



QR-1200GF10

PC/ABS Alloy

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Appearance	<u>General Description</u> Natural Color Custom Colors Available
Features	General Purpose High Heat Resistance
Filler/Additive	10% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.22	
Glass Percentage	ASTM D5630	10	%
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	471,000	psi
Flex Strength @ Yield	ASTM D790	15,700	psi
Notched Izod Impact, 73°F	ASTM D256	1.43	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	10,150	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	280	°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.

****All values are subject to change. Before production begins a Production Planning Worksheet will be faxed or emailed to the customer stating the final values per the customers request.****

-Injection Molding

Drying Conditions

Min 2 hours – Max 4 hours 250 °F

Cylinder

Rear 550-600 °F

Middle 550-600 °F

Front 550-600 °F

Nozzle 550-600 °F

Mold

Maximum 220 °F

Minimum 170 °F

Processing Temp

560-600 °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.