



QR-8000-GF15

Glass Filled PBT

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Injection Molding Grade High Heat Resistance Good Dimensional Stability Good Chemical Resistance High Strength
Filler/Additive	15% Glass Fiber

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.42	
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.004 – 0.006	in/in
<i>-Mechanical</i>			
Notched Izod Impact, 73°F	ASTM D256	1.0	ft.lbs/in
Flex Modulus	ASTM D790	650,000	psi
Flex Strength @ Yield	ASTM D790	20,000	psi
Tensile Strength @ Yield	ASTM D638	12,500	psi
Tensile Elongation @ Break	ASTM D638	3.0	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	370	°F
Deflection Temp @ 66 psi	ASTM D648	380	°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 250 °F

Cylinder

Rear 450-520 °F

Middle 450-520 °F

Front 470-520 °F

Nozzle 470-520 °F

Mold

Maximum 250 °F

Minimum 150 °F

Processing Temp 480-520 °F

ISO 9001:2000 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.