



# QR-1220LG(V) PC/ABS Alloy

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Injection Molding Grade Good Impact Resistance Low Gloss Good UV Resistance
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.14	
Melt Flow Rate, 260°C/ 5.0 kg	ASTM D1238	20	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	12,200	psi
Notched Izod Impact, 73°F	ASTM D256	10	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7,700	psi
Tensile Elongation @ Break	ASTM D638	80	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	225	°F
Deflection Temp @ 66 psi	ASTM D648	255	°F
<i>-Flammable</i>			
Flame Rating – UL, HB	UL 94	0.059	in

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 4 hours	220	°F
<b>Cylinder</b>		
Rear	480-540	°F
Middle	490-550	°F
Front	500-565	°F
Nozzle	520-565	°F
<b>Mold</b>		
Maximum	180	°F
Minimum	140	°F
<b>Processing Temp</b>	520-570	°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.