

Cycloloy* Resin CU6800

Americas: COMMERCIAL

Non-chlorinated and non-brominated flame retardant PC/ABS featuring excellent flow properties. UL-94 V1 listed at 2.0mm intended for a wide range of different applications.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	46	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3.3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	66	%	ASTM D 638
Tensile Modulus, 50 mm/min	2990	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	88	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2520	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	517	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	47	J	ASTM D 3763
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	88	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	74	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	79	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.56E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.56E-05	1/°C	ASTM E 831
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	Value	Unit	Standard
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	23	g/10 min	ASTM D 1238
Melt Flow Rate, 260°C/5.0 kgf	81	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-1 Flame Class Rating (3)	2	mm	UL 94
UL Recognized, 94-5VB Rating (3)	2	mm	UL 94

Source GMD, last updated:05/09/2001

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	75 - 80	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	230 - 265	°C

Nozzle Temperature	230 - 265	°C
Front - Zone 3 Temperature	230 - 265	°C
Middle - Zone 2 Temperature	225 - 260	°C
Rear - Zone 1 Temperature	220 - 250	°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

Source GMD, last updated:05/09/2001

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

- (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°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.

Disclaimer : THE MATERIALS AND PRODUCTS OF THE BUSINESSES MAKING UP THE SABIC INNOVATIVE PLASTICS COMPANY, ITS SUBSIDIARIES AND AFFILIATES ("SABIC IP"), ARE SOLD SUBJECT TO SABIC IP' S STANDARD CONDITIONS OF SALE, WHICH ARE INCLUDED IN THE APPLICABLE DISTRIBUTOR OR OTHER SALES AGREEMENT, PRINTED ON THE BACK OF ORDER ACKNOWLEDGMENTS AND INVOICES, AND AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION, RECOMMENDATIONS, OR ADVICE CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SABIC IP MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (I) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (II) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SABIC IP MATERIALS, PRODUCTS, RECOMMENDATIONS OR ADVICE. EXCEPT AS PROVIDED IN SABIC IP' S STANDARD CONDITIONS OF SALE, SABIC IP AND ITS REPRESENTATIVES SHALL IN NO EVENT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS MATERIALS OR PRODUCTS DESCRIBED HEREIN. Each user bears full responsibility for making its own determination as to the suitability of SABIC IP' s materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating SABIC IP materials or products will be safe and suitable for use under end-use conditions. Nothing in this or any other document, nor any oral recommendation or advice, shall be deemed to alter, vary, supersede, or waive any provision of SABIC IP' s Standard Conditions of Sale or this Disclaimer, unless any such modification is specifically agreed to in a writing signed by SABIC IP. No statement contained herein concerning a possible or suggested use of any material, product or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of SABIC Innovative Plastics Company or any of its subsidiaries or affiliates covering such use or design, or as a recommendation for the use of such material, product or design in the infringement of any patent or other intellectual property right

* Cycoloy is a trademark of the SABIC Innovative Plastics Company

© 1997-2008 SABIC Innovative Plastics Company.All rights reserved