

CYCOLAC™ DL100 resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics Europe

Message:

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

General Information			
Features	Low volatilization		
	Impact resistance, high		
	Heat resistance, high		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	7.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	8.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 - 0.70	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	104		ASTM D785
Ball Indentation Hardness (H 358/30)	91.0	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	44.0	MPa	ASTM D638
Yield	46.0	MPa	ISO 527-2/5
Yield	45.0	MPa	ISO 527-2/50
Tensile Strain			
Yield	3.5	%	ISO 527-2/5
Yield	3.4	%	ISO 527-2/50
Fracture ⁴	90	%	ASTM D638
Fracture	60	%	ISO 527-2/5
Fracture	10	%	ISO 527-2/50
Flexural Modulus ⁵	2260	MPa	ISO 178
Flexural Stress	69.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶			ISO 179/1eA
-30°C	14	kJ/m ²	ISO 179/1eA

23°C	34	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C	700	J/m	ASTM D256
23°C, 6.40 mm	550	J/m	ASTM D256
-30°C ⁷	15	kJ/m ²	ISO 180/1A
23°C ⁸	35	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	105	°C	ASTM D648
0.45 MPa, unannealed, 100 mm span ⁹	104	°C	ISO 75-2/Be
1.8 MPa, unannealed, 3.20mm	88.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	90.0	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹⁰	87.0	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	105	°C	ISO 306/B50
--	107	°C	ISO 306/B120
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 60°C	9.8E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 60°C	9.8E-5	cm/cm/°C	ISO 11359-2
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI	60.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 100	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Hopper Temperature	60.0 - 80.0	°C	
Rear Temperature	230 - 260	°C	
Middle Temperature	250 - 280	°C	
Front Temperature	250 - 280	°C	
Nozzle Temperature	245 - 275	°C	
Processing (Melt) Temp	250 - 280	°C	
Mold Temperature	40.0 - 80.0	°C	
NOTE			
1.	Tensile Bar		
2.	5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		

5.	2.0 mm/min
6.	80*10*4 sp=62mm
7.	80*10*4
8.	80*10*4
9.	120*10*4 mm
10.	120*10*4 mm

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