



CP09-N0003

Polycarbonate

Good Flow, w/ Release

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Physical	Method	Typical Value	Units
Melt Flow	ASTM D1238	20	g/10 min
Specific Gravity	ASTM D792	1.20	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.006	in/in

Impact

Notched Izod Impact (.125 in) 73°F	ASTM D256	13	ft-lbs/in
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Mechanical

Tensile Strength @ Yield	ASTM D638	8,800	psi
Tensile Elongation @ Break	ASTM D638	>100	%
Flexural Strength	ASTM D790	13,500	psi
Flexural Modulus	ASTM D790	335,000	psi

Thermal

Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	278	°F
.250 in, 264 psi	ASTM D648	263	°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	250°F
Drying Time	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	490 - 530 °F
Middle Temperature	510 - 550 °F
Front Temperature	530 - 570 °F
Nozzle Temperature	520 - 560 °F
Processing (Melt) Temperature	530 - 570 °F
Mold Temperature	160 - 200 °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.