Technical Data Sheet

Qr Resin QR-1000F-GFR10

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, 10% Filler by Weight	
Features	• Foamable	• High Heat Resistance
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.12	1.12 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)	7500 psi	51.7 MPa	ASTM D638
Flexural Modulus	500000 psi	3450 MPa	ASTM D790
Flexural Strength (Yield)	12800 psi	88.3 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Unnotched Izod Impact (73°f (23°c))	14 ft·lb/in	750 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	280 °F	138 °C	
264 Psi (1.8 Mpa), Unannealed	270 °F	132 °C	

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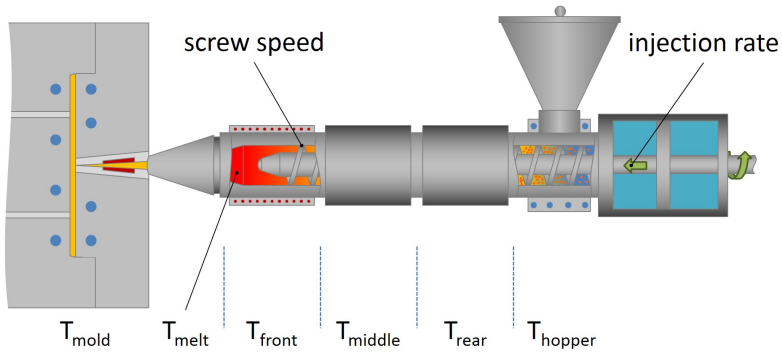

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	3.0 to 6.0 hr	3.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	540 to 590 °F	282 to 310 °C
Middle Temperature	560 to 600 °F	293 to 316 °C
Front Temperature	580 to 620 °F	304 to 327 °C
Nozzle Temperature	580 to 610 °F	304 to 321 °C
Processing (Melt) Temp	580 to 620 °F	304 to 327 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

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