

CYCOLACT™ RESIN DL100

REGION EUROPE

DESCRIPTION

CYCOLAC DL100 is a high heat, high impact, low emissions ABS/PC blend.

TYPICAL PROPERTY VALUES

Revision 20190709

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	46	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.5	%	ISO 527
Tensile Strain, break, 5 mm/min	60	%	ISO 527
Tensile Strain, yield, 50 mm/min	3.4	%	ISO 527
Tensile Strain, break, 50 mm/min	10	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	69	MPa	ISO 178
Flexural Modulus, 2 mm/min	2250	MPa	ISO 178
Ball Indentation Hardness, H358/30	91	MPa	ISO 2039-1
IMPACT			
Izod Impact, notched 80°10°4 +23°C	35	kJ/m²	ISO 180/1A
Izod Impact, notched 80°10°4 -30°C	15	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80°10°4 sp=62mm	34	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80°10°4 sp=62mm	14	kJ/m²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.2	W/m.°C	ISO 8302
CTE, 23°C to 60°C, flow	9.8E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	9.8E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	105	°C	ISO 306
Vicat Softening Temp, Rate B/120	107	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm	104	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120°10°4 sp=100mm	87	°C	ISO 75/Ae
Relative Temp Index, Elec	60	°C	UL 746B
Relative Temp Index, Mech w/impact	60	°C	UL 746B
Relative Temp Index, Mech w/o impact	60	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Density	1.08	g/cm³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg	8	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Yellow Card Link	E45329-236566	-	-
UL Recognized, 94HB Flame Class Rating	1.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value	3	mm	UL 94
INJECTION MOLDING			

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CHEMISTRY THAT MATTERS™



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Temperature	90 – 100	°C	
Drying Time	2 – 4	Hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	250 – 280	°C	
Nozzle Temperature	245 – 275	°C	
Front - Zone 3 Temperature	250 – 280	°C	
Middle - Zone 2 Temperature	250 – 280	°C	
Rear - Zone 1 Temperature	230 – 260	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	40 – 80	°C	

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