



QR-1000-GFR10 Polycarbonate

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<p>Appearance</p> <p>Features</p> <p>Flame Packages available as:</p> <p>Filler/Additive</p>	<p>Min. Thickness: 0.0625 in.</p>	<p><u>General Description</u> Natural Color Custom Colors Available Good Toughness Injection Grade With UV(V) or Release(R) 94V-2, 94V-0, 94-5VA (PO Specified) 10% Glass</p>
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<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.27	
Melt Flow Rate, 300°C/ 1.2 kg	ASTM D1238	10-20	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.003	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	450,000	psi
Flex Strength @ Yield	ASTM D790	14,800	psi
Notched Izod Impact, 73°F	ASTM D256	1.5	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	9,400	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	285	°F
Deflection Temp @ 66 psi	ASTM D648	290	°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	540-590	°F
Middle	560-600	°F
Front	580-620	°F
Nozzle	580-610	°F
Mold		
Maximum	240	°F
Minimum	180	°F
Processing Temp	580-620	°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.