CP09-N0114

Polycarbonate

10% Glass Fiber Reinforcement

High Flow, Impact Modified, UV Stabilized, w/ Release

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Physical	Method	Typical Value	Units
Melt Flow	ASTM D1238	22	g/10 min
Specific Gravity	ASTM D792	1.26	
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	9,500	psi
Tensile Elongation @ Break	ASTM D638	12	%
Flexural Strength	ASTM D790	14,000	psi
Flexural Modulus	ASTM D790	480,000	psi
Thermal			
Deflection Temperature Under Load			
.25 in, 66 psi	ASTM D648	293	°F
.25 in, 264 psi	ASTM D648	286	°F

Recommended Processing Parameters

Drying Temperature	250°F
Drying Time	2.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	530 - 580 °F
Middle Temperature	550 - 600 °F
Front Temperature	570 - 620°F
Nozzle Temperature	560 - 610°F
Processing (Melt) Temperature	570 - 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.