Technical Data Sheet

Qr Resin QR-1000-GF30

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description		
Available with UV (V) or Release (R).		
General		
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Features	• Good Toughness	
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.43	1.43 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°c/1.2 Kg)	10 to 20 g/10 min	10 to 20 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	19000 psi	131 MPa	ASTM D638
Flexural Modulus	1.00E+6 psi	6890 MPa	ASTM D790
Flexural Strength (Yield)	22800 psi	157 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Unnotched Izod Impact (73°f (23°c))	20 ft·lb/in	1100 J/m	ASTM D4812
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	305 °F	152 °C	
264 Psi (1.8 Mpa), Unannealed	295 °F	146 °C	

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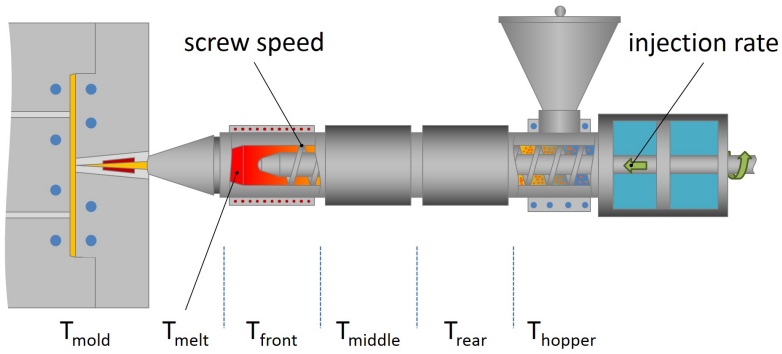

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	3.0 to 6.0 hr	3.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	540 to 580 °F	282 to 304 °C
Middle Temperature	560 to 600 °F	293 to 316 °C
Front Temperature	580 to 640 °F	304 to 338 °C
Nozzle Temperature	580 to 640 °F	304 to 338 °C
Processing (Melt) Temp	600 to 650 °F	316 to 343 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

These are typical property values not to be construed as specification limits.