

CYCOLOYTM FR RESIN RCY6214

REGION ASIA

DESCRIPTION

CYCOLOY RCY6214 resin is an injection moldable PC/ABS blend with non-brominated and non-chlorinated flame retardant. It contains 35% post consumer recycle content with a UL-94 VO rating @ 1.5 mm. Developed for wide variety of applications that require balanced flow and impact performance. Limited availability and restricted color only.

TYPICAL PROPERTY VALUES

Revision 20231109

MECHANICA.¹¹¹ Tensile Stress, bit, Type i, 50 mm/min 60 M36 ASTM D638 Tensile Stress, bit, Type i, 50 mm/min 47 M69 ASTM D638 Tensile Strain, Jid, Type i, 50 mm/min 4 S ASTM D638 Tensile Strain, Jid, Type i, 50 mm/min 40 % ASTM D638 Tensile Strain, Jid, Type i, 50 mm/min 90 M6a ASTM D638 Flexural Stress, yid, 1,3 mm/min, 50 mm span 90 M6a ASTM D790 Flexural Modulus, 1,3 mm/min, 50 mm span 90 M6a ASTM D790 MPACT 1¹¹ Turn March Modulus, 1,3 mm/min, 50 mm span 50 1/m ASTM D790 MPACT 1¹¹ Turn March Modulus, 1,3 mm/min, 50 mm span 50 1/m ASTM D536 MPACT 1¹¹ Turn March Modulus, 1,3 mm/min, 50 mm span 50 1/m ASTM D536 MPACT 1¹¹ Turn March Modulus, 1,3 mm/min, 50 mm span 50 1/m ASTM D536 MPACT 1¹¹ Turn March Modulus, 1,3 mm/min, 50 mm span 50 1/m ASTM D536 MPACT 1¹ March Modulus, 1,3 mm/min, 50 mm span 50 3 <	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Tensile Stress, br., Type I, 50 mm/min 47 MPa ASTM D638 Tensile Strain, Jd., Type I, 50 mm/min 40 % ASTM D638 Tensile Modulus, 50 mm/min 2500 MPa ASTM D638 Flexural Stress, Jd. 1.3 mm/min, 50 mm span 90 MPa ASTM D790 Hexural Modulus, 1.3 mm/min, 50 mm span 90 MPa ASTM D790 MPACT** TU ASTM D790 MPa ASTM D790 Instrumented Dart Impact Total Energy, 23°C 50 J ASTM D256 Instrumented Dart Impact Total Energy, 23°C 50 J ASTM D556 Instrumented Dart Impact Total Energy, 23°C 50 J ASTM D556 Instrumented Bo*10°3 *23°C 50 J ASTM D556 Instrumented Bo*10°3 *23°C 50 J ASTM D548 Instrumented Bo*10°3 *23°C 50 C ASTM D548 Instrumented Bo*10°3 *23°C 50 ASTM D548 ASTM D548 Instrumented Bo*10°3 *23°C 10 ASTM D548 ASTM D548 Instrumented Bo*10°1 *3 *23°C *3 ASTM D54	MECHANICAL (1)			
Tensile Strain, yld. Type I, 50 mm/min 4 % ASTM DG38 Tensile Strain, brk, Type I, 50 mm/min 40 % ASTM DG38 Tensile Modulus, 50 mm/min 2500 MPa ASTM DG38 Elexural Modulus, 51 mm/min, 50 mm span 400 MPa ASTM DG30 Blexural Modulus, 1.3 mm/min, 50 mm span 400 MPa ASTM DG30 IMPACT************************************	Tensile Stress, yld, Type I, 50 mm/min	60	MPa	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min 40 % ASTM D638 Tensile Modulus, 50 mm/min 2500 MPa ASTM D638 Flexural Nodulus, 13 mm/min, 50 mm span 90 MPa ASTM D790 Instrumental Stress, yld. 1.3 mm/min, 50 mm span 90 MPa ASTM D790 Instrumental Data Impact, notched, 23°C 50 Jm ASTM D256 Instrumentad Dart Impact, notched, 80°10°3 +23°C 50 Jm ASTM D3763 Izod Impact, notched, 80°10°3 +23°C 50 Jm ASTM D3763 Izod Impact, notched, 80°10°3 +23°C 50 Jm ASTM D3763 Izod Impact, notched, 90°10°3 +23°C 50 Jm ASTM D3763 Izod Impact, notched, 90°10°3 +23°C 50 20 ASTM D484 Izod Impact, notched, 90°10°3 +23°C 80 20 ASTM D548 Izod Impact, notched, 90°10°3 +23°C 80 20 ASTM D548 Izod Impact, notched, 90°10°3 +23°C 80 ASTM D548 ASTM D548 IDO, 13.2 Mm,	Tensile Stress, brk, Type I, 50 mm/min	47	MPa	ASTM D638
Fensile Modulus, 50 mm/min 2500 MPa ASTM DG38 Flexural Stress, yld, 1.3 mm/min, 50 mm span 90 MPa ASTM D790 Flexural Modulus, 1.3 mm/min, 50 mm span 2400 MPa ASTM D790 IMPACT*** VIX. ASTM D256 ASTM D256 Izod Impact, notched, 23°C 50 J m ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 J m ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 J m ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 J m ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 Q ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 Q ASTM D3763 Izod Impact, notched 80°10°3 +23°C 30 ASTM D3763 Izod Impact, notched 80°10°3 +23°C 30 ASTM D3763 Izod Impact, notched 80°10°3 +23°C 35 ASTM D3763 Izod Impact, notched 80°10°3 +23°C 35 ASTM D3763 Izod Impact, notched 80°10°3 +23°C 35 ASTM D4864 Izod Impact, notched 80°10°3 +23°C	Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span 90 MPa ASTM D790 Flexural Modulus, 1.3 mm/min, 50 mm span 2400 MPa ASTM D296 IMPACT ¹¹ V V ASTM D256 Izod Impact, notched, 23°C 500 J m ASTM D256 Izod Impact, notched 80°10°3 +23°C 50 J m ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 J m ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 J m ASTM D3763 Izod Impact, notched 80°10°3 +23°C 50 20 ASTM D3763 Izod Impact, notched 80°10°3 +23°C 90 20 ASTM D436 Izod Impact, notched 80°10°3 +23°C 30 ASTM D458 Izod Impact, notched 80°10°3 +23°C 30 ASTM D458 Izod Impact, notched 80°10°3 +23°C 40 ASTM D458 Izod Impact, notched 80°10°3 +23°C 40 ASTM D488 Izod M20, 40, 40 20 ASTM D488 Izod Coo'C, flow 31 C ASTM D488 Izod Coo'C, flow 31 C ASTM D492 <	Tensile Strain, brk, Type I, 50 mm/min	40	%	ASTM D638
Flexural Modulus, 1.3 mm/min, 50 mm span 4400 MPa ASTM D790 IMPACT ⁽¹⁾ Izod Impact, notched, 23°C 500 1/m ASTM D256 Izod Impact, notched, 80°10°3 + 23°C 50 1/m ASTM D256 Izod Impact, notched 80°10°3 + 23°C 51 20 1/m ASTM D256 Izod Impact, notched 80°10°3 + 23°C 51 20 2 ASTM D363 Izod Impact, notched 80°10°3 + 23°C 80 60 2 ASTM D1525 HDT, 1.82 MPa, 5.2 mm, unannealed 80 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 92 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 92 °C ASTM D648 CFE, 40°C to 60°C, flow 7.E Cos ASTM E831 CFE, 40°C to 60°C, flow 7.E Cos ASTM E831 Relative Temp Index, Mech w/impact (°) 85 °C U.7 468 Relative Temp Index, Mech w/impact (°) 18 S °C U.7 468 Relative Temp Index, Mech w/impact (°) 18 S S S S	Tensile Modulus, 50 mm/min	2500	MPa	ASTM D638
IMPACT (¹) IX old Impact, notched, 23°C 500 1/m ASTM D256 Instrumented Dart Impact Total Energy, 23°C 50 1/m ASTM D3763 Izod Impact, notched 80°10°3 + 23°C 51 kl/m² 15080/1A THERMAL (¹) ************************************	Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D790
Ized Impact, notched, 23°C 500 J/m ASTM D256 Instrumented Dart Impact Total Energy, 23°C 50 J/m ASTM D3763 Ized Impact, notched 80°10°3 + 23°C 51 J/m Bot 180/1A THERMALI** Vicas Offening Temp, Rate B/50 C ASTM D1525 HDT, 1.82 MPa, 3.2mm, unannealed 85 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 101 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 22 °C ASTM D648 LT, 40°C to 60°C, flow 7.1E-05 1/°C ASTM E831 CTE, 40°C to 60°C, flow 7.2E-05 1/°C ASTM E831 Relative Temp Index, Mech w/ impact (2) 85 °C U.7468 Relative Temp Index, Mech w/ impact (2) 85 °C U.7468 Relative Temp Index, Mech w/ impact (2) 85 °C U.7468 Relative Temp Index, Mech w/ impact (2) 1.8 S C U.7468 MOS ASTM D570 ASTM D57	Flexural Modulus, 1.3 mm/min, 50 mm span	2400	MPa	ASTM D790
Instrumented Dark Impact Total Energy, 23°C 50 J ASTM D3763 Izod Impact, notched 80°10°3 +23°C 51 kJ/m² ISO 180/1A THERMAL¹¹¹ Vicat Softening Temp, Rate B/50 100 °C ASTM D525 HDT, 1.82 MPa, 3.2mm, unannealed 85 °C ASTM D648 HDT, 0.45 MPa, 6.4 mm, unannealed 101 °C ASTM D648 DHT, 1.82 MPa, 6.4 mm, unannealed 22 °C ASTM D648 CFE, 40°C to 60°C, flow 7.1E·05 1/°C ASTM B831 CFE, 40°C to 60°C, flow 7.2E·05 1/°C ASTM E831 Relative Temp Index, Elec ⁽²⁾ 85 °C U. 7468 Relative Temp Index, Mech w/impact ⁽²⁾ 85 °C U. 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 °C U. 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 118 ~ ASTM D792 Water Absorption, (23°C/24hrs) 0.1 % ASTM D792 Water Absorption, (23°C/24hrs) 0.4 ~ 0.6 % ASTM D792 Mold Shrinkage, flow	IMPACT (1)			
Izod Impact, notched 80°10'3 +23°C 51 Izona	Izod Impact, notched, 23°C	500	J/m	ASTM D256
THERMAL (*) Vicat Softening Temp, Rate B/50 100 °C ASTM D1525 HDT, 1.82 MPa, 3.2mm, unannealed 85 °C ASTM D648 HDT, 0.45 MPa, 6.4 mm, unannealed 101 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 92 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 7.Ee 1°C ASTM E831 CTE, 40°C to 60°C, flow 7.Ee 1°C ASTM E831 CTE, 40°C to 60°C, flow 7.Ee 1°C ASTM E831 Relative Temp Index, Elec (*) 85 °C U.1 7468 Relative Temp Index, Mech w/ impact (*) 85 °C U.1 7468 Relative Temp Index, Mech w/ impact (*) 85 °C MI 7468 Relative Temp Index, Mech w/ impact (*) 18 °C MI 7468 PHYSICAL (*) 1 * ASTM D792 Water Absorption, (23°C/24hrs) 0.1 % ASTM D792 Mold Shrinkage, flow, 3.2 mm (*) 0.4 - 0.6 % ASTM D123 Melt Flow Rate, 260°C/2.16 kgf 2 M	Instrumented Dart Impact Total Energy, 23°C	50	J	ASTM D3763
Vicat Softening Temp, Rate B/50 100 °C ASTM D1525 HDT, 1.82 MPa, 3.2mm, unannealed 85 °C ASTM D648 HDT, 0.45 MPa, 6.4 mm, unannealed 101 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 92 °C ASTM D648 CTE, 40°C to 60°C, folow 7.16-05 1/°C ASTM E831 CTE, 40°C to 60°C, xiflow 7.26-05 1/°C ASTM E831 Relative Temp Index, Blec (²) 85 °C UL 7468 Relative Temp Index, Mech w/impact (²) 85 °C UL 7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL 7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL 7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL 7468 Welst Floravity 1.18 °C ASTM D792 Water Absorption, (23°C/24hrs) 0.4 - 0.6 % ASTM D570 Mold Shrinkage, flow, 3.2 mm (³) 0.4 - 0.6 % ASTM D1238 Bell Erion Rate, 260°C/2.16 kgf 2 ASTM D1238 ASTM D	Izod Impact, notched 80*10*3 +23°C	51	kJ/m²	ISO 180/1A
HOT, 1.82 MPa, 3.2mm, unannealed 85 °C ASTM D648 HDT, 0.45 MPa, 6.4 mm, unannealed 101 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 92 °C ASTM D648 CTE, -40°C to 60°C, filow 7.1E-05 1/°C ASTM E831 CTE, -40°C to 60°C, xiflow 7.2E-05 1/°C ASTM E831 Relative Temp Index, Elec (²) 85 °C U.7468 Relative Temp Index, Mech w/impact (²) 85 °C U.7468 Relative Temp Index, Mech w/o impact (²) 85 °C U.7468 Relative Temp Index, Mech w/o impact (²) 85 °C U.7468 Relative Temp Index, Mech w/o impact (²) 85 °C U.7468 Relative Temp Index, Mech w/o impact (²) 85 °C U.7468 Relative Temp Index, Mech w/o impact (²) 85 °C W.7468 Relative Temp Index, Mech w/o impact (²) 1.8 °C ASTM D792 Mold Shrinkage, flow, 3.2 mm (³) 0.4 -0.6 % ASTM D570 Mold Shrinkage, flow, 3.2 mm (³) 0.4 -0.6 %<	THERMAL (1)			
HDT, 0.45 MPa, 6.4 mm, unannealed 101 °C ASTM D648 HDT, 1.82 MPa, 6.4 mm, unannealed 92 °C ASTM D648 CTE, 40°C to 60°C, filow 7.1E05 1/°C ASTM E831 CTE, 40°C to 60°C, xiflow 7.2E05 1/°C ASTM E831 Relative Temp Index, Elec (²) 85 °C UL7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL7468 Relative Temp Index, Mech w/o impact (²) 85 °C UL7468 Relative Temp Index, Mech w/o impact (²) 85 S C WIT468 Relative Temp Index, Mech w/o impact (²) 118 S C ASTM D792 C Water Absorption, (23°C/24hrs) 0.1 8 ASTM D570 ASTM D570 <t< td=""><td>Vicat Softening Temp, Rate B/50</td><td>100</td><td>°C</td><td>ASTM D1525</td></t<>	Vicat Softening Temp, Rate B/50	100	°C	ASTM D1525
HDT, 1.82 MPa, 6.4 mm, unannealed 92 °C ASTM D648 CTE, 40°C to 60°C, flow 7.16.05 1/°C ASTM E831 CTE, 40°C to 60°C, xflow 7.26.05 1/°C ASTM E831 Relative Temp Index, Elec ⁽²⁾ 85 °C UL 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 °C UL 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 °C UL 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 °C UL 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 °C UL 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 °C UL 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 °C UL 7468 Relative Temp Index, Mech w/o impact ⁽²⁾ 85 Samuel Mech Willed 8 Samuel Mech Willed West Call Mech Mech w/o impact ⁽²⁾ 1.18 Samuel Mech Willed ASTM D792 Samuel Mech Willed ASTM D792 ASTM D570 Mech Mech Willed ASTM D570 Mech Mech Willed ASTM D570 Mech Mech Willed ASTM D570 Mech Mech Willed<	HDT, 1.82 MPa, 3.2mm, unannealed	85	°C	ASTM D648
CTE, 40°C to 60°C, flow 7.1E-05 1/°C ASTM E831 CTE, 40°C to 60°C, xflow 7.2E-05 1/°C ASTM E831 Relative Temp Index, Elec (²) 85 °C UL 746B Relative Temp Index, Mech w/impact (²) 85 °C UL 746B Relative Temp Index, Mech w/o impact (²) 85 °C UL 746B PHYSICAL (¹) Specific Gravity 1.18 - ASTM D792 Water Absorption, (23°C/24hrs) 0.1 % ASTM D570 Mold Shrinkage, flow, 3.2 mm (³) 0.4 − 0.6 % SABIC method Mold Shrinkage, xflow, 3.2 mm (³) 0.4 − 0.6 % SABIC method Melt Flow Rate, 260°C/2.16 kgf 21 g/10 min ASTM D1238 ELECTRICAL (¹) Hot-Wire Ignition (HWI), PLC 2 23 mm UL 746A FLAME CHARACTERISTICS (²) UL Yellow Card Link E207780-100937373 - - UL Recognized, 94V·0 Flame Class Rating ≥1,5 mm UL 94	HDT, 0.45 MPa, 6.4 mm, unannealed	101	°C	ASTM D648
CTE, 40°C to 60°C, xflow7.2E-051/°CASTM E831Relative Temp Index, Elec (2)85°CUL 746BRelative Temp Index, Mech w/impact (2)85°CUL 746BRelative Temp Index, Mech w/o impact (2)85°CUL 746BPHYSICAL (1)Specific Gravity1.18-ASTM D792Water Absorption, (23°C/24hrs)0.1%ASTM D570Mold Shrinkage, flow, 3.2 mm (3)0.4 − 0.6%ASIM CmethodMold Shrinkage, xflow, 3.2 mm (3)0.4 − 0.6%ASIM CmethodMelt Flow Rate, 260°C/2.16 kgf21g/10 minASTM D1238ELECTRICAL (1)≥3mmUL 746AFLAME CHARACTERISTICS (2)Ut Yellow Card Link£207780-100937373Ut Recognized, 94V-0 Flame Class Rating≥1.5mmUL 94	HDT, 1.82 MPa, 6.4 mm, unannealed	92	°C	ASTM D648
Relative Temp Index, Elec (2)85°CUL 746BRelative Temp Index, Mech w/impact (2)85°CUL 746BRelative Temp Index, Mech w/o impact (2)85°CUL 746BPHYSICAL (1)Specific Gravity1.18-ASTM D792Water Absorption, (23°C/24hrs)0.1%ASTM D570Mold Shrinkage, flow, 3.2 mm (3)0.4 - 0.6%SABIC methodMold Shrinkage, xflow, 3.2 mm (3)0.4 - 0.6%SABIC methodMelt Flow Rate, 260°C/2.16 kgf21g/10 minASTM D1238ELECTRICAL (1)23mmUL 746AFLAME CHARACTERISTICS (2)UL Yellow Card LinkE207780-100937373UL Yellow Card Link≥1.5mmUL 94	CTE, -40°C to 60°C, flow	7.1E-05	1/°C	ASTM E831
Relative Temp Index, Mech w/impact (2)85°CUL 746BPHYSICAL (1)Specific Gravity1.18-ASTM D792Water Absorption, (23°C/24hrs)0.1%ASTM D570Mold Shrinkage, flow, 3.2 mm (3)0.4 - 0.6%SABIC methodMolt Shrinkage, xflow, 3.2 mm (3)0.4 - 0.6%SABIC methodMelt Flow Rate, 260°C/2.16 kgf22SABIC methodELECTRICAL (1)******Hot-Wire Ignition (HWI), PLC 2\$3mmUL 746AFLAME CHARACTERISTICS (2)UL Yellow Card Link£207780-100937373***UL Recognized, 94V-0 Flame Class Rating\$1.5mmUL 94	CTE, -40°C to 60°C, xflow	7.2E-05	1/°C	ASTM E831
Relative Temp Index, Mech w/o impact (2)85°CUL 746BPHYSICAL (1)Specific Gravity1.18-ASTM D792Water Absorption, (23°C/24hrs)0.1%ASTM D570Mold Shrinkage, flow, 3.2 mm (3)0.4 - 0.6%SABIC methodMold Shrinkage, xflow, 3.2 mm (3)0.4 - 0.6%SABIC methodMelt Flow Rate, 260°C/2.16 kgf21y/o minASTM D1238ELECTRICAL (1)****MinUL 746AFLAME CHARACTERISTICS (2)******UL Yellow Card Link£207780-100937373-***UL Recognized, 94V-0 Flame Class Rating≥1.5mmUL 94	Relative Temp Index, Elec ⁽²⁾	85	°C	UL 746B
PHYSICAL (1) Specific Gravity 1.18 0.1 0.1 0.4 - 0.6 Mold Shrinkage, flow, 3.2 mm (3) Mold Shrinkage, xflow, 3.2 mm (3) Delta Flow Rate, 260°C/2.16 kgf 21 21 21 21 21 21 21 21 21 2	Relative Temp Index, Mech w/impact (2)	85	°C	UL 746B
Specific Gravity 1.18 - O.1 ASTM D792 Mold Shrinkage, flow, 3.2 mm (3) 0.4 − 0.6 % ASTM D570 Mold Shrinkage, xflow, 3.2 mm (3) 0.4 − 0.6 % SABIC method Melt Flow Rate, 260°C/2.16 kgf 21 g/10 min ASTM D1238 ELECTRICAL (1) THOt-Wire Ignition (HWI), PLC 2 ≥3 mm UL 746A FLAME CHARACTERISTICS (2) UL Yellow Card Link €207780-100937373 - - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	Relative Temp Index, Mech w/o impact (2)	85	°C	UL 746B
Water Absorption, (23°C/24hrs) 0.1 % ASTM D570 Mold Shrinkage, flow, 3.2 mm (3) 0.4 – 0.6 % SABIC method Mold Shrinkage, xflow, 3.2 mm (3) 0.4 – 0.6 % SABIC method Melt Flow Rate, 260°C/2.16 kgf 21 g/10 min ASTM D1238 ELECTRICAL (1) Thot-Wire Ignition (HWI), PLC 2 ≥3 mm UL 746A FLAME CHARACTERISTICS (2) UL Yellow Card Link E207780-100937373 - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	PHYSICAL (1)			
Mold Shrinkage, flow, 3.2 mm (3) 0.4 − 0.6 % SABIC method Mold Shrinkage, xflow, 3.2 mm (3) 0.4 − 0.6 % SABIC method Melt Flow Rate, 260°C/2.16 kgf 21 g/10 min ASTM D1238 ELECTRICAL (1) THO-Wire Ignition (HWI), PLC 2 ≥3 mm UL 746A FLAME CHARACTERISTICS (2) THAME CHARACTERISTICS (2) THO-Wire Ignition (HWI) Plane Class Rating E207780-100937373 - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	Specific Gravity	1.18	-	ASTM D792
Mold Shrinkage, xflow, 3.2 mm (3) 0.4 - 0.6 % SABIC method Melt Flow Rate, 260°C/2.16 kgf 21 g/10 min ASTM D1238 ELECTRICAL (1) FLOW Price Ignition (HWI), PLC 2 ≥3 mm UL 746A FLAME CHARACTERISTICS (2) UL Yellow Card Link £207780-100937373 - - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	Water Absorption, (23°C/24hrs)	0.1	%	ASTM D570
Melt Flow Rate, 260°C/2.16 kgf 21 g/10 min ASTM D1238 ELECTRICAL (¹) FLOW Florition (HWI), PLC 2 ≥3 mm UL 746A FLAME CHARACTERISTICS (²) UL Yellow Card Link E207780-100937373 - - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	Mold Shrinkage, flow, 3.2 mm ⁽³⁾	0.4 – 0.6	%	SABIC method
ELECTRICAL (¹) Hot-Wire Ignition (HWI), PLC 2 ≥3 mm UL 746A FLAME CHARACTERISTICS (²) UL Yellow Card Link E207780-100937373 - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	Mold Shrinkage, xflow, 3.2 mm (3)	0.4 – 0.6	%	SABIC method
Hot-Wire Ignition (HWI), PLC 2 ≥3 mm UL 746A FLAME CHARACTERISTICS (2) UL Yellow Card Link E207780-100937373 - - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	Melt Flow Rate, 260°C/2.16 kgf	21	g/10 min	ASTM D1238
FLAME CHARACTERISTICS ⁽²⁾ UL Yellow Card Link	ELECTRICAL (1)			
UL Yellow Card Link E207780-100937373 - - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
UL Yellow Card Link E207780-100937373 - - - UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94	FLAME CHARACTERISTICS (2)			
UL Recognized, 94V-0 Flame Class Rating ≥1.5 mm UL 94		F207780-100937373	-	
			mm	III 94



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Recognized, 94HB Flame Class Rating	≥0.3	mm	UL 94
INJECTION MOLDING (4)			
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 – 265	°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	

- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
- (3) 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. The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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