



# QR-1220LG(V) 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	Injection Molding Grade Good Impact Resistance Low Gloss Good UV Resistance
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	320,000	psi
Flex Strength @ Yield	ASTM D790	12,200	psi
Notched Izod Impact, 73°F	ASTM D256	10	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7,700	psi
Tensile Elongation @ Break	ASTM D638	80	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	225	°F
Deflection Temp @ 66 psi	ASTM D648	255	°F
<i>-Flammable</i>			
Flame Rating – UL, HB	UL 94	0.059	in

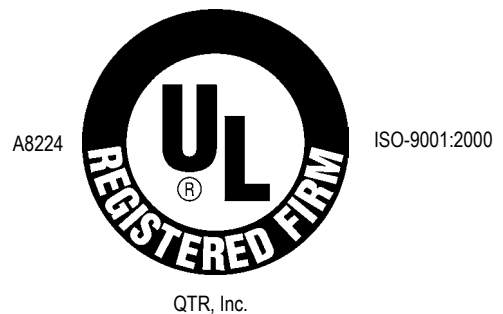
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### *-Injection Molding*

#### Drying Conditions

Min 3 hours – Max 4 hours	220	°F
<b>Cylinder</b>		
Rear	480-540	°F
Middle	490-550	°F
Front	500-565	°F
Nozzle	520-565	°F
<b>Mold</b>		
Maximum	180	°F
Minimum	140	°F
Processing Temp	520-570	°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.