Technical Data Sheet

Qr Resin QR-1012

Polycarbonate
LyondellBasell Industries
Engineering Plastics

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

General		
Features	• High Impact Resistance	
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°c/1.2 Kg)	12 g/10 min	12 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	9000 psi	62.1 MPa	ASTM D638
Flexural Modulus	340000 psi	2340 MPa	ASTM D790
Flexural Strength (Yield)	13900 psi	95.8 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°f (23°c))	12 ft·lb/in	640 J/m	ASTM D256
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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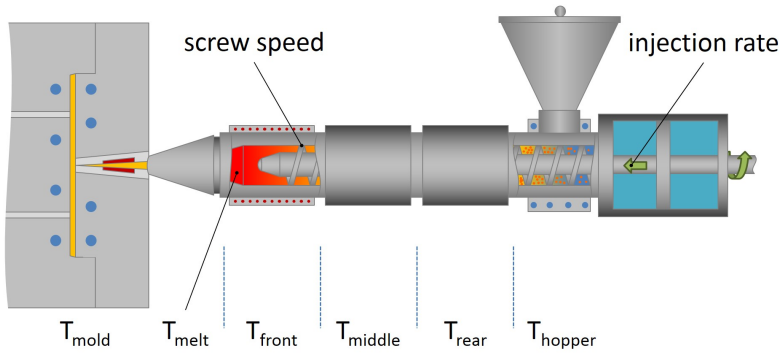

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	520 to 560 °F	271 to 293 °C
Middle Temperature	540 to 590 °F	282 to 310 °C
Front Temperature	560 to 600 °F	293 to 316 °C
Nozzle Temperature	550 to 590 °F	288 to 310 °C
Processing (Melt) Temp	560 to 600 °F	293 to 316 °C
Mold Temperature	160 to 200 °F	71 to 93 °C

Notes

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