



# QR-4100-GF10

## Glass filled PPE/PS

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<p>Appearance Features</p> <p>Filler/Additive</p>	<p><u>General Description</u> Available in Black and Custom Colors High Heat Resistance Good Stiffness 10% Glass</p>
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<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.14	
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	500,000	psi
Flex Strength @ Yield	ASTM D790	13,500	psi
Notched Izod Impact, 73°F	ASTM D256	1.4	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,500	psi
Tensile Elongation @ Break	ASTM D638	5	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	120	°C

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 4 hours      225      °F

#### Cylinder

Rear      510-580      °F

Middle      520-590      °F

Front      560-600      °F

Nozzle      560-600      °F

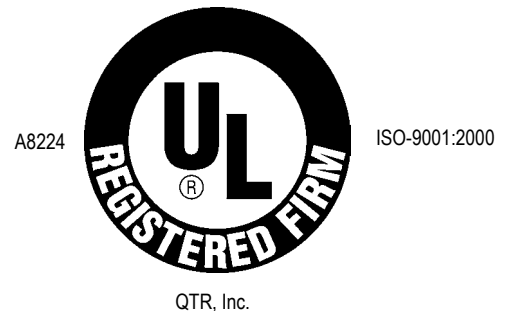
#### Mold

Maximum      220      °F

Minimum      170      °F

Processing Temp      560-600      °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.