



Cycolac* Resin DL100LG Europe-Africa-Middle East: COMMERCIAL

Cycolac DL100LG is a low gloss, high heat, high impact ABS/PC blend with low emission

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	51	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	38	MPa	ASTM D 638
Tensile Stress, yld, Type I, 5 mm/min	47	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	40	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	12	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	85	%	ASTM D 638
Tensile Modulus, 50 mm/min	2240	MPa	ASTM D 638
Tensile Stress, yield, 5 mm/min	47	MPa	ISO 527
Tensile Stress, break, 5 mm/min	36	MPa	ISO 527
Tensile Stress, yield, 50 mm/min	51	MPa	ISO 527
Tensile Stress, break, 50 mm/min	39	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4	%	ISO 527
Tensile Strain, break, 5 mm/min	50	%	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	12	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	74	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
Hardness, H358/30	80	MPa	ISO 2039-1

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(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 ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Izod Impact, notched, 23°C	380	J/m	ASTM D 256
Izod Impact, notched, -30°C	115	J/m	ASTM D 256
Izod Impact, notched 80*10*3 +23°C	45	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	19	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 +23°C	28	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	11	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	22	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	11	kJ/m ²	ISO 179/1eA
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	85	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.2E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.3E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate A/50	118	°C	ISO 306
Vicat Softening Temp, Rate A/120	120	°C	ISO 306
Vicat Softening Temp, Rate B/50	105	°C	ISO 306
Vicat Softening Temp, Rate B/120	107	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	103	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	84	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 220°C/10.0 kgf	10	g/10 min	ASTM D 1238
Density	1.08	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 220°C/10.0 kg	10	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 260°C/5.0 kg	12	cm ³ /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.1	%
Melt Temperature	250 - 280	°C
Nozzle Temperature	245 - 275	°C
Front - Zone 3 Temperature	250 - 280	°C
Middle - Zone 2 Temperature	250 - 280	°C
Rear - Zone 1 Temperature	230 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	40 - 80	°C

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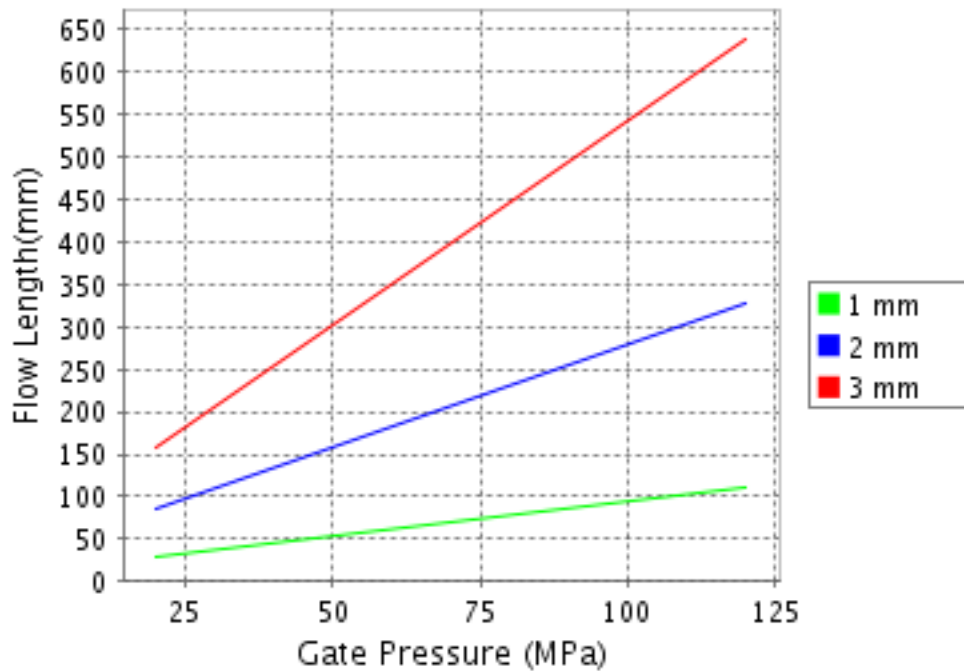
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CALCULATED FLOW LENGTH INDICATION
Moldflow® Radial Flow Analysis
Cyclocac® DL100LG
Melt Temperature : 265°C
Mold Temperature : 60°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.
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