



**CP55-N0018**

**PPE+PS+PA**

Increased Heat Stability, Paintable, Medium Flow

5401 N Hwy 41 / Suite 1000 Evansville, IN 47711 • Phone: 812.426.1350 • FAX: 888.855.3671 • www.cpptech.com

Physical	Method	Typical Value	Units
Melt Flow (280°C / 2.16kg)	ASTM D1238	3.5	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	3.0	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	280	in-lbs

**Mechanical**

Tensile Strength @ Yield	ASTM D638	7,700	psi
Tensile Elongation @ Break	ASTM D638	20.0	%
Flexural Strength	ASTM D790	11,000	psi
Flexural Modulus	ASTM D790	275,000	psi

**Thermal**

Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	329	°F
.250 in, 264 psi	ASTM D648	250	°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.