



CP09-N0063

Polycarbonate

20% Glass Fiber Reinforcement

Mold Release

5401 N Hwy 41 / Suite 1000 Evansville, IN 47711 • Phone: 812.426.1350 • FAX: 888.855.3671 • www.cpptech.com

Physical	Method	Typical Value	Units
Melt Flow	ASTM D1238	15	g/10 min
Specific Gravity	ASTM D792	1.32	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.004	in/in
Impact			
Notched Izod Impact (.125 in) 73°F	ASTM D256	2.0	ft-lbs/in
Mechanical			
Tensile Strength @ Yield	ASTM D638	12,500	psi
Tensile Elongation @ Break	ASTM D638	4.5	%
Flexural Strength	ASTM D790	20,500	psi
Flexural Modulus	ASTM D790	760,000	psi
Thermal			
Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	292	°F
.250 in, 264 psi	ASTM D648	285	°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	2.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	540 - 580 °F
Middle Temperature	560 - 600 °F
Front Temperature	580 - 620 °F
Nozzle Temperature	570 - 610 °F
Processing (Melt) Temperature	580 - 620°F
Mold Temperature	180 - 240 °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.