



QR-1305IM(LT) PC/Polyester

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	Low Melt Flow, Non-Lubricated Good Impact (Room Temperature and Low Temperature) Injection Grade Chemically Resistant Thermal Stability
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.21	
Melt Flow Rate, 250°C/ 3.8 kg	ASTM D1238	5.0	g/10min
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	300,000	psi
Flex Strength @ Yield	ASTM D790	12,000	psi
Notched Izod Impact, 73°F	ASTM D256	13	ft.lbs/in
- Low Temp (-22°F)	ASTM D256	9	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,000	psi
Tensile Elongation @ Break	ASTM D638	120	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	235	°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 6 hours 230 °F

Cylinder

Rear 480-520 °F

Middle 490-530 °F

Front 500-540 °F

Nozzle 490-530 °F

Mold

Maximum 200 °F

Minimum 150 °F

Processing Temp 500-540 °F

Maximum Moisture Content 0.02 %

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.