CYCOLOY™ FR RESIN CX7510

REGION ASIA

DESCRIPTION

CYCOLOY CX7510 Polycarbonate/Acrylonitrile Butadiene Styrene (PC/ABS) blend is an injection moldable, high flow, high heat resistant, non chlorinated/brominated flame retardant grade. It has a UL94 V0@1.5mm and 5VB@1.5mm flame rating. This grade has improved chemical resistance compared to standard PC/ABS blends and is a good candidate for thin wall applications.

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	49	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	36	%	ASTM D 638
Tensile Modulus, 50 mm/min	2580	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	97	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2330	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	64	MPa	ISO 527
Tensile Stress, break, 50 mm/min	48	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.5	%	ISO 527
Tensile Strain, break, 50 mm/min	36	%	ISO 527
Tensile Modulus, 1 mm/min	2540	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	99	MPa	ISO 178
Flexural Modulus, 2 mm/min	2620	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	640	J/m	ASTM D 256
Izod Impact, notched, -30°C	137	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	65	J	ASTM D 3763
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	36	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	113	°C	ASTM D 1525
HDT, 1.82 MPa, 6.4 mm, unannealed	106	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	115	°C	ISO 306
Vicat Softening Temp, Rate B/120	118	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	95	°C	ISO 75/Af
Relative Temp Index, Elec [1]	60	°C	UL 746B
Relative Temp Index, Mech w/impact [1]	60	°C	UL 746B
Relative Temp Index, Mech w/o impact [1]	60	°C	UL 746B
PHYSICAL			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Specific Gravity	1.18	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.56 – 0.63	%	SABIC method
Melt Flow Rate, 260°C/2.16 kgf	16	g/10 min	ASTM D 1238
Melt Flow Rate, 260°C/5.0 kgf	45	g/10 min	ASTM D 1238
Density	1.18	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.11	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.05	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	41	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS (1)			
UL Yellow Card Link	E207780-570688	-	-
UL Recognized, 94-5VB Flame Class Rating	≥1.5	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating	≥1.5	mm	UL 94
INJECTION MOLDING			
Drying Temperature	90 – 100	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.04	%	
Melt Temperature	270 – 300	°C	
Nozzle Temperature	265 – 300	°C	
Front - Zone 3 Temperature	265 – 300	°C	
Middle - Zone 2 Temperature	260 – 300	°C	
Rear - Zone 1 Temperature	260 – 300	°C	
Mold Temperature	60 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 80	%	
Vent Depth	0.038 – 0.076	mm	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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