

Cycoloy* Resin CY100FC
Americas: COMMERCIAL

High impact PC+ABS material designed for local Pacific Automotive applications

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	540	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	540	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	21900	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	790	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	53	MPa	ISO 527
Tensile Stress, break, 50 mm/min	53	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	100	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	76	MPa	ISO 178
Flexural Modulus, 2 mm/min	2050	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	53	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	45	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	611	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	50	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	40	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	55	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	40	kJ/m ²	ISO 179/1eA

¹ Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

² Only typical data for material selection purpose. Not to be used for part or tool design.
³ This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
⁴ Own measurement according to UL.
⁵ Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

备注：以上原料物性数据由厂家发布, 我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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THERMAL			
Vicat Softening Temp, Rate B/50	127	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	102	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	127	°C	ISO 306
Vicat Softening Temp, Rate B/120	128	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	105	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.13	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.9	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	11	g/10 min	ASTM D 1238
Density	1.13	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.3	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.08	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	10	cm ³ /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	100 - 110	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	240 - 280	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	250 - 290	°C
Rear - Zone 1 Temperature	230 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	60 - 90	°C

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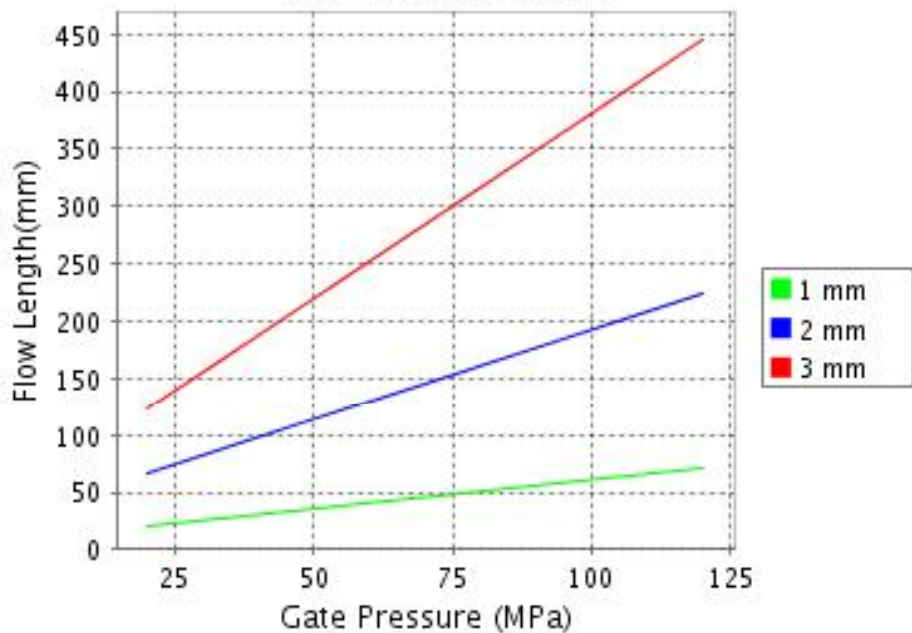
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CALCULATED FLOW LENGTH INDICATION
Moldflow® Radial Flow Analysis
Cycloloy* CY100FC
Melt Temperature : 265°C
Mold Temperature : 75°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.
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