

CYCOLOY™ RESIN C1200HF

REGION AMERICAS

DESCRIPTION

PC+ABS, excellent flow/impact/high heat resistance, Low temperature ductility.

TYPICAL PROPERTY VALUES

Revision 20260509

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	57	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D638
Tensile Modulus, 50 mm/min	2270	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	88	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4.8	%	ISO 527
Tensile Strain, break, 50 mm/min	114	%	ISO 527
Tensile Modulus, 1 mm/min	2400	MPa	ISO 527
Flexural Stress	86	MPa	ISO 178
Flexural Modulus	2250	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	587	J/m	ASTM D256
Izod Impact, notched, -30°C	480	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	54	J	ASTM D3763
Instrumented Dart Impact Total Energy, -30°C	54	J	ASTM D3763
Izod Impact, notched, 23°C, 80°10°4mm, Cut	49	kJ/m²	ISO 180/1A
Izod Impact, notched, -30°C, 80°10°4mm, Cut	34	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	129	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	112	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E831
Vicat Softening Temp, Rate B/50	130	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80°10°4 sp=64mm	130	°C	ISO 75/Bf
HDT/At, 1.8 MPa Flatw 80°10°4 sp=64mm	110	°C	ISO 75/At
Relative Temp Index, Elec	105	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	105	°C	UL 746B
PHYSICAL			
Specific Gravity	1.15	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 260°C/5.0 kgf	19	g/10 min	ASTM D1238
Melt Volume Rate, MVR at 265°C/5.0 kg	24	cm³/10 min	ISO 1133
ELECTRICAL			

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CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Hot Wire Ignition (PLC)	3	PLC Code	UL 746A
High Ampere Arc Ign, surface (PLC)	1	PLC Code	UL 746A
Comparative Tracking Index (UL) (PLC)	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Yellow Card Link	E121562-221028	-	-
UL Recognized, 94HB Flame Class Rating	1.19	mm	UL 94
INJECTION MOLDING			
Drying Temperature	100 – 110	°C	
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	275 – 300	°C	
Nozzle Temperature	275 – 300	°C	
Front - Zone 3 Temperature	260 – 300	°C	
Middle - Zone 2 Temperature	255 – 295	°C	
Rear - Zone 1 Temperature	250 – 290	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 90	°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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