

Cycoloy* Resin MC5220

Europe-Africa-Middle East: COMMERCIAL

CYCOLOY MC5220 is a 20% glass reinforced PC+ABS blend for injection moulding purposes.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield, 5 mm/min	107	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	113	MPa	ISO 178
Flexural Modulus, 2 mm/min	5880	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	3.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	5.E-05	1/°C	ISO 11359-2
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.2 - 0.4	%	GE Method
Density	1.33	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 260°C/5.0 kg	27	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+16	Ohm-cm	IEC 60093
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.5	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	100 - 110	°C
Drying Time	2 - 4	hrs
Melt Temperature	240 - 280	°C
Mold Temperature	50 - 80	°C

