



QR-4100-GF20

Glass filled PPE/PS

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<p>Appearance Features</p> <p>Filler/Additive</p>	<p><u>General Description</u> Black Color and Custom Colors Available High Heat Resistance Good Stiffness</p> <p>20% 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	1.2	
Melt Flow Rate	ASTM D1238	N/A	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.002-0.005	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	750,000	psi
Flex Strength @ Yield	ASTM D790	20,000	psi
Notched Izod Impact, 73°F	ASTM D256	2.0	ft.lbs/in
- Low Temp (-22°F)	ASTM D256	1.8	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	13,000	psi
Tensile Elongation @ Break	ASTM D638	5	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	275	°F
Deflection Temp @ 66 psi	ASTM D648	290	°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 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.