



QR-1200-GF20

PC/ABS Alloy

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	<u>General Purpose</u> High Heat Resistance
Filler/Additive	20% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.26-1.30	
Glass Percentage	ASTM D5630	18-22	%
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.001-0.005	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	870,000 minimum	psi
Flex Strength @ Yield	ASTM D790	18,900 minimum	psi
Notched Izod Impact, 73°F	ASTM D256	1.4 minimum	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	10,800 minimum	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	240 minimum	°F
Deflection Temp @ 66 psi	ASTM D648	266 minimum	°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 190 °F

Cylinder

Rear 480-500 °F

Middle 490-510 °F

Front 500-520 °F

Nozzle 510-530 °F

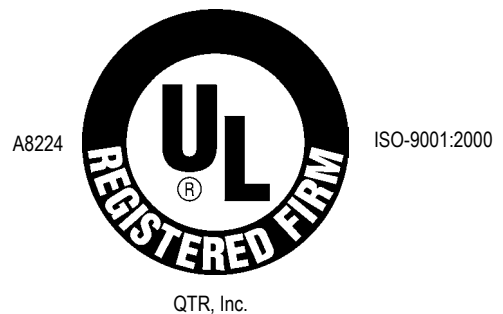
Mold

Maximum 150 °F

Minimum 100 °F

Processing Temp 480-530 °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.