



# QR-1015FR Polycarbonate

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

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.21	
Melt Flow Rate, 300°C/ 1.2 kg	ASTM D1238	15	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	324,000	psi
Flex Strength @ Yield	ASTM D790	13,000	psi
Notched Izod Impact, 73°F	ASTM D256	12	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	9,000	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      230      °F

#### Cylinder

Rear                                      500-540      °F  
 Middle                                    520-560      °F  
 Front                                      540-580      °F  
 Nozzle                                    530-570      °F

#### Mold

Maximum                                180            °F  
 Minimum                                160            °F

Processing Temp                      540-570      °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.