



# QR-1310IM-GF30

## PC/Polyester

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|                              |                               |  |
|------------------------------|-------------------------------|--|
| Appearance                   |                               | <u>General Description</u><br>Natural/Black Color<br>Custom Colors Available |
| Features                     |                               | Good Ductility<br>Impact Modified<br>With UV(V) or Release(R)                |
| Flame Packages available as: | Min. Thickness:<br>0.0625 in. | 94V-2, 94V-0, 94-5VA (PO Specified)  |
| Filler/Additive              |                               | 30% Glass  |

| <u>Property</u>                  | <u>Method</u> | <u>Value</u> | <u>Unit</u> |
|----------------------------------|---------------|--------------|-------------|
| <i>-Physical</i>                 |               |              |             |
| Specific Gravity                 | ASTM D792     | 1.45         |             |
| Melt Flow Rate                   | ASTM D1238    | N/A          | g/10min     |
| Mold Shrink, Linear Flow (0.125) | ASTM D955     | 0.003        | in/in       |
| <i>-Mechanical</i>               |               |              |             |
| Flex Modulus                     | ASTM D790     | 770,000      | psi         |
| Flex Strength @ Break            | ASTM D790     | 18,900       | psi         |
| Notched Izod Impact, 73°F        | ASTM D256     | 2.5          | ft.lbs/in   |
| - Low Temp (-20°F)               | ASTM D256     | 2.0          | ft.lbs/in   |
| Tensile Strength @ Break         | ASTM D638     | 13,000       | psi         |
| <i>-Thermal</i>                  |               |              |             |
| Deflection Temp @ 264 psi        | ASTM D648     | 300          | °F          |
| Deflection Temp @ 66 psi         | ASTM D648     | 390          | °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 |
| <b>Cylinder</b>           |         |    |
| Rear                      | 470-510 | °F |
| Middle                    | 480-530 | °F |
| Front                     | 490-540 | °F |
| Nozzle                    | 475-530 | °F |
| <b>Mold</b>               |         |    |
| 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.