

**Technical Data Sheet**

***Diamond QR-1015-BKBLK***



Polycarbonate

**Product Description**

Available with UV (V) or Release (R).

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	High Impact Resistance
<b>Forms</b>	Pellets
<b>Appearance</b>	Colors Available; Natural Color

<b>Typical Properties</b>	<b>Nominal Value</b>	<b>Units</b>	<b>Test Method</b>
<b>Physical</b>			
Melt Flow Rate, (300 °C/1.2 kg)	15	g/10 min	ASTM D1238
Density - Specific Gravity	1.2	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield	62.1	MPa	ASTM D638
Flexural Strength at Yield	89.6	MPa	ASTM D790
Flexural Modulus	2280	MPa	ASTM D790
<b>Impact</b>			
Notched Izod Impact, (23 °C)	640	J/m	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (264 psi)	127	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	135	°C	ASTM D648

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
Drying Time	4.0 to 8.0	hr
Drying Temperature	121	°C
Nozzle Temperature	271 to 293	°C
Processing (Melt) Temp	271 to 293	°C
Front Temperature	277 to 299	°C
Middle Temperature	266 to 299	°C
Rear Temperature	254 to 277	°C
Mold Temperature	71 to 93	°C
Drying Time, Maximum	8	hr