



**CP51-N0035-(HF)**  
**Polycarbonate / ABS Alloy**

Excellent Flow, High Impact

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Physical	Method	Typical Value	Units
Melt Flow @ 260°C / 5.0kg	ISO 1133	26	g / 10 min
Melt Volume-Flow Rate @ 260°C / 5.0kg	ISO 1133	22	cm <sup>3</sup> / 10 min
Density	ISO 1183	1.13	g / cm <sup>3</sup>
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	46	kJ / m <sup>2</sup>
-30°C (Notched, Type A, Edgewise)	ISO 179	28	kJ / m <sup>2</sup>

**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

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	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.