Technical Data Sheet

Qr Resin QR-1022-FR

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

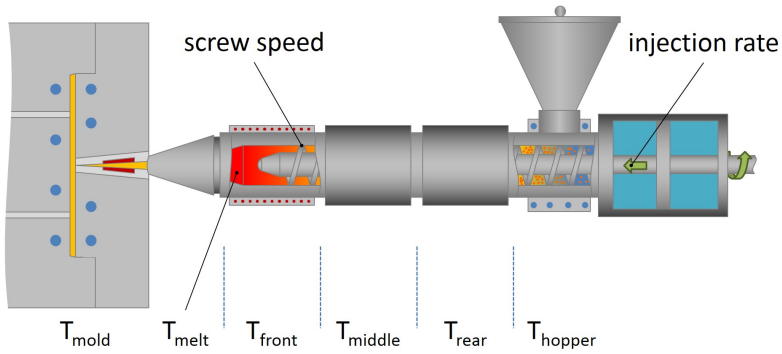
General		
Features	• High Impact Resistance	
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°c/1.2 Kg)	20 g/10 min	20 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	322000 psi	2220 MPa	ASTM D790
Flexural Strength (Yield)	12900 psi	88.9 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	

Technical Data Sheet

Qr Resin QR-1022-FR

Polycarbonate
LyondellBasell Industries
Engineering Plastics



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.