



QR-8000-GF30

Glass fiber reinforced PBT

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Injection Molding Grade High Heat Resistance Good Dimensional Stability Good Chemical Resistance Good Stiffness High Strength
Filler/Additive	30% Glass Fiber

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.53	
Mold Shrink, Linear Flow	ASTM D955	0.003-0.005	in/in
<i>-Mechanical</i>			
Tensile Strength @ Break	ASTM D638	17,000	psi
Tensile Elongation @ Break	ASTM D638	3	%
Flexural Modulus	ASTM D790	1,050,000	psi
Flexural Strength @ Break	ASTM D790	27,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.5	ft.lbs/in
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	400	°F
Deflection Temp @ 66 psi	ASTM D648	415	°F

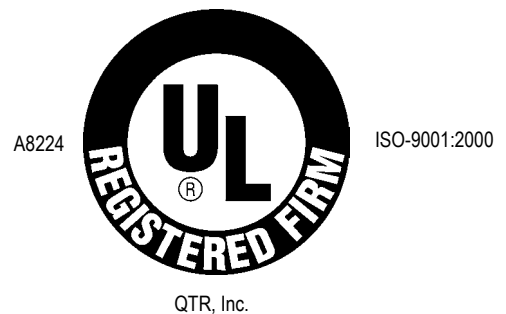
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-Injection Molding

Drying Conditions

Min 3 hours – Max 8 hours	250	°F
Cylinder		
Rear	460-490	°F
Middle	470-500	°F
Front	480-510	°F
Nozzle	470-500	°F
Mold		
Maximum	190	°F
Minimum	150	°F
Processing Temp	480-510	°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.