

Physical	Method	Typical Value	Units
Specific Gravity	ISO 1183	1.14	
Melt Flow Rate (260°C / 5.0kg)	ISO 1133	30.0	g/10 min
Melt Volume Rate (260°C / 5.0kg)	ISO 1133	28.0	g/cm ³
Mold Shrinkage (Flow Direction, 3.2mm)	ASTM D955	0.60	%
Mold Shrinkage (Cross Flow Direction, 3.2mm)	ASTM D955	0.60	%
Impact			
Charpy Impact Strength (+23°C, Notched, Type A, Edgewise)	ISO 179	44.0	kJ/m ²
Charpy Impact Strength (-30°C, Notched, Type A, Edgewise)	ISO 179	5.5	kJ/m ²
Mechanical			
Tensile Strength at Yield (+23°C, 50 mm/min, specimen A)	ISO 527	60.0	MPa
Tensile Elongation at Yield (+23°C, 50 mm/min, specimen A)	ISO 527	7.5	%
Tensile Strength at Break (+23°C, 50 mm/min, specimen A)	ISO 527	50.0	MPa
Tensile Elongation at Break (+23°C, 50 mm/min, specimen A)	ISO 527	70.0	%
Tensile Modulus (+23°C, 1.0 mm/min, specimen A)	ISO 527	2620	MPa
Flexural Strength (+23°C, 2.0 mm/min x-head)	ISO 178	93.0	MPa
Flexural Modulus (+23°C, 2.0 mm/min x-head)	ISO 178	2590	MPa
Thermal			
Heat Deflection Temperature (0.45 MPa, method A, flatwise)	ISO 75	128.0	°C
Heat Deflection Temperature (1.82 MPa, method A, flatwise)	ISO 75	108.0	°C
Vicat Softening Temperature (B50 method)	ISO 306	123.0	°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	176°F	80°C
Drying Time	3.0 - 4.0 Hours	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.05%	0.05%
Rear Temperature	470 - 530°F	238 - 260°C
Middle Temperature	480 - 540°F	245 - 265°C
Front Temperature	480 - 540°F	248 - 270°C
Nozzle Temperature	490 - 540°F	255 - 275°C
Processing (Melt) Temperature	490 - 540°F	260 - 280°C
Mold Temperature	160 - 200°F	70 - 95°C

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.