



# CP51-N0015

## Polycarbonate / ABS Alloy

15% Mineral Filled, High Heat Resistance

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Physical	Method	Typical Value	Units
Melt Mass-Flow Rate @ 260°C / 5.0kg	ISO 1133	16	g/10 min
Density	ISO 1183	1.27	g/cm <sup>3</sup>
Mold Shrink, w/ Flow (3.2mm)	CPPT Method	0.4	%
Mold Shrink, x/ Flow (3.2mm)	CPPT Method	0.4	%
<b>Impact</b>			
Notched Charpy Impact 23°C	ISO 179/1eA	10.0	kJ/m <sup>2</sup>
<b>Mechanical</b>			
Tensile Modulus (1.0mm/min)	ISO 527	4,100	MPa
Tensile Yield Strength (50mm/min)	ISO 527	63.0	MPa
Tensile Elongation (break)	ISO 527	17.0	%
Flexural Modulus (2.0mm/min)	ISO 178	4,300	MPa
Flexural Strength	ISO 178	105	MPa
<b>Thermal</b>			
Heat Deflection Temperature 1.82 MPa, Unannealed	ISO 75-2/A	120	°C
CLTE			
Flow: -30 to 100°C	ISO 11359-2	4.5E-5	cm/cm/°C
Transverse: -30 to 100°C	ISO 11359-2	6.0E-5	cm/cm/°C

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	100°C
Drying Time	3.0 - 4.0 Hours	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.04%	0.04%
Rear Temperature	480 - 520 °F	245 - 270°C
Middle Temperature	500 - 540 °F	260 - 280°C
Front Temperature	500 - 540 °F	260 - 280°C
Nozzle Temperature	520 - 560 °F	270 - 295°C
Processing (Melt) Temperature	520 - 560 °F	270 - 295°C
Mold Temperature	140 - 195 °F	60 - 90°C

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.