



CYCOLOY™ Resin CM8722
Americas: COMMERCIAL

High stiffness PC/ABS blend offering practical impact, low CTE, high heat resistance, with good aesthetics suitable for injection molding

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Modulus, 5 mm/min	43800	kgf/cm ²	ASTM D 638
Tensile Stress, yield, 5 mm/min	56	MPa	ISO 527
Tensile Stress, break, 5 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.7	%	ISO 527
Tensile Strain, break, 5 mm/min	40	%	ISO 527
Tensile Modulus, 1 mm/min	4200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	100	MPa	ISO 178
Flexural Modulus, 2 mm/min	4000	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	489	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	15	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	27	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -40°C to 40°C, flow	4.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	131	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	117	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Density	1.27	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg	16	cm ³ /10 min	ISO 1133

(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.

(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.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 125	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.01	%
Melt Temperature	270 - 300	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	270 - 300	°C
Middle - Zone 2 Temperature	265 - 290	°C
Rear - Zone 1 Temperature	260 - 270	°C
Mold Temperature	60 - 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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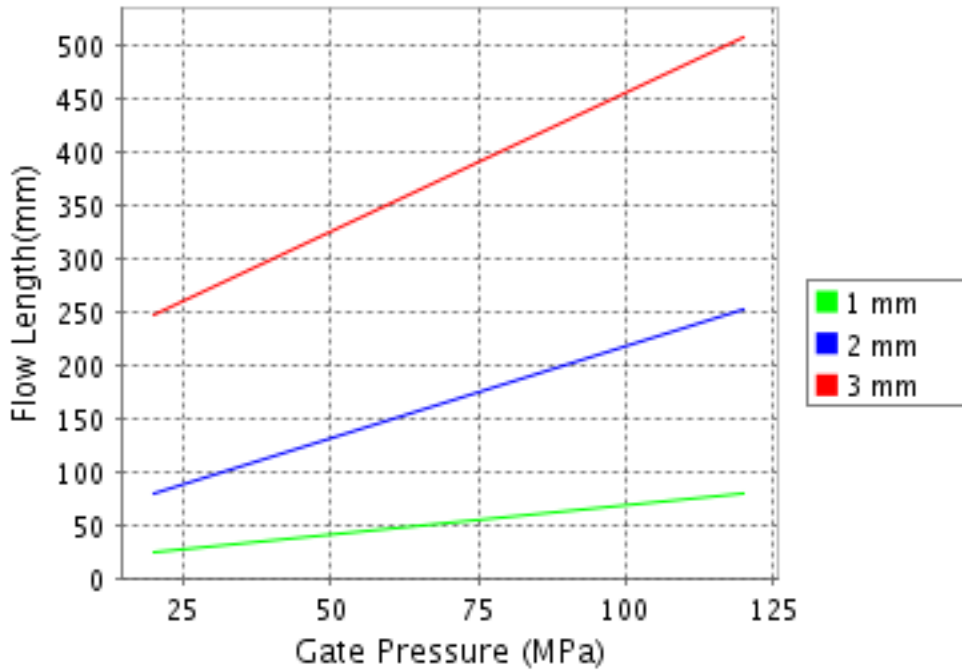
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CALCULATED FLOW LENGTH INDICATION
Moldflow® Radial Flow Analysis
CYCOLOY® CM8722
Melt Temperature : 285°C
Mold Temperature : 80°C



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