



QR-1000-GFR30 Polycarbonate

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Appearance		<u>General Description</u> Natural Color Custom Colors Available
Features		Good Toughness Injection Grade With UV(V) or Release(R)
Flame Packages available as:	Min. Thickness: 0.0625 in.	94V-2, 94V-0, 94-5VA (PO Specified)
Filler/Additive		30% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.44	
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	990,000	psi
Flex Strength @ Yield	ASTM D790	22,500	psi
Unnotched Izod Impact, 73°F	ASTM D256	15	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	18,800	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	295	°F
Deflection Temp @ 66 psi	ASTM D648	307	°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.