

Cycoloy* Resin C6200
Americas: COMMERCIAL

Non-chlorinated, nombrominated flame retardant PC/ABS offering balanced heat, flow and impact to meet various application needs.

| TYPICAL PROPERTIES ¹ | TYPICAL VALUE | UNIT | STANDARD |
|---|---------------|---------------------|--------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 50 mm/min | 680 | kgf/cm ² | ASTM D 638 |
| Tensile Strain, brk, Type I, 50 mm/min | 50 | % | ASTM D 638 |
| Flexural Stress, yld, 2.6 mm/min, 100 mm span | 1050 | kgf/cm ² | ASTM D 790 |
| Flexural Modulus, 2.6 mm/min, 100 mm span | 27400 | kgf/cm ² | ASTM D 790 |
| IMPACT | | | |
| Izod Impact, notched, 23°C | 54 | cm-kgf/cm | ASTM D 256 |
| Instrumented Impact Energy @ peak, 23°C | 622 | cm-kgf | ASTM D 3763 |
| Instrumented Impact Energy @ peak, -30 | 553 | cm-kgf | ASTM D 3763 |
| THERMAL | | | |
| HDT, 1.82 MPa, 3.2mm, unannealed | 87 | °C | ASTM D 648 |
| HDT, 1.82 MPa, 6.4 mm, unannealed | 90 | °C | ASTM D 648 |
| Relative Temp Index, Elec | 85 | °C | UL 746B |
| Relative Temp Index, Mech w/impact | 85 | °C | UL 746B |
| Relative Temp Index, Mech w/o impact | 85 | °C | UL 746B |
| PHYSICAL | | | |
| Specific Gravity | 1.18 | - | ASTM D 792 |
| Mold Shrinkage, flow, 3.2 mm (5) | 0.4 - 0.6 | % | SABIC Method |
| Mold Shrinkage, xflow, 3.2 mm (5) | 0.4 - 0.6 | % | SABIC Method |
| Melt Flow Rate, 260°C/2.16 kgf | 14.5 | g/10 min | ASTM D 1238 |
| Spiral Flow, 260°C, 10 ips, 3.175 X 1524 mm | 685.8 | mm | - |
| ELECTRICAL | | | |
| Arc Resistance, Tungsten {PLC} | 6 | PLC Code | ASTM D 495 |

¹ Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

² Only typical data for material selection purpose. Not to be used for part or tool design.
³ This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
⁴ Own measurement according to UL.
⁵ Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 www.kedisujiao.com

备注：以上原料物性数据由厂家发布，我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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|---|---------------|----------|-------------|
| ELECTRICAL | | | |
| Hot Wire Ignition {PLC} | 2 | PLC Code | UL 746A |
| High Voltage Arc Track Rate {PLC} | 3 | PLC Code | UL 746A |
| High Ampere Arc Ign, surface {PLC} | 0 | PLC Code | UL 746A |
| Comparative Tracking Index (UL) {PLC} | 2 | PLC Code | UL 746A |
| Volume Resistivity | >1.E+15 | Ohm-cm | IEC 60093 |
| Surface Resistivity, ROA | >1.E+15 | Ohm | IEC 60093 |
| Dielectric Strength, in oil, 0.8 mm | 35 | kV/mm | IEC 60243-1 |
| Dielectric Strength, in oil, 1.6 mm | 25 | kV/mm | IEC 60243-1 |
| Dielectric Strength, in oil, 3.2 mm | 17 | kV/mm | IEC 60243-1 |
| Relative Permittivity, 50/60 Hz | 2.8 | - | IEC 60250 |
| Relative Permittivity, 1 MHz | 2.7 | - | IEC 60250 |
| Dissipation Factor, 50/60 Hz | 0.004 | - | IEC 60250 |
| Dissipation Factor, 1 MHz | 0.008 | - | IEC 60250 |
| FLAME CHARACTERISTICS | | | |
| UL Recognized, 94HB Flame Class Rating (3) | 0.71 | mm | UL 94 |
| UL Recognized, 94V-1 Flame Class Rating (3) | 1.21 | mm | UL 94 |
| UL Recognized, 94V-0 Flame Class Rating (3) | 1.47 | mm | UL 94 |
| UL Recognized, 94-5VA Rating (3) | 3.4 | mm | UL 94 |
| UL Recognized, 94-5VB Rating (3) | 2 | mm | UL 94 |

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| PROCESSING PARAMETERS | TYPICAL VALUE | UNIT |
|-----------------------------|---------------|------|
| Injection Molding | | |
| Drying Temperature | 80 - 90 | °C |
| Drying Time | 3 - 4 | hrs |
| Drying Time (Cumulative) | 8 | hrs |
| Maximum Moisture Content | 0.04 | % |
| Melt Temperature | 245 - 275 | °C |
| Nozzle Temperature | 245 - 275 | °C |
| Front - Zone 3 Temperature | 245 - 275 | °C |
| Middle - Zone 2 Temperature | 220 - 275 | °C |
| Rear - Zone 1 Temperature | 220 - 255 | °C |
| Mold Temperature | 60 - 80 | °C |
| Back Pressure | 0.3 - 0.7 | MPa |
| Screw Speed | 40 - 70 | rpm |
| Shot to Cylinder Size | 30 - 80 | % |
| Vent Depth | 0.038 - 0.076 | mm |

• NOTE: Back Pressure, Screw Speed, Shot to Cylinder Size and Vent Depth are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity.
All properties, except the melt volume rate are measured on injection moulded samples.
All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
4) Own measurement according to UL.
5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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