CYCOLOY™ RCX7233 resin

Polycarbonate + ABS

SABIC Innovative Plastics Asia Pacific

Message:

CYCOLOY RCX7233 (experimental grade name EXCY0355) resin is an injection moldable impact modified PC blend with non-brominated and non-chlorinated flame retardant. It contains 30% post consumer recycle content with a UL-94 V0 rating @ 0.75 mm for all color. Developed for applications require excellent flow and impact balance with thin wall flame resistance. Limited availability and restricted color only.

General Information			
UL YellowCard	E207780-101883169		
Additive	Flame Retardant Impact Modifier		
Recycled Content	Yes,30%		
Features	Bromine Free Chlorine Free Flame Retardant High Flow Impact Modified		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.19	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	19	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	Internal Method
Water Absorption (Saturation, 23°C)	0.15	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [1]	2500	MPa	ASTM D638
Tensile Strength [2]			ASTM D638
Yield	60.0	MPa	
Break	55.0	MPa	
Tensile Elongation [3]			ASTM D638
Yield	4.0	%	
Break	60	%	
Flexural Modulus [4] (50.0 mm Span)	2400	MPa	ASTM D790
Flexural Strength [5] (Yield, 50.0 mm Span)	100	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
-30°C	130	J/m	ASTM D256
23°C	690	J/m	ASTM D256

23°C [6]	50	kJ/m²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	57.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	103	°C	
1.8 MPa, Unannealed, 3.20 mm	87.0	°C	
1.8 MPa, Unannealed, 6.40 mm	93.0	°C	
Vicat Softening Temperature	107	°C	ASTM D1525 [7]
CLTE			ASTM E831
Flow : -40 to 40°C	7.5E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.5E-5	cm/cm/°C	
Flammability	**Nominal Value**		**Test Method**
Flame Rating			UL 94
0.400 mm, Testing by SABIC	V-2		
0.750 mm, Testing by SABIC	V-0		
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	60.0 to 80.0	°C	
Rear Temperature	230 to 280	°C	
Middle Temperature	240 to 290	°C	
Front Temperature	250 to 300	°C	
Nozzle Temperature	250 to 300	°C	
Processing (Melt) Temp	250 to 300	°C	
Mold Temperature	60.0 to 85.0	°C	
Vent Depth	0.030 to 0.075	mm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 50 mm/min		
3.	Type I, 50 mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		
6.	80*10*3		
7.	Rate B (120°C/h), Loading 2 (50 N)		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China