



**CP55-N0004**

**PPE+PS+PA**

General Purpose, Paintable, Medium Flow

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Physical	Method	Typical Value	Units
Melt Flow (280°C / 2.16kg)	ASTM D1238	5.0	g/10 min
Melt Flow (280°C / 5.0kg)	ASTM D1238	18.5	g/10 min
Specific Gravity	ASTM D792	1.08	
Mold Shrink, Flow: 0.125 in	ASTM D955	0.012	in/in

**Impact**

Notched Izod Impact (.125 in) 73°F	ASTM D256	3.5	ft-lbs/in
Gardner Impact (.125 in) 73°F	ASTM D5420	220	in-lbs

**Mechanical**

Tensile Strength @ Yield	ASTM D638	8,200	psi
Tensile Elongation @ Break	ASTM D638	40.0	%
Flexural Strength	ASTM D790	12,500	psi
Flexural Modulus	ASTM D790	330,000	psi

**Thermal**

Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	330	°F
.250 in, 264 psi	ASTM D648	270	°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	225°F
Drying Time	3.0 - 5.0 Hours
Suggested Maximum Moisture Content	0.07%
Rear Temperature	480 - 560 °F
Middle Temperature	500 - 560 °F
Front Temperature	510 - 560 °F
Nozzle Temperature	520 - 560 °F
Processing (Melt) Temperature	520 - 560 °F
Mold Temperature	150 - 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.