



QR-1013 Polycarbonate

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	<u>General Purpose</u> Injection Grade With UV(V) or Release(R)
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.2	
Melt Flow Rate, 300°C/ 1.2 kg	ASTM D1238	13	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	330,000	psi
Flex Strength @ Yield	ASTM D790	13,500	psi
Notched Izod Impact, 73°F	ASTM D256	12	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	9,000	psi
Tensile Elongation @ Break	ASTM D638	120	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	260	°F
Deflection Temp @ 66 psi	ASTM D648	275	°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 8 hours 250 °F

Cylinder

Rear 520-550 °F

Middle 540-570 °F

Front 540-570 °F

Nozzle 550-580 °F

Mold

Maximum 220 °F

Minimum 170 °F

Processing Temp 550-580 °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.