



CP55-N0006

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 | 2.5 | g/10 min |
| Melt Flow (280°C / 5.0kg) | ASTM D1238 | 12.0 | g/10 min |
| Specific Gravity | ASTM D792 | 1.08 | |
| Mold Shrink, Flow: 0.125 in | ASTM D955 | 0.012 | in/in |
| Rockwell Hardness (R-scale) | ASTM D785 | 115 | R |

Impact

| | | | |
|--|------------|-----|-----------|
| Notched Izod Impact (.125 in) 73°F (23°C) | ASTM D256 | 4.5 | ft-lbf/in |
| Notched Izod Impact (.125 in) -22°F (-30°C) | ASTM D256 | 2.0 | ft-lbf/in |
| Notched Izod Impact (.125 in) -40°F (-40°C) | ASTM D256 | 1.0 | ft-lbf/in |
| Gardner Impact (.125 in) 73°F (23°C) | ASTM D5420 | 240 | in-lbs |

Mechanical

| | | | |
|----------------------------|-----------|---------|-----|
| Tensile Strength @ Yield | ASTM D638 | 7,900 | 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 | 329 | °F |
| .250 in, 264 psi | ASTM D648 | 255 | °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 |
| Mold Temperature | 140 - 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.