



QR-4100-GF30

Glass filled PPE/PS

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Appearance	<u>General Description</u> Natural Color Custom Colors Available
Features	High Heat Resistance Good Stiffness
Filler/Additive	30% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.28	
Melt Flow Rate	ASTM D1238	N/A	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.001-0.004	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	1,000,000	psi
Flex Strength @ Yield	ASTM D790	23,000	psi
Notched Izod Impact, 73°F	ASTM D256	2.0	ft.lbs/in
- Low Temp (-22°F)	ASTM D256	1.8	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	15,000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	275	°F
Deflection Temp @ 66 psi	ASTM D648	315	°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 3 hours – Max 4 hours 225 °F

Cylinder

Rear 510-580 °F

Middle 520-590 °F

Front 560-600 °F

Nozzle 560-600 °F

Mold

Maximum 220 °F

Minimum 170 °F

Processing Temp 560-600 °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.