



**CP01-N0007**

**ABS**

Flame Retardant

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Physical	Method	Typical Value	Units
Melt Flow (200°C / 5.0kg)	ASTM D1238	3.5	g/10 min
Specific Gravity	ASTM D792	1.15	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.0035	in/in

**Impact**

Notched Izod Impact (.126 in) 73°F	ASTM D256	3.4	ft-lbs/in
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**Mechanical**

Tensile Strength @ Yield	ASTM D638	5,700	psi
Tensile Elongation @ Break	ASTM D638	18.0	%
Flexural Strength	ASTM D790	7,700	psi
Flexural Modulus	ASTM D790	290,000	psi

**Thermal**

Deflection Temperature Under Load			
.252 in, 66 psi	ASTM D648	214	°F
.252 in, 264 psi	ASTM D648	176	°F

**Flammability**

Flame Rating @ 1.5 mm	UL 94	V-0	-
Flame Rating @ 2.5 mm	UL 94	V-0, 5VB	-
Flame Rating @ 3.0 mm	UL 94	V-0, 5VA	-

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	180°F
Drying Time	2-4 hrs.
Suggested Maximum Moisture Content	0.10%
Rear Temperature	350 - 375 °F
Middle Temperature	380 - 400 °F
Front Temperature	390 - 410 °F
Nozzle Temperature	400 - 420 °F
Processing (Melt) Temperature	370 - 410 °F
Mold Temperature	100 - 160 °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.