

CYCOLOY™ MC1300 resin

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

CYCOLOY MC1300 resin is an injection moldable PC/ABS blend featuring excellent flow and impact performance. It is designed for plating applications mostly used in automotive industry.

General Information			
UL YellowCard	E207780-228505		
Features	Impact resistance, good		
	Electroplateable		
	Good liquidity		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	14	g/10 min	ASTM D1238
Molding Shrinkage			Internal method
Flow: 3.20mm	0.50 - 0.80	%	Internal method
Transverse flow: 3.20mm	0.50 - 0.70	%	Internal method
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2140	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	50.3	MPa	ASTM D638
Fracture	44.1	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	8.6	%	ASTM D638
Fracture	150	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2070	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	430	J/m	ASTM D256
23°C	530	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	33.9	J	ASTM D3763
23°C, Total Energy	40.7	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	116	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	98.9	°C	ASTM D648
Vicat Softening Temperature	112	°C	ASTM D1525 ⁶
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	7.2E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	9.0E-5	cm/cm/°C	ASTM E831
Thermal Conductivity	0.20	W/m/K	ASTM C177
Injection	Nominal Value	Unit	
Drying Temperature	98.9 - 104	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	30 - 80	%	
Rear Temperature	249 - 282	°C	
Middle Temperature	254 - 288	°C	
Front Temperature	254 - 288	°C	
Nozzle Temperature	260 - 288	°C	
Processing (Melt) Temp	260 - 288	°C	
Mold Temperature	76.7 - 98.9	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.038 - 0.076	mm	
NOTE			
1.	50 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		
6.	标准 B (120°C/h), 载荷2 (50N)		

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