CP01-N0007

ABS

Flame Retardant

CrossPoint Polymer Technologies

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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
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	-

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