

CYCOLOY™ CY5120 resin

Polycarbonate + ABS

SABIC Innovative Plastics Asia Pacific

Message:

Non-chlorinated and non-brominated flame retardant PC/ABS offering balanced flow and impact for various applications.

General Information			
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	21	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2430	MPa	ASTM D638
Tensile Strength ² (Yield)	60.0	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	4.0	%	
Break	40	%	
Flexural Modulus ⁴ (50.0 mm Span)	2430	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	94.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	500	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	80.0	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.20 mm	V-0		
2.00 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	77.0 to 82.0	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	30 to 80	%	
Rear Temperature	210 to 254	°C	

Middle Temperature	216 to 260	°C
Front Temperature	227 to 274	°C
Nozzle Temperature	232 to 274	°C
Processing (Melt) Temp	232 to 274	°C
Mold Temperature	49.0 to 71.0	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.038 to 0.076	mm

NOTE

- | | |
|----|-------------------|
| 1. | 50 mm/min |
| 2. | Type I, 50 mm/min |
| 3. | Type I, 50 mm/min |
| 4. | 1.3 mm/min |
| 5. | 1.3 mm/min |

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