



QR-8000-GF20 GF/PBT

2301 St. Joseph Industrial Park Drive Evansville, IN 47720 Phone 812/429-0901 Fax 812/429-0905 www.customcompounding.com

Appearance	<u>General Description</u> Natural or Black Color Custom Colors Available
Features	Injection Grade High Heat Resistance Good Dimensional Stability High Stiffness and Strength
Filler/Additive	20% Glass Available w/ Lubricant (L)

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	800,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.1	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	14,500	psi
Tensile Elongation @ Yield	ASTM D638	2.7	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	400	°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 6 hours 250 °F

Cylinder

Rear 460-490 °F

Middle 470-500 °F

Front 480-510 °F

Nozzle 470-500 °F

Mold

Maximum 200 °F

Minimum 150 °F

Processing Temp 480-520 °F

Maximum Moisture Content 0.02 %

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.