



CP01-N0029

ABS

High Heat Resistance, High Impact, Low Gloss

5401 N Hwy 41 / Suite 1000 Evansville, IN 47711 • Phone: 812.426.1350 • FAX: 888.855.3671 • www.cpptech.com

Physical	Method	Typical Value	Units
Melt Flow (230°C / 3.8kg)	ASTM D1238	3.5	g/10 min
Specific Gravity	ASTM D792	1.06	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.006	in/in

Impact

Notched Izod Impact (.125 in) 73°F	ASTM D256	6.5	ft-lbs/in
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Mechanical

Tensile Strength @ Yield	ASTM D638	6,800	psi
Tensile Elongation @ Break	ASTM D638	25.0	%
Flexural Strength	ASTM D790	11,500	psi
Flexural Modulus	ASTM D790	355,000	psi

Thermal

Deflection Temperature Under Load			
.125 in, 66 psi	ASTM D648	215	°F
.125 in, 264 psi	ASTM D648	190	°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	175°F
Drying Time	3-4 hrs.
Suggested Maximum Moisture Content	0.07%
Rear Temperature	440 - 470 °F
Middle Temperature	450 - 480 °F
Front Temperature	460 - 480 °F
Nozzle Temperature	460 - 480 °F
Processing (Melt) Temperature	450 - 480 °F
Mold Temperature	100 - 140 °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.