



QR-1815IM(LT)V PC/PBT

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Low Temperature Impact Modified Good Chemical Resistance With UV(V) Stabilizer
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.19	
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.008-0.010	in/in
Melt Flow Rate, 250°C/ 5.0 kg	ASTM D1238	15	g/10min
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	275,000	psi
Flex Strength @ Yield	ASTM D790	11,000	psi
Notched Izod Impact, 73°F	ASTM D256	13.0	ft.lbs/in
- Low Temp(-22°F)	ASTM D256	8	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	7500	psi
Tensile Elongation @ Break	ASTM D638	150	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	195	°F
Deflection Temp @ 66 psi	ASTM D648	220	°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 6 hours 230 °F

Cylinder

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

Mold

Maximum 180 °F
 Minimum 100 °F

Processing Temp 490-530 °F

QS-9000 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.