



Diamond QR-1015-BKBLK

LyondellBasell Industries - Polycarbonate

General Information

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9010	psi	ASTM D638
Flexural Modulus	331000	psi	ASTM D790
Flexural Strength (Yield)	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	12	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	275	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	261	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0 to 8.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	489 to 531	°F
Middle Temperature	511 to 570	°F
Front Temperature	531 to 570	°F
Nozzle Temperature	520 to 559	°F
Processing (Melt) Temp	520 to 559	°F
Mold Temperature	160 to 199	°F