



QR-3000 PET

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Injection Molding Grade Semi-Crystalline Good Chemical Resistance
Filler/Additive	None

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.3	
<i>-Mechanical</i>			
Tensile Strength @ Yield	ASTM D638	7,000	psi
Flexural Modulus	ASTM D790	300,000	psi
Flexural Strength @ Break	ASTM D790	12,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.0	ft.lbs/in
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	140	°F
Deflection Temp @ 66 psi	ASTM D648	150	°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 8 hours 250 °F

Cylinder

Rear 460-490 °F

Middle 470-500 °F

Front 480-510 °F

Nozzle 470-500 °F

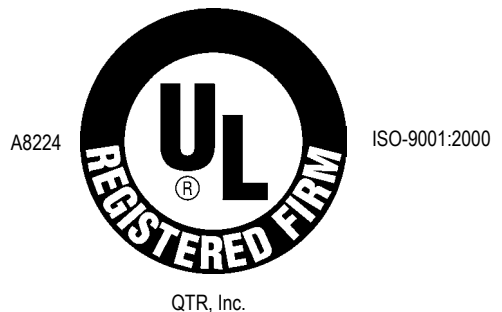
Mold

Maximum 190 °F

Minimum 150 °F

Processing Temp 480-510 °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.