

Preliminary Data Sheet
QC-8850
Thermoset Engineered Structural Composite (ESC) Molding Compound

QC-8850 is a polyester hybrid ESC molding compound designed for compression molding of components requiring high structural strength. It exhibits unusual toughness, and excellent stiffness, and is suggested for applications subject to impacts and rough handling.

TYPICAL PROPERTIES -- UNCURED

Form Rolled Sheet, Shelf Life: @75°F 2 month
24" & 48" width, 0.125"
thick
Color Black Glass Fiber Content 43%
Glass Fiber Length 1 inch

TYPICAL PROPERTIES -- CURED

<u>Test</u>	<u>Procedure</u>	<u>Value</u>
Specific Gravity	ASTM D-792	1.70
Shrinkage, inch/inch (cm/cm)	ASTM D-955	0.000 (0.000)
Flexural Strength, psi (MPa) ¹	ASTM D-790	59,000 (406)
Flexural Modulus, psi (GPa) ¹	ASTM D-790	2.0x10 ⁶ (13.7)
Tensile Strength, psi (MPa) ¹	ASTM D-638	39,000 (269)
Izod Impact, notched, ft.lb./in. (J/m)	ASTM D-256	30 (1602)

Molding Suggestions -- QC-8850, can be molded over a range of temperatures and pressures. For part thickness of 0.5 inches or less, molding temperatures of 270 to 300°F are suggested as a starting point, with molding pressure of 300 to 1000 psi. For molding thicker sections, the molding temperature should be reduced. Cure time will depend on molding temperature and part thickness. A 0.25-inch section will cure in 3 to 5 minutes at 280°F.

Precautions -- QC-8850 contains glass fibers and styrene monomer. Use only in areas with good ventilation. Handle carefully in order to minimize skin contact. See Material Safety Data Sheet for additional information.

WARRANTY -- The above information is offered for your consideration, investigation, and verification. No warranty, expressed or implied, is given, nor is freedom from any patents owned by Premix, Inc. or others implied. Final determination of the suitability of this material is the sole responsibility of the buyer. Contact our sales representative for assistance in developing procedures to fit individual requirements.

¹ Tensile and Flexural Properties are determined using net shape molded specimens. Values obtained on cut specimens will typically be lower.