

CYCOLAC™ DL100LG resin

Acrylonitrile Butadiene Styrene
SABIC Innovative Plastics Europe

Message:

CYCOLAC DL100LG is a low gloss, high heat, high impact ABS/PC blend with low emission

General Information			
Features	High Heat Resistance		
	High Impact Resistance		
	Low Emissions		
	Low Gloss		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	10	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR)			ISO 1133
220°C/10.0 kg	10.0	cm³/10min	
260°C/5.0 kg	12.0	cm³/10min	
Molding Shrinkage - Flow ¹	0.50 to 0.70	%	Internal Method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	80.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	2240	MPa	ASTM D638
--	2200	MPa	ISO 527-2/1
Tensile Strength			
Yield ³	47.0	MPa	ASTM D638
Yield ⁴	51.0	MPa	ASTM D638
Yield	47.0	MPa	ISO 527-2/5
Yield	51.0	MPa	ISO 527-2/50
Break ⁵	40.0	MPa	ASTM D638
Break ⁶	38.0	MPa	ASTM D638
Break	36.0	MPa	ISO 527-2/5
Break	39.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁷	4.0	%	ASTM D638
Yield ⁸	4.0	%	ASTM D638

Yield	4.0	%	ISO 527-2/5, ISO 527-2/50
Break ⁹	85	%	ASTM D638
Break ¹⁰	12	%	ASTM D638
Break	50	%	ISO 527-2/5
Break	12	%	ISO 527-2/50
Flexural Modulus ¹¹	2200	MPa	ISO 178
Flexural Stress	74.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹²			ISO 179/1eA
-30°C	11	kJ/m ²	
23°C	22	kJ/m ²	
Notched Izod Impact			
-30°C	120	J/m	ASTM D256
23°C	380	J/m	ASTM D256
-30°C ¹³	19	kJ/m ²	ISO 180/1A
-30°C ¹⁴	11	kJ/m ²	ISO 180/1A
23°C ¹⁵	45	kJ/m ²	ISO 180/1A
23°C ¹⁶	28	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 64.0 mm Span ¹⁷	103	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 6.40 mm	85.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁸	84.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	118	°C	ISO 306/A50
--	120	°C	ISO 306/A120
--	105	°C	ISO 306/B50
--	107	°C	ISO 306/B120
CLTE			ISO 11359-2
Flow : -40 to 40°C	8.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	8.3E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	230 to 260	°C	
Middle Temperature	250 to 280	°C	
Front Temperature	250 to 280	°C	
Nozzle Temperature	245 to 275	°C	
Processing (Melt) Temp	250 to 280	°C	
Mold Temperature	40.0 to 80.0	°C	

NOTE	
1.	Tensile Bar
2.	50 mm/min
3.	Type I, 5.0 mm/min
4.	Type I, 50 mm/min
5.	Type I, 5.0 mm/min
6.	Type I, 50 mm/min
7.	Type I, 5.0 mm/min
8.	Type I, 50 mm/min
9.	Type I, 5.0 mm/min
10.	Type I, 50 mm/min
11.	2.0 mm/min
12.	80*10*3 sp=62mm
13.	80*10*3
14.	80*10*4
15.	80*10*3
16.	80*10*4
17.	80*10*4 mm
18.	80*10*4 mm

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