



QR-1335IM(V) PC/PET

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	High Impact (at room temperature and low temperature) Chemically Resistant UV (V) Stabilized
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, 260°C/ 5.0 kg	ASTM D1238	35	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.009	in/in
<i>-Mechanical</i>			
Flexural Modulus	ASTM D790	300,000	psi
Flexural Strength	ASTM D790	11,500	psi
Notched Izod Impact, 73°F	ASTM D256	12	ft-lb/in
Tensile Strength @ Yield	ASTM D638	8,500	psi
Tensile Elongation	ASTM D638	125	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	255	°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	480-520	°F
Middle	490-530	°F
Front	500-540	°F
Nozzle	490-530	°F
Mold		
Maximum	150	°F
Minimum	190	°F
Processing Temp	500-530	°F
Maximum Moisture Content	0.02	%

ISO 9001:2000 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.