



**CP10-N0004**  
**Polyether Imide**

20% Glass Fiber Reinforcement

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Physical	Method	Typical Value	Units
Melt Flow @ 337°C / 6.6 kg	ASTM D1238	7.0	g/10 min
Specific Gravity	ASTM D792	1.42	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.005	in/in

**Impact**

Notched Izod Impact (.125 in) 73°F	ASTM D256	1.0	ft-lbs/in
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**Mechanical**

Tensile Strength @ Yield	ASTM D638	18,000	psi
Tensile Elongation @ Break	ASTM D638	4.0	%
Flexural Strength @ Break	ASTM D790	32,000	psi
Flexural Modulus	ASTM D790	950,000	psi

**Thermal**

Deflection Temperature Under Load .250 in, 66 psi	ASTM D648	408	°F
.250 in, 264 psi	ASTM D648	408	°F

**Flammability**

Flame Rating (.0625")	V-0
Flame Rating (.125")	5VA

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	300°F
Drying Time	4.0 - 6.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	620 - 740 °F
Middle Temperature	630 - 740 °F
Front Temperature	640 - 740 °F
Nozzle Temperature	640 - 740 °F
Processing (Melt) Temperature	650 - 740 °F
Mold Temperature	280 - 330 °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.