



# QR-1000F-GFR10 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	Foamable High Heat Resistance With UV(V) or Release(R)
Flame Packages available as:	Min. Thickness: 94V-0 0.250 in.
Filler/Additive	10% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.12	
Melt Flow Rate, 300°C/ 1.2 kg	ASTM D1238	10-20	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.005	in/in
<i>-Mechanical (10% Foamed)</i>			
Flex Modulus	ASTM D790	500,000	psi
Flex Strength @ Yield	ASTM D790	12,800	psi
Unnotched Izod Impact, 73°F	ASTM D256	14	ft.lbs/in
- Low Temp ( °F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7,500	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	270	°F
Deflection Temp @ 66 psi	ASTM D648	280	°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

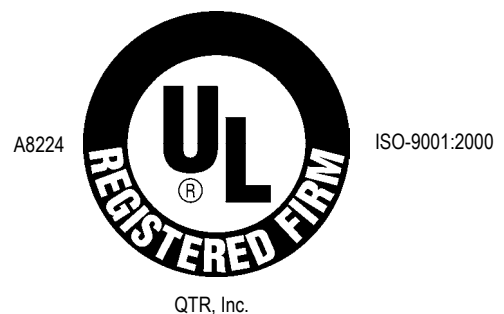
#### Mold

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.