



QR-1310IM

PC/Polyester

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Low Temperature Impact Chemically Resistant With UV(V) or Release(R)
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	10	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.009	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	300,000	psi
Notched Izod Impact, 73°F	ASTM D256	14	ft.lbs/in
- Low Temp (-40°F)	ASTM D256	8	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7,500	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	210	°F
Deflection Temp @ 66 psi	ASTM D648	230	°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 470-510 °F

Middle 480-520 °F

Front 490-530 °F

Nozzle 490-520 °F

Mold

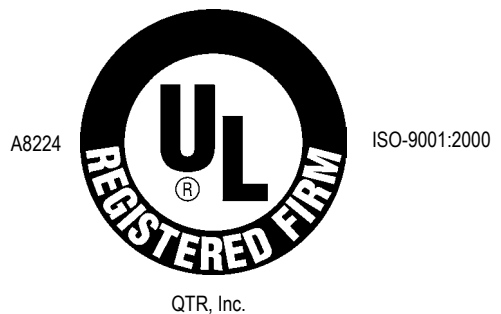
Maximum 150 °F

Minimum 190 °F

Processing Temp 500-530 °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.