



CYCOLOY™ Resin LG9000
Americas: COMMERCIAL

PC/ABS low gloss.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	550	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	75	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	860	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23500	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	118	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	54	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	32	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	414	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	345	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	129	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	123	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	107	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	129	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	110	°C	ASTM D 648
CTE, -20°C to 150°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, xflow	7.2E-05	1/°C	ASTM E 831
Thermal Conductivity	0.2	W/m-°C	ASTM C 177
Relative Temp Index, Elec	60	°C	UL 746B
Relative Temp Index, Mech w/impact	60	°C	UL 746B
Relative Temp Index, Mech w/o impact	60	°C	UL 746B
PHYSICAL			
Specific Gravity	1.13	-	ASTM D 792

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(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(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.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Water Absorption, 24 hours	0.1	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.4	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	17	g/10 min	ASTM D 1238
OPTICAL			
Gloss, untextured, 60 degrees	30	-	ASTM D 523
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	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
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	275 - 300	°C
Nozzle Temperature	275 - 300	°C
Front - Zone 3 Temperature	260 - 300	°C
Middle - Zone 2 Temperature	255 - 295	°C
Rear - Zone 1 Temperature	250 - 290	°C
Mold Temperature	60 - 90	°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

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