



QR-8000 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/Black Color Custom Colors Available
Features	Injection Molding Grade Fast Cycle Times
Filler/Additive	None

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.31	
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.008 – 0.016	in/in
<i>-Mechanical</i>			
Notched Izod Impact, 73°F	ASTM D256	1.0	ft.lbs/in
Flex Modulus	ASTM D790	325,000	psi
Flex Strength @ Yield	ASTM D790	11,500	psi
Tensile Strength @ Yield	ASTM D638	7,100	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	115	°F
Deflection Temp @ 66 psi	ASTM D648	290	°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 6 hours	250	°F
Cylinder		
Rear	440-470	°F
Middle	450-480	°F
Front	460-490	°F
Nozzle	450-480	°F
Mold		
Maximum	170	°F
Minimum	120	°F
Processing Temp	460-490	°F
Maximum Moisture Content	0.02	%

ISO 9001:2000 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.