CYCOLAC™ RESIN DL200H

REGION ASIA

DESCRIPTION

CYCOLAC DL200H is a hydrostable high heat ABS/PC blend

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	47	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	70	%	ASTM D 638
Tensile Modulus, 5 mm/min	2330	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	77	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2200	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	49	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.9	%	ISO 527
Tensile Strain, break, 50 mm/min	75	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2100	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	620	J/m	ASTM D 256
Izod Impact, notched, 23°C, 6.4mm	500	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	56	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	21	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	65	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	30	kJ/m²	ISO 179/1eA
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	118	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	96	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	101	°C	ASTM D 648
Vicat Softening Temp, Rate B/50	112	°C	ISO 306
Vicat Softening Temp, Rate B/120	114	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	96	°C	ISO 75/Af
PHYSICAL			
Melt Flow Rate, 260°C/5.0 kgf	25	g/10 min	ASTM D 1238
Density	1.11	g/cm³	ISO 1183
Melt Flow Rate, 220°C/10.0 kg	9	g/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	100 – 105	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Maximum Moisture Content	0.04	%	
Melt Temperature	260 – 290	°C	
Nozzle Temperature	260 – 290	°C	
Front - Zone 3 Temperature	255 – 290	°C	
Middle - Zone 2 Temperature	255 – 290	°C	
Rear - Zone 1 Temperature	250 – 280	°C	
Mold Temperature	75 – 100	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	30 – 80	%	
Vent Depth	0.038 – 0.076	mm	

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