



# QR-1018IM Polycarbonate

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	High Impact Injection Grade Good Flow Good Processability 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	320,000	psi
Flex Strength @ Yield	ASTM D790	12,700	psi
Notched Izod Impact, 73°F	ASTM D256	12	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,300	psi
Tensile Elongation @ Break	ASTM D638	110	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	260	°F
Deflection Temp @ 66 psi	ASTM D648	270	°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      490-530      °F

Middle      510-550      °F

Front      530-570      °F

Nozzle      520-560      °F

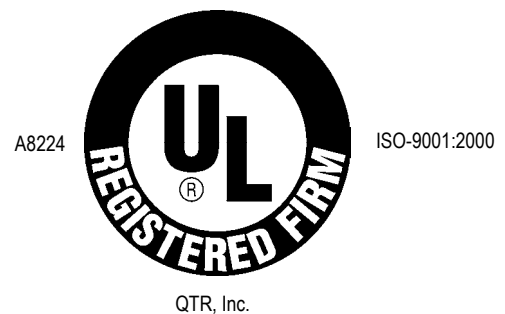
#### Mold

Maximum      200      °F

Minimum      160      °F

Processing Temp      520-560      °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.