



QR-1815

PC / PBT

2301 St. Joseph Industrial Park Drive Evansville, IN 47720 Phone 812/429-0901 Fax 812/429-0905 www.customcompounding.com

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

Property	Method	Value	Unit
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.22	
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.008	in/in
Melt Flow Rate, 250°C/ 5.0 kg	ASTM D1238	15	g/10min
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	266,000	psi
Flex Strength @ Yield	ASTM D790	13,070	psi
Notched Izod Impact, 73°F	ASTM D256	10.0	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	210	°F
Deflection Temp @ 66 psi	ASTM D648	223	°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 230 °F

Cylinder

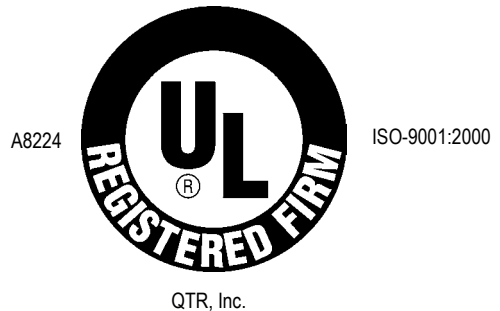
Rear 470-510 °F
 Middle 480-520 °F
 Front 490-530 °F
 Nozzle 490-520 °F

Mold

Maximum 190 °F
 Minimum 150 °F

Processing Temp 470-530 °F

ISO9001:2000 Registered



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 request.

