



# QR-1220LG PC/ABS Alloy

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Good Impact Resistance Low Gloss
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	330,000	psi
Flex Strength @ Yield	ASTM D790	12,200	psi
Notched Izod Impact, 73°F	ASTM D256	9	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7,800	psi
Tensile Elongation @ Break	ASTM D638	120	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	220	°F
Deflection Temp @ 66 psi	ASTM D648	240	°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 4 hours      220      °F

#### Cylinder

Rear      480-540      °F

Middle      490-550      °F

Front      500-565      °F

Nozzle      520-565      °F

#### Mold

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.