

Technical Data Sheet

***Diamaloy* QR-1310IM(V)R-BKBLK**



Polycarbonate + Polyester

Product Description

QR-1310IM is available with UV (V) or Release (R).

Processing Method	Injection Molding
Attribute	Good Chemical Resistance; Good Mold Release; Low Temperature Impact Resistance
Forms	Pellets
Appearance	Black; Colors Available; Natural Color
Additive	Mold Release; UV Stabilizer

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (250 °C/5.0 kg)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.21	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	51.7	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Impact			
Notched Izod Impact			
(23 °C)	750	J/m	ASTM D256
(-40 °C)	430	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	98.9	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	110	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	110	°C
Suggested Max Moisture	0.02	%
Nozzle Temperature	254 to 271	°C
Processing (Melt) Temp	260 to 277	°C
Front Temperature	254 to 277	°C
Middle Temperature	249 to 271	°C
Rear Temperature	243 to 266	°C
Mold Temperature	66 to 88	°C
Drying Time, Maximum	6	hr