



QR-1310IM-GF30

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: 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
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.