Technical Data Sheet

Qr Resin QR-1805IMLM

Polycarbonate + Polyester
LyondellBasell Industries
Engineering Plastics

General			
Features	• Chemical Resistant	• Good Impact Resistance	• Low Flow
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.00	0.998 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (266°c/5.0 Kg)	8.0 g/10 min	8.0 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	8150 psi	56.2 MPa	ASTM D638
Tensile Elongation (Break)	160 %	160 %	ASTM D638
Flexural Modulus	297000 psi	2050 MPa	ASTM D790
Flexural Strength (Yield)	11600 psi	80.0 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°f (23°c))	15 ft·lb/in	800 J/m	ASTM D256
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 Psi (1.8 Mpa), Unannealed	232 °F	111 °C	

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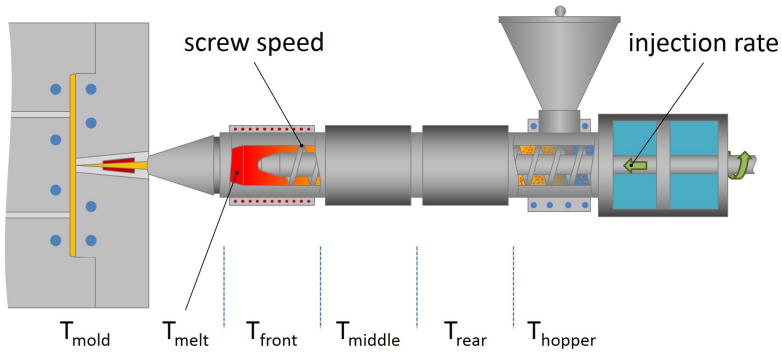

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	230 °F	110 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Rear Temperature	470 to 510 °F	243 to 266 °C
Middle Temperature	480 to 520 °F	249 to 271 °C
Front Temperature	490 to 530 °F	254 to 277 °C
Nozzle Temperature	490 to 520 °F	254 to 271 °C
Processing (Melt) Temp	500 to 530 °F	260 to 277 °C
Mold Temperature	150 to 190 °F	66 to 88 °C

Notes

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