



CP53-N0004

Polycarbonate / PBT Alloy

Good Flow, Good Low Temperature Impact

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Physical	Method	Typical Value	Units
Melt Flow @ 250°C / 5.0kg	ASTM D1238	40	g/10 min
Specific Gravity	ASTM D792	1.21	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.009	in/in

Impact

Notched Izod Impact (.125 in)			
73°F	ASTM D256	13.0	ft-lbs/in
-22°F	ASTM D256	8.0	ft-lbs/in
-40°F	ASTM D256	5.0	ft-lbs/in

Mechanical

Tensile Strength @ Yield	ASTM D638	7,200	psi
Tensile Elongation @ Break	ASTM D638	>100	%
Flexural Strength	ASTM D790	11,500	psi
Flexural Modulus	ASTM D790	310,000	psi

Thermal

Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	220	°F
.250 in, 264 psi	ASTM D648	200	°F

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 - 5.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	460 - 500 °F
Middle Temperature	470 - 510 °F
Front Temperature	480 - 520 °F
Nozzle Temperature	480 - 520 °F
Processing (Melt) Temperature	490 - 520 °F
Mold Temperature	150 - 190 °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.