		
5.	80*10*3		
6.	80*10*4 mm		

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