

Qr Resin QR-1012

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

Available with UV (V) or Release (R).

General

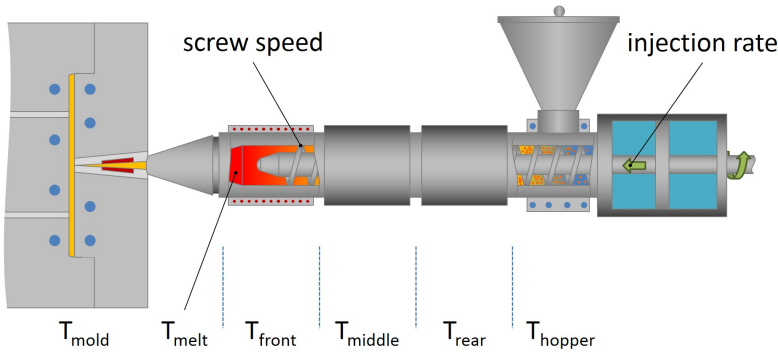
Features	• High Impact Resistance
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 Kg)	12 g/10 min	12 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	340000 psi	2340 MPa	ASTM D790
Flexural Strength (Yield)	13900 psi	95.8 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	



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	520 to 560 °F	271 to 293 °C
Middle Temperature	540 to 590 °F	282 to 310 °C
Front Temperature	560 to 600 °F	293 to 316 °C
Nozzle Temperature	550 to 590 °F	288 to 310 °C
Processing (Melt) Temp	560 to 600 °F	293 to 316 °C
Mold Temperature	160 to 200 °F	71 to 93 °C

Notes

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

