



QR-1220 PC/ABS Alloy

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	High Impact Injection Grade High Heat Resistance With UV(V) or Release(R)
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.14	
Melt Flow Rate, 260°C/ 5.0 kg	ASTM D1238	20	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	335,000	psi
Flex Strength @ Yield	ASTM D790	12,500	psi
Notched Izod Impact, 73°F	ASTM D256	10	ft.lbs/in
- Low Temp (-22°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	220	°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 4 hours – Max 8 hours 225 °F

Cylinder

Rear 475-540 °F

Middle 480-560 °F

Front 500-570 °F

Nozzle 520-570 °F

Mold

Maximum 190 °F

Minimum 140 °F

Processing Temp 480-560 °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.