

Technical Data Sheet

Qr Resin QR-1000-GFR30

Polycarbonate
 LyondellBasell Industries
 Engineering Plastics

Product Description

Available with UV (V) or Release (R).
 Flame Packages Available (0.0625 in min. thickness): 94V-2, 94V-0, 94-5VA

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	1.44	1.44 g/cm ³	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)	18800 psi	130 MPa	ASTM D638
Flexural Modulus	990000 psi	6830 MPa	ASTM D790
Flexural Strength (Yield)	22500 psi	155 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Unnotched Izod Impact (73°F (23°C))	15 ft·lb/in	800 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	307 °F	153 °C	
264 Psi (1.8 Mpa), Unannealed	295 °F	146 °C	

Technical Data Sheet

Qr Resin QR-1000-GFR30

Polycarbonate
LyondellBasell Industries
Engineering Plastics



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.