



# QR-1310 PC/Polyester

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Good Impact Injection Grade Chemically Resistant With UV(V) or Release(R)
Automotive Approval(s)	GM: GMP.PC+PBTP.004R
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.20	
Melt Flow Rate, 260°C/ 5.0 kg	ASTM D1238	30	g/10min
230°C/ 3.8 kg	ASTM D1238	12	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.009	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	345,000	psi
Flex Strength @ Yield	ASTM D790	12,500	psi
Notched Izod Impact, 73°F	ASTM D256	12	ft.lbs/in
- Low Temp (-40°F)	ASTM D256	5	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,600	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	210	°F
Deflection Temp @ 66 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 2 hours – Max 4 hours      220      °F

#### Cylinder

Rear      475-520      °F

Middle      490-525      °F

Front      500-540      °F

Nozzle      500-525      °F

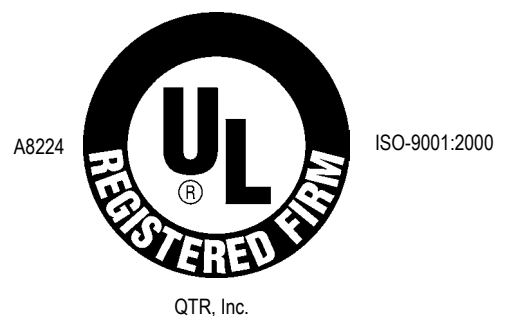
#### Mold

Maximum      200      °F

Minimum      140      °F

Processing Temp      500-540      °F

ISO9001:2000 Registered



QTR, Inc.

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.