

CYCOLAC™ DL200H resin

Acrylonitrile Butadiene Styrene

SABIC Innovative Plastics

Message:

CYCOLAC DL200H is a hydrostable high heat ABS/PC blend

General Information			
Features	Heat resistance, high		
	Hydrolysis stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)			
260°C/5.0 kg	25	g/10 min	ASTM D1238
220°C/10.0 kg	9.0	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2330	MPa	ASTM D638
--	2350	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	47.0	MPa	ASTM D638
Yield	49.0	MPa	ISO 527-2/50
Fracture	40.0	MPa	ISO 527-2/50
Tensile Strain			
Yield	3.9	%	ISO 527-2/50
Fracture ³	70	%	ASTM D638
Fracture	75	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁴	2200	MPa	ASTM D790
-- ⁵	2100	MPa	ISO 178
Flexural Stress			
--	75.0	MPa	ISO 178
Yield, 50.0mm span ⁶	77.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁷			ISO 179/1eA
-30°C	30	kJ/m²	ISO 179/1eA
23°C	65	kJ/m²	ISO 179/1eA
Notched Izod Impact			
23°C	620	J/m	ASTM D256

23°C, 6.40 mm	500	J/m	ASTM D256
-40°C ⁸	21	kJ/m ²	ISO 180/1A
23°C ⁹	56	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	118	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ¹⁰	120	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	96.0	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	101	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹¹	96.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	112	°C	ISO 306/B50
--	114	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature	98.9 - 104	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	30 - 80	%	
Rear Temperature	249 - 282	°C	
Middle Temperature	254 - 288	°C	
Front Temperature	254 - 288	°C	
Nozzle Temperature	260 - 288	°C	
Processing (Melt) Temp	260 - 288	°C	
Mold Temperature	76.7 - 98.9	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.038 - 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4 sp=62mm		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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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

