

Cycoloy* Resin CM6140
Americas: COMMERCIAL

Cycoloy resin grade CM6140 is a flame retardant, filled PC/ABS blend. It is of non-brominated & non-chlorinated FR system to meet UL94 V0 at 0.8mm. Key features include thin wall FR, higher stiffness, balanced properties in flow, impact and heat designed for various thin wall applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, yld, Type I, 5 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	500	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	35600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1010	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	33600	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.5	%	ISO 527
Tensile Strain, break, 50 mm/min	15	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	97	MPa	ISO 178
Flexural Modulus, 2 mm/min	3450	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	20	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	8	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	509	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*3 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	5	kJ/m ²	ISO 179/1eA

¹ Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 230C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

² Only typical data for material selection purpose. Not to be used for part or tool design.
³ This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.
⁴ Own measurement according to UL.
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.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

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THERMAL			
Vicat Softening Temp, Rate B/50	91	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	83	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	97	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	89	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	5.5E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	98	°C	ISO 306
Vicat Softening Temp, Rate B/120	102	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	80	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.26	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Moisture Absorption, 50% RH, 24 hrs	0.01	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.3 - 0.5	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.4 - 0.6	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	17.5	g/10 min	ASTM D 1238
Density	1.25	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.09	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.01	%	ISO 62
Melt Volume Rate, MVR at 220°C/5.0 kg	14	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	2.68E+16	Ohm-cm	ASTM D 257

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
ELECTRICAL			
Surface Resistivity	3.54E+15	Ohm	ASTM D 257
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	0.6	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.8	mm	UL 94
UL Recognized, 94-5VB Rating (3)	1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at	0.8	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	850	°C	IEC 60695-2-13
Glow Wire Ignitability Temperature, 3.0 mm	800	°C	IEC 60695-2-13

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	90	°C
Drying Time	>4	hrs
Maximum Moisture Content	0.04	%
Melt Temperature	275 - 300	°C
Nozzle Temperature	280 - 300	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	275 - 300	°C
Rear - Zone 1 Temperature	275 - 300	°C
Mold Temperature	60 - 80	°C

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