

CYCOLOY™ C7210A resin

Polycarbonate + ABS

SABIC Innovative Plastics Asia Pacific

Message:

Cycoloy* C7210A resin is talc-filled PC+ABS, nonhalogenated FR for thinwall molding applications. Very good modulus-ductility balance.

General Information			
UL YellowCard	E207780-228483	E45587-236943	
Filler / Reinforcement	Talc		
Additive	Flame Retardant		
Features	Flame Retardant		
	Halogen Free		
Uses	Thin-walled Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.30 to 0.50	%	
Across Flow : 3.20 mm	0.40 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3520	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	63.4	MPa	
Break	49.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	3.6	%	
Break	80	%	
Flexural Modulus ⁴ (50.0 mm Span)	3140	MPa	ASTM D790
Flexural Strength ⁵ (Break, 50.0 mm Span)	106	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	180	J/m	ASTM D256
Unnotched Izod Impact (23°C)	1900	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	47.5	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	92.2	°C	
1.8 MPa, Unannealed, 3.20 mm	82.2	°C	

Vicat Softening Temperature	102	°C	ASTM D1525 ⁶
CLTE			ASTM E831
Flow : -40 to 40°C	5.9E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.7E-5	cm/cm/°C	
RTI Elec	90.0	°C	UL 746
RTI Imp	85.0	°C	UL 746
RTI Str	90.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.19 mm	V-0		
1.98 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.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		
6.	Rate B (120°C/h), Loading 2 (50 N)		

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