



QR-1310IM-GF10

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	Good Ductility Impact Modified With UV(V) or Release(R)
Flame Packages available as:	Min. Thickness: 94V-2, 94V-0, 94-5VA (PO Specified) 0.0625 in.
Filler/Additive	10% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.26	
Melt Flow Rate	ASTM D1238	N/A	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.008	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	390,000	psi
Flex Strength @ Break	ASTM D790	13,700	psi
Notched Izod Impact, 73°C	ASTM D256	3.0	ft.lbs/in
- Low Temp (-20°F)	ASTM D256	2.0	ft.lbs/in
Tensile Strength @ Break	ASTM D638	8,800	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	240	°F
Deflection Temp @ 66 psi	ASTM D648	340	°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 8 hours 220 °F

Cylinder

Rear 470-510 °F

Middle 480-530 °F

Front 490-540 °F

Nozzle 475-530 °F

Mold

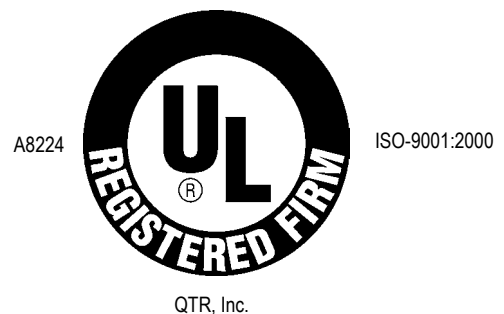
Maximum 150 °F

Minimum 200 °F

Processing Temp 510-530 °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.