Technical Data Sheet

Qr Resin QR-1000-GF40

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description		
Available with UV (V) or Release (R).		
General		
Filler / Reinforcement	• Glass Fiber, 40% 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	1.52	1.52 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)	23000 psi	159 MPa	ASTM D638
Flexural Modulus	1.40E+6 psi	9650 MPa	ASTM D790
Flexural Strength (Yield)	26500 psi	183 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Unnotched Izod Impact (73°f (23°c))	22 ft·lb/in	1200 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	310 °F	154 °C	
264 Psi (1.8 Mpa), Unannealed	295 °F	146 °C	

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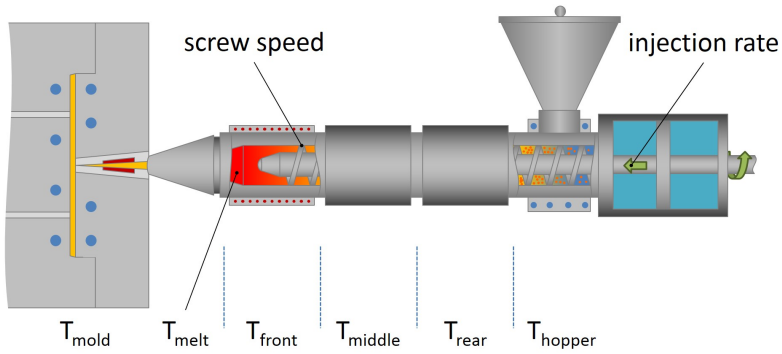

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	3.0 to 6.0 hr	3.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	560 to 600 °F	293 to 316 °C
Middle Temperature	580 to 620 °F	304 to 327 °C
Front Temperature	600 to 640 °F	316 to 338 °C
Nozzle Temperature	590 to 630 °F	310 to 332 °C
Processing (Melt) Temp	600 to 640 °F	316 to 338 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

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