

Technical Data Sheet

Qr Resin QR-1000-GF30

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

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

General

Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Features	• Good Toughness
Appearance	• Colors Available • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.43	1.43 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 Kg)	10 to 20 g/10 min	10 to 20 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	19000 psi	131 MPa	ASTM D638
Flexural Modulus	1.00E+6 psi	6890 MPa	ASTM D790
Flexural Strength (Yield)	22800 psi	157 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Unnotched Izod Impact (73°F (23°C))	20 ft·lb/in	1100 J/m	ASTM D4812
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	305 °F	152 °C	
264 Psi (1.8 Mpa), Unannealed	295 °F	146 °C	

Technical Data Sheet

Qr Resin QR-1000-GF30

Polycarbonate
LyondellBasell Industries
Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	3.0 to 6.0 hr	3.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	540 to 580 °F	282 to 304 °C
Middle Temperature	560 to 600 °F	293 to 316 °C
Front Temperature	580 to 640 °F	304 to 338 °C
Nozzle Temperature	580 to 640 °F	304 to 338 °C
Processing (Melt) Temp	600 to 650 °F	316 to 343 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

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