



**CP02-N0005**

**ASA**

High Impact

\*\*Available in Natural & Colors

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Physical	Method	Typical Value	Units
Melt Flow (220°C / 10.0 kg)	ISO 1133	10.0	g/10 min
Melt Flow (230°C / 3.8 kg)	ISO 1133	4.0	g/10 min
Density	ISO 1183	1.07	g/cm <sup>3</sup>
Linear Mold Shrinkage, Flow	Internal Method	0.006	cm/cm

**Impact**

Charpy Impact	23°C	ISO 179	18.0	kJ/m <sup>2</sup>
	-30°C	ISO 179	3.5	kJ/m <sup>2</sup>

**Mechanical**

Tensile Modulus (1 mm/min)	ISO 527	2,375	MPa
Tensile Strength @ Yield (50 mm/min)	ISO 527	52.0	MPa
Tensile Elongation @ Break (50 mm/min)	ISO 527	10.0	%
Flexural Strength	ISO 178	76	MPa
Flexural Modulus	ISO 178	2,300	MPa

**Thermal**

Deflection Temperature Under Load	.125 in, 66 psi	ISO 75	94	°C
	.125 in, 264 psi	ISO 75	82	°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	175°F
Drying Time	3-4 hrs.
Suggested Maximum Moisture Content	0.1%
Rear Temperature	440 - 500 °F
Middle Temperature	450 - 510 °F
Front Temperature	460 - 520 °F
Nozzle Temperature	460 - 520 °F
Processing (Melt) Temperature	460 - 520 °F
Mold Temperature	100 - 160 °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.