

**Cycology\* 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.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	610	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	470	kgf/cm <sup>2</sup>	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	30500	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	890	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25700	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	52	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	487	cm-kgf	ASTM D 3763
<b>THERMAL</b>			
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
<b>PHYSICAL</b>			
Specific Gravity	1.2	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/2.16 kgf	23	g/10 min	ASTM D 1238

<sup>1</sup> Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

<sup>2</sup> Only typical data for material selection purpose. Not to be used for part or tool design.  
<sup>3</sup> This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
<sup>4</sup> Own measurement according to UL.  
<sup>5</sup> 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.

如需要更多物性资料请查阅 [www.kedisujiao.com](http://www.kedisujiao.com)

备注：以上原料物性数据由厂家发布，我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>PHYSICAL</b>			
Melt Flow Rate, 260°C/5.0 kgf	81	g/10 min	ASTM D 1238
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-1 Flame Class Rating (3)	2	mm	UL 94
UL Recognized, 94-5VB Rating (3)	2	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
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

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