



QR-1220IM

PC/ABS Alloy

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

Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	High Impact (Ambient and Low Temp) Injection Grade High Heat Resistance
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.13	
Melt Flow Rate, 260°C/ 5.0 kg	ASTM D1238	18 (+/- 15%)	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	327,000	psi
Flex Strength @ Yield	ASTM D790	12,300	psi
Notched Izod Impact, 73°F	ASTM D256	10	ft.lbs/in
- Low Temp (-22°F)	ASTM D256	8	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7,540	psi
Tensile Elongation	ASTM D638	150	%
<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 3 hours – Max 8 hours 220 °F

ISO9001:2000 Registered

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 520-560 °F



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.