



QR-1000F-GFR20 Polycarbonate

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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: 0.0625 in.	94V-0, 94V-2, 94-5VA (PO Specified)
Filler/Additive		20% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.19	
Melt Flow Rate, 300°C/ 1.2 kg	ASTM D1238	10-20	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.004	in/in
<i>-Mechanical (10% Foamed)</i>			
Flex Modulus	ASTM D790	740,000	psi
Flex Strength @ Yield	ASTM D790	15,200	psi
Unnotched Izod Impact, 73°F	ASTM D256	8	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,500	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	275	°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	550-600	°F
Middle	570-620	°F
Front	590-630	°F
Nozzle	590-620	°F
Mold		
Maximum	250	°F
Minimum	200	°F
Processing Temp	590-630	°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.