



CP01-N0033

ABS

High Heat Resistance, High Impact, Low Gloss

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Physical	Method	Typical Value	Units
Melt Flow (220°C / 10.0kg)	ISO 1133	8.0	g/10 min
Density	ISO 1183	1.04	g/cm ³
Mold Shrink, Linear Flow (3.2mm)	ISO 294-4	0.4 - 0.8	%

Impact

Notched Izod Impact (23°C)	ISO 180/1A	21.0	kJ/m ²
Notched Charpy Impact (23°C)	ISO 179/1eA	21.0	kJ/m ²

Mechanical

Tensile Strength @ Yield (50mm/min)	ISO 527	52	MPa
Tensile Modulus (1mm/min)	ISO 527	2,440	MPa
Flexural Strength (2mm/min)	ISO 178	79	MPa
Flexural Modulus (2mm/min)	ISO 178	2,400	MPa

Thermal

Deflection Temperature Under Load (1.8Mpa)	ISO 75/Be	85	°C
Vicat Softening Temperature (50N, 50°C/h)	ISO 306	101	°C

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	80 - 90°C
Drying Time	3-4 hrs.
Suggested Maximum Moisture Content	0.07%
Rear Temperature	180 - 210 °C
Middle Temperature	210 - 230 °C
Front Temperature	230 - 240 °C
Nozzle Temperature	230 - 240 °C
Processing (Melt) Temperature	230 - 260 °C
Mold Temperature	40 - 60 °C

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.