CP51-N0015

Polycarbonate / ABS Alloy

15% Mineral Filled, High Heat Resistance

CrossPoint Polymer Technologies

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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/cm³
Mold Shrink, w/ Flow (3.2mm)	CPPT Method	0.4	%
Mold Shrink, x/ Flow (3.2mm)	CPPT Method	0.4	%
Impact			
Notched Charpy Impact			
23°C	ISO 179/1eA	10.0	kJ/m²
Mechanical			
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
Thermal			
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

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