

CYCOLOY™ CY6025 resin

Polycarbonate + ABS

SABIC Innovative Plastics Asia Pacific

Message:

CY6025 is a flame retardant (FR) PC+ABS blend with non-brominated and non-chlorinated FR systems featuring excellent flow and thin wall FR with balanced properties.

General Information			
Additive	Flame Retardant		
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
	High Flow		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	28	g/10 min	ASTM D1238
Molding Shrinkage ¹			Internal Method
Flow	0.23	%	
Across Flow	0.31	%	
Water Absorption (Saturation, 23°C)	0.29	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield	59.0	MPa	Internal Method
Yield ²	56.0	MPa	ASTM D638
Yield	57.0	MPa	ISO 527-2/50
Tensile Elongation			
Break	79	%	Internal Method
Break ³	99	%	ASTM D638
Break	99	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁴	2570	MPa	ASTM D790
-- ⁵	2880	MPa	ISO 178
Flexural Stress			
--	96.0	MPa	ISO 178
Yield, 50.0 mm Span ⁶	89.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷ (23°C)	11	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	370	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 64.0 mm Span ⁸	83.6	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	72.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	74.0	°C	ISO 75-2/Af
CLTE			ASTM E831
Flow : -40 to 40°C	7.0E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.7E-5	cm/cm/°C	
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Comparative Tracking Index (CTI)	PLC 0		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.00 mm	V-1		
1.20 mm	V-0		
1.50 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 87.8	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	30 to 80	%	
Rear Temperature	221 to 254	°C	
Middle Temperature	221 to 266	°C	
Front Temperature	243 to 277	°C	
Nozzle Temperature	243 to 277	°C	
Processing (Melt) Temp	243 to 277	°C	
Mold Temperature	60.0 to 82.2	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.038 to 0.076	mm	
NOTE			
1.	1.5 to 3.2 mm		
2.	Type I, 50 mm/min		
3.	Type I, 50 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*3 sp=62mm		

8.	80*10*4 mm
9.	80*10*4 mm

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