QR-1008-FR
Polycarbonate

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

		General Description
Appearance		Natural Color Custom Colors Available
Features		High Impact Injection/Extrusion Grade With UV(V) or Release(R)
Flame Package available as:	Min. Thickness: 0.0625 in.	94V-2, 94V-0, 94-5VA (PO Specified)
Filler/Additive		No

Property	Method	Value	Unit
-Physical			
Specific Gravity	ASTM D792	1.21	
Melt Flow Rate, 300°C/ 1.2 kg	ASTM D1238	8	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
-Mechanical			
Flex Modulus	ASTM D790	325,000	psi
Flex Strength @ Yield	ASTM D790	13,000	psi
Notched Izod Impact, 73°F	ASTM D256	12	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	9,000	psi
-Thermal			
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	540-580	°F
Middle	560-600	°F
Front	580-620	°F
Nozzle	570-610	°F
Mold		
Maximum	240	°F
Minimum	180	°F
Processing Temp	580-620	°F

ISO9001:2000 Registered

A8224 ISO-9001:2000

QTR, Inc.

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.