

Technical Data Sheet

Schulblend QR-10120HF-GY25618GRY



Polycarbonate + ASA

Product Description

QR-10120HF-GY25618 is an unfilled, UV and heat stabilized, impact modified, grey, PC/ASA compound that is suitable for injection molding.

Processing Method Injection Molding

Forms Pellets

Appearance Grey

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (260 °C/5.0 kg)	40	g/10 min	ASTM D1238
Density - Specific Gravity	1.17	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	58.6	MPa	ASTM D638
Flexural Strength at Yield	96.5	MPa	ASTM D790
Flexural Modulus	2340	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C)	270	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	132	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	138	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	100	°C
Nozzle Temperature	240-265	°C
Processing (Melt) Temp	304 to 327	°C
Front Temperature	245-270	°C
Middle Temperature	250-275	°C
Rear Temperature	250-275	°C
Mold Temperature	65-95	°C
Drying Time, Maximum	4	hr