



**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 <sup>3</sup> /10min
Density	ISO 1183	1.14	g/cm <sup>3</sup>
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 <sup>2</sup>
-30°C (Notched, Type A, Edgewise)	ISO 179	42	kJ / m <sup>2</sup>

**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

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
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

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.