Technical Data Sheet

Qr Resin QR-1013

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description
QR-1013 is availible with UV (V) or Release (R).

General			
Additive	• Mold Release	• UV Stabilizer	
Features	• General Purpose		
Appearance	• Black	• 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)	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
Tensile Elongation (Break)	120 %	120 %	ASTM D638
Flexural Modulus	330000 psi	2280 MPa	ASTM D790
Flexural Strength (Yield)	13500 psi	93.1 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	275 °F	135 °C	
264 Psi (1.8 Mpa), Unannealed	260 °F	127 °C	

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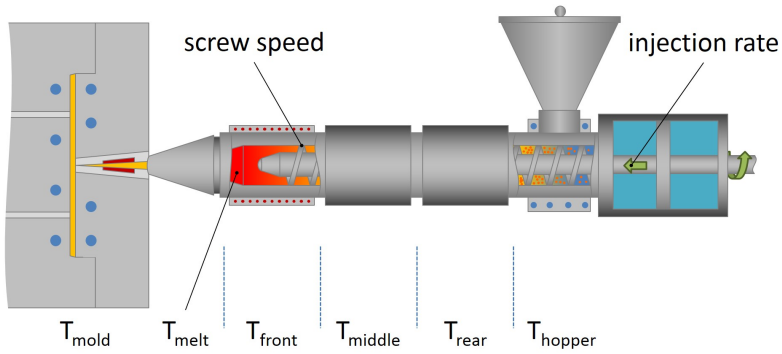

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	4.0 to 8.0 hr	4.0 to 8.0 hr
Drying Time, Maximum	8.0 hr	8.0 hr
Rear Temperature	520 to 550 °F	271 to 288 °C
Middle Temperature	540 to 570 °F	282 to 299 °C
Front Temperature	540 to 570 °F	282 to 299 °C
Nozzle Temperature	550 to 580 °F	288 to 304 °C
Processing (Melt) Temp	550 to 580 °F	288 to 304 °C
Mold Temperature	170 to 220 °F	77 to 104 °C

Notes

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