



# QR-1805IMLM

## PC/Polyester

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Low Melt Flow, Non-Lubricated Good Impact Injection Grade Chemically Resistant

Filler/Additive No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.00	
Melt Flow Rate, 266°C/ 5.0 kg	ASTM D1238	8	g/10min
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	297,000	psi
Flex Strength @ Yield	ASTM D790	11,600	psi
Notched Izod Impact, 73°F	ASTM D256	15	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,150	psi
Tensile Elongation @ Break	ASTM D638	160	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	232	°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 190 °F

Minimum 150 °F

Processing Temp 500-530 °F

Maximum Moisture Content 0.02 %

ISO9001:2000 Registered



QTR, Inc.

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.