

Physical	Method	Typical Value	Units
Specific Gravity	ASTM D792	1.08	-
Melt Flow (280°C / 2.16kg)	ASTM D1238	3.5	g/10 min
Melt Flow (280°C / 5.0kg)	ASTM D1238	9.0	g/10 min
Mold Shrinkage, (0.125 in, w/flow)	ASTM D955	0.012	in/in
Mold Shrinkage, (0.125 in, x/flow)	ASTM D955	0.011	in/in
Rockwell Hardness (R-scale)	ASTM D785	115	R
Impact			
Izod Impact Strength (.125 in, notched, 23°C)	ASTM D256	3.8	ft-lbf/in
Izod Impact Strength (.125 in, notched, -30°C)	ASTM D256	2.2	ft-lbf/in
Izod Impact Strength (.125 in, notched, -40°C)	ASTM D256	1.0	ft-lbf/in
Gardner Impact Strength (.125 in, 23°C)	ASTM D5420	320	in-lbs
Mechanical			
Tensile Strength @ Yield	ASTM D638	7,900	psi
Tensile Elongation @ Break	ASTM D638	40.0	%
Flexural Strength	ASTM D790	12,000	psi
Flexural Modulus	ASTM D790	295,000	psi
Thermal			
Deflection Temperature Under Load (0.250 in, 66 psi)	ASTM D648	329	°F
Deflection Temperature Under Load (0.250 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	95°C	200°F
Drying Time, (do not over-dry)	2.0 - 6.0 hrs	2.0 - 6.0 hrs
Minimum Moisture Content	0.02%	0.02%
Maximum Moisture Content	0.08%	0.08%
Rear Temperature	260 - 270°C	500 - 520°F
Middle Temperature	265 - 280°C	510 - 535°F
Front Temperature	275 - 290°C	530 - 560°F
Nozzle Temperature	280 - 295°C	535 - 565°F
Processing (Melt) Temperature	275 - 300°C	530 - 570°F
Mold Temperature	50 - 95°C	120 - 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.