

Technical Data Sheet

Diamond QR-1015-BKBLK



Polycarbonate

Product Description

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

Processing Method	Injection Molding
Attribute	High Impact Resistance
Forms	Pellets
Appearance	Colors Available; Natural Color

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (300 °C/1.2 kg)	15	g/10 min	ASTM D1238
Density - Specific Gravity	1.2	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	62.1	MPa	ASTM D638
Flexural Strength at Yield	89.6	MPa	ASTM D790
Flexural Modulus	2280	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C)	640	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	127	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	135	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 8.0	hr
Drying Temperature	121	°C
Nozzle Temperature	271 to 293	°C
Processing (Melt) Temp	271 to 293	°C
Front Temperature	277 to 299	°C
Middle Temperature	266 to 299	°C
Rear Temperature	254 to 277	°C
Mold Temperature	71 to 93	°C
Drying Time, Maximum	8	hr