



**CP01-N0002**

**ABS**

Low Flow, Medium Impact

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Physical	Method	Typical Value	Units
Melt Flow (230°C / 3.8kg)	ASTM D1238	2.0	g/10 min
Specific Gravity	ASTM D792	1.05	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.006	in/in

**Impact**

Notched Izod Impact (.125 in) 73°F	ASTM D256	3.5	ft-lbs/in
Gardner Impact (.125 in) 73°F	ASTM D5420	60	in-lbs

**Mechanical**

Tensile Strength @ Yield	ASTM D638	6,600	psi
Tensile Elongation @ Yield	ASTM D638	7.5	%
Flexural Strength @ Yield	ASTM D790	10,800	psi
Flexural Modulus	ASTM D790	330,000	psi

**Thermal**

Deflection Temperature Under Load .125 in, 264 psi	ASTM D648	178	°F
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Information provided is based on typical values from reliable procedures. Values are based on natural or black materials unless otherwise noted. No guarantees or warranties of any kind are expressed or implied. Users are responsible for determining the suitability of the product for their intended application.

**Recommended Processing Parameters**

Drying Temperature	175°F
Drying Time	3-4 hrs.
Suggested Maximum Moisture Content	0.07%
Rear Temperature	440 - 470 °F
Middle Temperature	450 - 480 °F
Front Temperature	460 - 480 °F
Nozzle Temperature	460 - 480 °F
Processing (Melt) Temperature	450 - 480 °F
Mold Temperature	100 - 140 °F

CPPT recommended processing parameters are meant to serve as guidelines only and are not intended to be used for specification purposes. Conditions should be adjusted to optimize material performance with the equipment part design and tooling.