

## Cycoloy\* Resin MC1300

### Americas: COMMERCIAL

Cycoloy MC1300 resin is an injection moldable PC/ABS blend with excellent flow and impact performance. It is designed for plating applications mostly used in the automotive industry.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	510	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	440	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	8.6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Tensile Modulus, 50 mm/min	21700	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	730	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21000	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	54	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	43	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
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	111	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	115	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	98	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.E-05	1/°C	ASTM E 831
Thermal Conductivity	0.2	W/m-°C	ASTM C 177
<b>PHYSICAL</b>			
Specific Gravity	1.1	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23±176.C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(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.

Source GMD, last updated:

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>PHYSICAL</b>			
Melt Flow Rate, 260°C/5.0 kgf	14	g/10 min	ASTM D 1238

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	100 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	255 - 290	°C
Middle - Zone 2 Temperature	255 - 290	°C
Rear - Zone 1 Temperature	250 - 280	°C
Mold Temperature	75 - 100	°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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