



QR-1018 Polycarbonate

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Appearance	<u>General Description</u> Natural Color Custom Colors Available
Features	High Impact 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	18	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	340,000	psi
Flex Strength @ Yield	ASTM D790	13,000	psi
Notched Izod Impact, 73°F	ASTM D256	12	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,900	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	270	°F
Deflection Temp @ 66 psi	ASTM D648	280	°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 2 hours – Max 4 hours	250	°F
Cylinder		
Rear	500-540	°F
Middle	520-560	°F
Front	540-560	°F
Nozzle	530-560	°F
Mold		
Maximum	200	°F
Minimum	160	°F
Processing Temp	540-580	°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.