

CYCOLAC™ DL100 resin

Acrylonitrile Butadiene Styrene
SABIC Innovative Plastics Europe

Message:

CYCOLAC DL100 is a high heat, high impact, low emissions ABS/PC blend.

General Information			
UL YellowCard	E45329-236566		
Features	High Heat Resistance		
	High Impact Resistance		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 to 0.70	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	91.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ISO 527-2/1
Tensile Stress			
Yield	46.0	MPa	ISO 527-2/5
Yield	45.0	MPa	ISO 527-2/50
Tensile Strain			
Yield	3.5	%	ISO 527-2/5
Yield	3.4	%	ISO 527-2/50
Break	60	%	ISO 527-2/5
Break	10	%	ISO 527-2/50
Flexural Modulus ²	2260	MPa	ISO 178
Flexural Stress	69.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179/1eA
-30°C	14	kJ/m ²	
23°C	34	kJ/m ²	
Notched Izod Impact Strength ⁴			ISO 180/1A
-30°C	15	kJ/m ²	
23°C	35	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 100 mm Span	104	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	87.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	105	°C	ISO 306/B50
--	107	°C	ISO 306/B120
CLTE			
Flow : 23 to 60°C	9.8E-5	cm/cm/°C	
Transverse : 23 to 60°C	9.8E-5	cm/cm/°C	
Thermal Conductivity	0.20	W/m/K	ISO 8302
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	230 to 260	°C	
Middle Temperature	250 to 280	°C	
Front Temperature	250 to 280	°C	
Nozzle Temperature	245 to 275	°C	
Processing (Melt) Temp	250 to 280	°C	
Mold Temperature	40.0 to 80.0	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		
3.	80*10*4 sp=62mm		
4.	80*10*4		
5.	120*10*4 mm		

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