

Cycoloy* Resin LG9000

Americas: COMMERCIAL

PC+ABS blend, low gloss and UV-stable, suitable for automotive interior applications.

| 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 |

www. c9021.com

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.

Source, GMD, Last Update:10/31/2000

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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 | 0.5 - 0.7 | % | SABIC Method |
| Mold Shrinkage, xflow, 3.2 mm | 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 |
| CSA (See File for complete listing) | LS88480 | File No. | CSA LISTED |

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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.

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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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