CP51-N0036

Polycarbonate / ABS Alloy

20% Glass Fiber Filled, UV Stabilized, Good Mold Release

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Physical	Method	Typical Value	Units
Melt Flow @ 260°C / 5.0kg	ASTM D1238	18	g/10 min
Specific Gravity	ASTM D792	1.27	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.004	in/in
Impact			
Notched Izod Impact (.125 in)			
73°F	ASTM D256	1.7	ft-lbs/in
Mechanical			
Tensile Strength @ Yield	ASTM D638	11,000	psi
Tensile Elongation @ Break	ASTM D638	3.5	%
Flexural Strength	ASTM D790	17,500	psi
Flexural Modulus	ASTM D790	750,000	psi
Thermal			
Deflection Temperature Under Load			
66 psi	ASTM D648	302	°F
264 psi	ASTM D648	285	°F

Recommended Processing Parameters

Drying Temperature	225°F
Drying Time	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	480 - 520 °F
Middle Temperature	480 - 540 °F
Front Temperature	500 - 560 °F
Nozzle Temperature	500 - 560 °F
Processing (Melt) Temperature	520 - 560 °F
Mold Temperature	160 - 210 °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.