



QR-2010 ABS

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Appearance	<u>General Description</u> Natural Color Custom Colors Available
Features	High Flow Good Heat Resistance High or Low Gloss (PO Specified)
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.05	
Melt Flow Rate, 230°C/ 3.8 kg	ASTM D1238	10	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	355,000	psi
Flex Strength @ Yield	ASTM D790	11,500	psi
Notched Izod Impact, 73°F	ASTM D256	5	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7,600	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	185	°F
Deflection Temp @ 66 psi	ASTM D648	205	°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 2 hours – Max 4 hours	200	°F
Cylinder		
Rear	380-450	°F
Middle	410-480	°F
Front	430-480	°F
Nozzle	450-520	°F
Mold		
Maximum	180	°F
Minimum	120	°F
Processing Temp	450-520	°F

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.