

Technical Data Sheet

# Qr Resin QR-1018-FR

Polycarbonate  
LyondellBasell Industries  
Engineering Plastics

**Product Description**

Flame Packages Available (0.0625 in min. thickness): 94V-2, 94V-0, 94-5VA

**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
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Density / Specific Gravity	1.21	1.21 g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 Kg)	18 g/10 min	18 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
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Tensile Strength (Yield)	9000 psi	62.1 MPa	ASTM D638
Flexural Modulus	324000 psi	2230 MPa	ASTM D790
Flexural Strength (Yield)	13000 psi	89.6 MPa	ASTM D790

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
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Notched Izod Impact (73°F (23°C))	12 ft·lb/in	640 J/m	ASTM D256
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Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
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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 540 °F	260 to 282 °C
Middle Temperature	520 to 560 °F	271 to 293 °C
Front Temperature	540 to 580 °F	282 to 304 °C
Nozzle Temperature	530 to 570 °F	277 to 299 °C
Processing (Melt) Temp	540 to 570 °F	282 to 299 °C
Mold Temperature	160 to 200 °F	71 to 93 °C

**Notes**

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