CP51-N0039

Polycarbonate / ABS Alloy

High Flow, High Impact, Good Low Temp Impact

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Physical	Method	Typical Value	Units
Melt Mass-Flow Rate (MFR) @ 260°C / 5.0kg	ISO 1133	20	g/10 min
Melt Volume-Flow Rate (MVR) @ 260°C / 5.0kg	ISO 1133	18	cm^3/10min
Density	ISO 1183	1.14	g/cm^3
Mold Shrinkage (Flow Direction, 3.2mm)	ISO 2577	0.7	%
Mold Shrinkage (Cross Flow Direction, 3.2mm)	ISO 2577	0.7	%
Impact			
Charpy Impact Strength			
+23°C (Notched, Type A, Edgewise)	ISO 179	51	kJ / m^2
-30°C (Notched, Type A, Edgewise)	ISO 179	42	kJ / m^2
Mechanical			
Tensile Strength @ Yield (50 mm/min)	ISO 527	53.5	MPa
Tensile Elongation @ Break (50 mm/min)	ISO 527	100	%
Tensile Modulus (1.0 mm/min)	ISO 527	2,320	MPa
Flexural Strength (2.0 mm/min x-head)	ISO 178	83.5	MPa
Flexural Modulus (2.0 mm/min x-head)	ISO 178	2,250	MPa
Thermal			
Heat Deflection Temperature			
.45 MPa, method A, flatwise	ISO 75	128	°C
1.82 MPa, method A, flatwise	ISO 75	109	°C
Vicat Softening Temperature	ISO 306/B50	130	°C

Recommended Processing Parameters

Drying Temperature	225°F
Drying Time	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.05%
Rear Temperature	470 - 530 °F
Middle Temperature	480 - 540 °F
Front Temperature	480 - 540 °F
Nozzle Temperature	490 - 540 °F
Processing (Melt) Temperature	490 - 540 °F
Mold Temperature	160 - 200 °F