



QR-1000-GF30 Polycarbonate

2301 St. Joseph Industrial Park Drive Evansville, IN 47720 Phone 812/429-0901 Fax 812/429-0905 www.customcompounding.com

Appearance	<u>General Description</u> Natural Color Custom Colors Available
Features	Good Toughness Injection Grade With UV(V) or Release(R)
Filler/Additive	30% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.43	
Melt Flow Rate, 300°C/ 1.2 kg	ASTM D1238	10-20	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.002	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	1,000,000	psi
Flex Strength @ Yield	ASTM D790	22,800	psi
Unnotched Izod Impact, 73°F	ASTM D256	20	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	19,000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	295	°F
Deflection Temp @ 66 psi	ASTM D648	305	°F

These test results are based on reliable procedures. Due to variable conditions and methods of processing, no guarantees or warranties are expressed or implied including the implied warranty of merchantability and fitness for particular use. The above information is not to be construed as a license or a recommendation to infringe on any patents.

-Injection Molding

Drying Conditions

Min 3 hours – Max 6 hours	250	°F
Cylinder		
Rear	540-580	°F
Middle	560-600	°F
Front	580-640	°F
Nozzle	580-640	°F
Mold		
Maximum	240	°F
Minimum	180	°F
Processing Temp	600-650	°F

ISO9001:2000 Registered



The guidelines listed above are based on specimens at various thicknesses typical in manufacturing. These values are not intended to be used for specification purposes. These are recommended starting parameters. The equipment part design and tooling will influence final process parameters. The percent recycle is dependent on part design, wall thickness, process, and final performance requests.