

Qr Resin QR-1805IMLM

Polycarbonate + Polyester

LyondellBasell Industries

Engineering Plastics

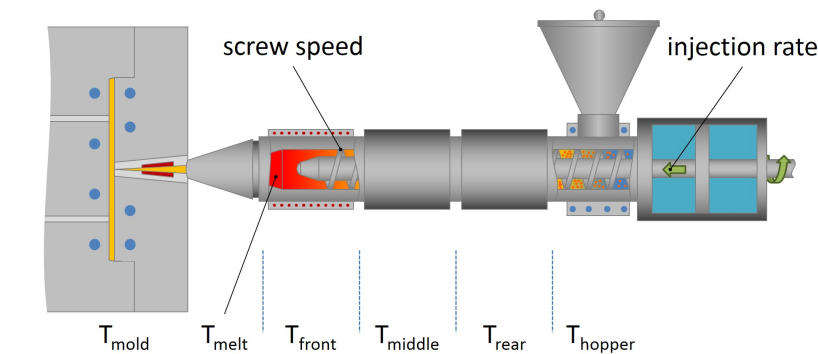
General			
Features	• Chemical Resistant	• Good Impact Resistance	• Low Flow
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.00	0.998 g/cm ³	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 264 Psi (1.8 Mpa), Unannealed	232 °F	111 °C	ASTM D648



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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.

