



QR-2005IM

ABS

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	Injection Grade High Impact High or Low Gloss (PO Specified)
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.04	
Melt Flow Rate, 230°C/ 3.8 kg	ASTM D1238	5	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	340,000	psi
Flex Strength @ Yield	ASTM D790	10,500	psi
Notched Izod Impact, 73°F	ASTM D256	7	ft.lbs/in
- Low Temp (-40°F)	ASTM D256	1.2	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	6,400	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	185	°F
Deflection Temp @ 66 psi	ASTM D648	200	°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 2 hours – Max 4 hours 200 °F

Cylinder

Rear 370-410 °F

Middle 400-440 °F

Front 420-460 °F

Nozzle 420-500 °F

Mold

Maximum 160 °F

Minimum 120 °F

Processing Temp 420-500 °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 requests.