CP51-N0035

Polycarbonate / ABS Alloy

High Flow, High Impact, Good Low Temp Impact

2301 St Joseph Industrial Park Dr Evansville, IN 47720 • Phone: 812.426.1350 • FAX: 888.855.3671 • www.cpptech.com

Physical	Method	Typical Value	Units
Melt Flow @ 260°C / 5.0kg	ISO 1133	23	g / 10 min
Melt Volume-Flow Rate @ 260°C / 5.0kg	ISO 1133	20	cm^3 / 10 min
Density	ISO 1183	1.13	g / cm^3
Mold Shrinkage (Flow Direction, 3.2mm)	ISO 2577	0.6	%
Mold Shrinkage (Cross Flow Direction, 3.2mm)	ISO 2577	0.6	%
Impact			
Charpy Impact Strength			
+23°C (Notched, Type A, Edgewise)	ISO 179	48	kJ / m^2
-30°C (Notched, Type A, Edgewise)	ISO 179	29	kJ / m^2
Mechanical			
Tensile Strength @ Yield (50 mm/min)	ISO 527	54.2	MPa
Tensile Elongation @ Break (50 mm/min)	ISO 527	53	%
Tensile Modulus (1.0 mm/min)	ISO 527	2,650	MPa
Flexural Strength (2.0 mm/min x-head)	ISO 178	86.4	MPa
Flexural Modulus (2.0 mm/min x-head)	ISO 178	2,450	MPa
Thermal			
Heat Deflection Temperature			
.45 MPa, method A, flatwise	ISO 75	125	°C
1.82 MPa, method A, flatwise	ISO 75	108	°C
Vicat Softening Temperature (B50 method)	ISO 306	127	°C

Recommended Processing Parameters

Drying Temperature	80°C
Drying Time	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.05%
Rear Temperature	238 - 260 °C
Middle Temperature	245 - 265 °C
Front Temperature	248 - 270 °C
Nozzle Temperature	255 - 275 °C
Processing (Melt) Temperature	260 - 280 °C
Mold Temperature	70 - 95 °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.