

Technical Data Sheet

Qr Resin QR-1013-IM

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

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

General

Features	• High Impact Resistance
Uses	• Automotive Applications
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/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°c/1.2 Kg)	13 g/10 min	13 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)	14000 psi	96.5 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	3.0 to 6.0 hr	3.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	500 to 550 °F	260 to 288 °C
Middle Temperature	520 to 580 °F	271 to 304 °C
Front Temperature	540 to 590 °F	282 to 310 °C
Nozzle Temperature	530 to 580 °F	277 to 304 °C
Processing (Melt) Temp	540 to 590 °F	282 to 310 °C
Mold Temperature	160 to 200 °F	71 to 93 °C

Notes

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