QR-1235P
PC/ABS Alloy

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	General Description
Appearance	Natural/Black Color Custom Colors Available
Features	Good Impact (Ambient and Low Temp) Injection Grade Plateable High Heat Resistance With UV(V) or Release(R)
Filler/Additive	No

Property	Method	Value	Unit
-Physical			
Specific Gravity	ASTM D792	1.14	
Melt Flow Rate, 260°C/ 5.0 kg	ASTM D1238	35	g/10min
230°C/ 3.8 kg	ASTM D1238	10	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
-Mechanical			
Flex Modulus	ASTM D790	350,000	psi
Flex Strength @ Yield	ASTM D790	13,000	psi
Notched Izod Impact, 73°C	ASTM D256	10	ft.lbs/in
- Low Temp (-22°F)	ASTM D256	8	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,100	psi
-Thermal			
Deflection Temp @ 264 psi	ASTM D648	225	°F
Deflection Temp @ 66 psi	ASTM D648	255	°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	225	°F
Cylinder		
Rear	475-540	°F
Middle	480-560	°F
Front	500-570	°F
Nozzle	520-570	°F
Mold		
Maximum	200	°F
Minimum	140	°F
Processing Temp	480-560	°F

ISO9001:2000 Registered

A8224 UL REGISTERED FIRM ISO-9001:2000

QTR, Inc.

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.