

CYCOLOY™ RESIN HC1204HF

REGION EUROPE

DESCRIPTION

High heat PC/ABS blend offering good flow and excellent impact. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI).

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 Stress, brk, Type I, 50 mm/min	47	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	5	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	100	%	ASTM D638
Tensile Modulus, 5 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	2300	MPa	ASTM D790
Taber Abrasion, CS-17, 1 kg	63	mg/1000cy	SABIC method
Tensile Stress, yield, 5 mm/min	55	MPa	ISO 527
Tensile Stress, break, 5 mm/min	45	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5	%	ISO 527
Tensile Strain, break, 5 mm/min	100	%	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	>50	%	ISO 527
Tensile Modulus, 1 mm/min	2400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Ball Indentation Hardness, H358/30	96	MPa	ISO 2039-1
Hardness, Rockwell R	115	-	ISO 2039-2
IMPACT			
Izod Impact, notched, 23°C	580	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
Izod Impact, unnotched 80°10°4 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80°10°4 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	40	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10°4 -30°C	20	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80°10°4 sp=62mm	45	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80°10°4 sp=62mm	18	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80°10°4 sp=62mm	NB	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80°10°4 sp=62mm	NB	kJ/m²	ISO 179/1eU
THERMAL			

© 2026 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate B/50	130	°C	ASTM D1525
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
CTE, -40°C to 40°C, xflow	7.2E-05	1/°C	ASTM E831
Thermal Conductivity	0.2	W/m.°C	ISO 8302
CTE, 23°C to 60°C, flow	8.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	126	°C	ISO 306
Vicat Softening Temp, Rate B/120	128	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	122	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	102	°C	ISO 75/Ae
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 on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 260°C/5.0 kgf	24	g/10 min	ASTM D1238
Density	1.15	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.6	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 260°C/2.16 kg	8	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 260°C/5.0 kg	22	cm³/10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	>1.E+15	Ω.cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ω	IEC 60093
Dielectric Strength, in oil, 0.8 mm	35	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	25	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.007	-	IEC 60250
Comparative Tracking Index	250	V	IEC 60112
Relative Permittivity, 50/60 Hz	2.8	-	IEC 60250
FLAME CHARACTERISTICS			
UL Yellow Card Link	E45329-236710	-	-
UL Recognized, 94HB Flame Class Rating	1.2	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value	3	mm	UL 94
Glow Wire Flammability Index 650°C, passes at	1	mm	IEC 60695-2-12
Oxygen Index (LOI)	23	%	ISO 4589
INJECTION MOLDING			
Drying Temperature	100 – 110	°C	
Drying Time	2 – 4	Hrs	

© 2026 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.

