



QR-4165

PPE/PS

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<p>Appearance</p> <p>Features</p> <p>Flame Package available as:</p> <p>Filler/Additive</p>	<p><u>General Description</u></p> <p>Available in Black and Grey</p> <p>Good Toughness</p> <p>Flame Retardant</p> <p>Extrusion Grade</p> <p>94V-0 (0.240") / 94V-1 (0.0625")</p> <p>No</p>
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<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.08	
Melt Flow Rate, 280°C/ 2.16 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	360,000	psi
Flex Strength @ Yield	ASTM D790	14,000	psi
Notched Izod Impact, 73°F	ASTM D256	3.0	ft.lbs/in
- Low Temp (-20°F)	ASTM D256	1.8	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	9000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	250	°F
Deflection Temp @ 66 psi	ASTM D648	285	°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 4 hours – Max 6 hours 220-235 °F

Cylinder

Rear 380-400 °F

Middle 420-440 °F

Front 460-480 °F

Nozzle/Adapter 460-480 °F

Mold, if applicable

Maximum 200 °F

Minimum 150 °F

Processing Temp 440-480 °F

Maximum Moisture Content 0.02 %

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.