



QR-2008FR

ABS

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 Color Custom Colors Available
Features		Good Processability Injection Grade With UV(V) or Release(R)
Flame Packages available as:	Min. Thickness: 0.0.625 in.	94V-2, 94V-0, 94-5VA (PO Specified)
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, 230°C/ 3.8 kg	ASTM D1238	8	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	339,000	psi
Flex Strength @ Yield	ASTM D790	9,200	psi
Notched Izod Impact, 73°F	ASTM D256	3	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	5,700	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	165	°F
Deflection Temp @ 66 psi	ASTM D648	170	°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 3 hours – Max 6 hours 180 °F

Cylinder

Rear 330-360 °F

Middle 380-400 °F

Front 400-420 °F

Nozzle 380-440 °F

Mold

Maximum 160 °F

Minimum 120 °F

Processing Temp 380-450 °F

QS-9000 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.