CYCOLOY™ FR RESIN CX7720

REGION ASIA

DESCRIPTION

CYCOLOY CX7720 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@1.2mm, 5VA@2.5mm 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	66	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	126	%	ASTM D 638
Tensile Modulus, 50 mm/min	2860	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	99	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2810	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	65	MPa	ISO 527
Tensile Stress, break, 50 mm/min	65	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	122	%	ISO 527
Tensile Modulus, 1 mm/min	2900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	97	MPa	ISO 178
Flexural Modulus, 2 mm/min	2090	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	150	J/m	ASTM D 256
Izod Impact, notched, -30°C	63	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	62	J	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	11	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	8	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	11	kJ/m²	ISO 179/1eA
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	11	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	127	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	122	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	110	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	124	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.06E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.59E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.06E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.59E-05	1/°C	ISO 11359-2

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate B/50	127	°C	ISO 306
Vicat Softening Temp, Rate B/120	129	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	110	°C	ISO 75/Af
Relative Temp Index, Elec [1]	100	°C	UL 746B
Relative Temp Index, Mech w/impact [1]	100	°C	UL 746B
Relative Temp Index, Mech w/o impact [1]	100	°C	UL 746B
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 260°C/2.16 kgf	9	g/10 min	ASTM D 1238
Melt Flow Rate, 260°C/5.0 kgf	25	g/10 min	ASTM D 1238
Density	1.22	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.15	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.07	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	22	cm³/10 min	ISO 1133
ELECTRICAL			
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
Hot-Wire Ignition (HWI), PLC 2	≥1.5	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 3	≥0.75	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 0	≥0.75	mm	UL 746A
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E207780-100028765	-	-
UL Recognized, 94-5VA Flame Class Rating	≥2.5	mm	UL 94
UL Recognized, 94-5VB Flame Class Rating	≥1.5	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating	≥1.2	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating	≥1	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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