CYCOLOY™ FR Resin RCM6134

REGION ASIA

DESCRIPTION

CYCOLOY RCM6134 resin is an injection moldable filled PC/ABS blend with non-brominated and non-chlorinated flame retardant. It contains 35% post consumer recycle content with a UL-94 V0 rating @ 1.0mm. Developed for thin wall applications that require high flow and high stiffness performance. Limited availability and restricted color only.

TYPICAL PROPERTY VALUES

Revision 20241021

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 5 mm/min	54	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	44	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	3.5	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	70	%	ASTM D638
Tensile Modulus, 5 mm/min	3100	MPa	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	3100	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	56	MPa	ISO 527
Tensile Stress, break, 5 mm/min	48	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.4	%	ISO 527
Tensile Strain, break, 5 mm/min	75	%	ISO 527
Tensile Modulus, 1 mm/min	3100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	3100	MPa	ISO 178
IMPACT [1]			
Izod Impact, notched, 23°C	300	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	52	J	ASTM D3763
Izod Impact, notched 80*10*3 +23°C	20	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	11	kJ/m²	ISO 179/1eA
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	88	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	80	°C	ASTM D648
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	81	°C	ISO 75/Af
Relative Temp Index, Elec [2]	60	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	60	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	60	°C	UL 746B
PHYSICAL [1]			
Specific Gravity	1.22	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm [3]	0.3 – 0.5	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm [3]	0.3 – 0.5	%	SABIC method
Melt Flow Rate, 260°C/2.16 kgf	11	g/10 min	ASTM D1238

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
ELECTRICAL [1]			
Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E207780-100874261	-	-
UL Recognized, 94V-0 Flame Class Rating	≥1	mm	UL 94
UL Recognized, 94V-1 Flame Class Rating	≥0.8	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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