



CP09-U2001-4
Polycarbonate

Standard Flow, UL Recognized Flame Rating, UV Stabilized, w/ Release

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Physical	Method	Typical Value	Units
Melt Flow Rate (300°C/1.2kg)	ASTM D1238	12	g/10 min
Specific Gravity	ASTM D792	1.21	-
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.006	in/in
Impact			
Notched Izod Impact (.125 in) 73°F	ASTM D256	12	ft-lbf/in
Mechanical			
Tensile Strength @ Yield	ASTM D638	8,500	psi
Tensile Elongation @ Break	ASTM D638	75	%
Flexural Strength	ASTM D790	12,500	psi
Flexural Modulus	ASTM D790	320,000	psi
Thermal			
Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	278	°F
.250 in, 264 psi	ASTM D648	268	°F
Flammability			
Flame Rating @ 1.5 mm	UL 94	V-0	-
Flame Rating @ 3.0 mm	UL 94	5VA	-

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	510 - 550 °F
Middle Temperature	530 - 570 °F
Front Temperature	550 - 590 °F
Nozzle Temperature	540 - 580 °F
Processing (Melt) Temperature	550 - 590 °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.