Technical Data Sheet

Qr Resin QR-1305IM(LT)

Polycarbonate + Polyester
LyondellBasell Industries
Engineering Plastics

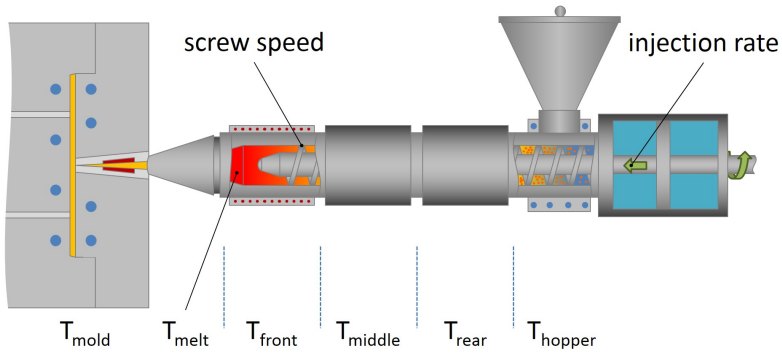
General			
Features	• Chemical Resistant • Good Impact Resistance	• Good Melt Strength • Good Thermal Stability	• Low Temperature Impact Resistance
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

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) (230°c/3.8 Kg)	5.0 g/10 min	5.0 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	8000 psi	55.2 MPa	ASTM D638
Tensile Elongation (Break)	120 %	120 %	ASTM D638
Flexural Modulus	300000 psi	2070 MPa	ASTM D790
Flexural Strength (Yield)	12000 psi	82.7 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256
-22°f (-30°c)	9.0 ft·lb/in	480 J/m	
73°f (23°c)	13 ft·lb/in	690 J/m	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 Psi (1.8 Mpa), Unannealed	235 °F	113 °C	

Technical Data Sheet

Qr Resin QR-1305IM(LT)

Polycarbonate + Polyester
LyondellBasell Industries
Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	230 °F	110 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Rear Temperature	480 to 520 °F	249 to 271 °C
Middle Temperature	490 to 530 °F	254 to 277 °C
Front Temperature	500 to 540 °F	260 to 282 °C
Nozzle Temperature	490 to 530 °F	254 to 277 °C
Processing (Melt) Temp	500 to 540 °F	260 to 282 °C
Mold Temperature	150 to 220 °F	66 to 104 °C

Notes

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