



# QR-1235FR

## PC/ABS Alloy

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<p>Appearance</p> <p>Features</p> <p>Flame Package available as:</p> <p>Filler/Additive</p>	<p>Min. Thickness: 0.0625 in.</p>	<p><u>General Description</u>            Natural Color            Custom Colors Available            Good Processability            Injection Grade            High Heat Resistance            With UV(V) or Release(R)            94V-2, 94V-0, 94-5VA (PO Specified)            No</p>
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<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.18	
Melt Flow Rate, 260°C/ 5.0 kg	ASTM D1238	35	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.005	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	385,000	psi
Flex Strength @ Yield	ASTM D790	13,800	psi
Notched Izod Impact, 73°F	ASTM D256	8	ft.lbs/in
- Low Temp ( °F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	9,000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	200	°F
Deflection Temp @ 66 psi	ASTM D648	215	°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 6 hours	200	°F
<b>Cylinder</b>		
Rear	490-510	°F
Middle	430-520	°F
Front	460-540	°F
Nozzle	530-570	°F
<b>Mold</b>		
Maximum	180	°F
Minimum	140	°F
Processing Temp	480-540	°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.