



CP01-N0031

ABS

High Flow, High Impact

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Physical	Method	Typical Value	Units
Melt Flow (230°C / 3.8kg)	ASTM D1238	6.5	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	5.6	ft-lbs/in
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Mechanical

Tensile Strength @ Yield	ASTM D638	7,500	psi
Tensile Elongation @ Break	ASTM D638	40.0	%
Flexural Strength	ASTM D790	10,200	psi
Flexural Modulus	ASTM D790	339,000	psi

Thermal

Deflection Temperature Under Load			
.252 in, 66 psi	ASTM D648	205	°F
.252 in, 264 psi	ASTM D648	189	°F

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	190°F
Drying Time	3-4 hrs.
Suggested Maximum Moisture Content	0.07%
Rear Temperature	390 - 420 °F
Middle Temperature	410 - 440 °F
Front Temperature	440 - 480 °F
Nozzle Temperature	450 - 490 °F
Processing (Melt) Temperature	430 - 490 °F
Mold Temperature	120 - 150 °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.