

Technical Data Sheet

Qr Resin QR-1000-GF40

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

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

General

Filler / Reinforcement	• Glass Fiber, 40% 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	1.52	1.52 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)	23000 psi	159 MPa	ASTM D638
Flexural Modulus	1.40E+6 psi	9650 MPa	ASTM D790
Flexural Strength (Yield)	26500 psi	183 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Unnotched Izod Impact (73°F (23°C))	22 ft·lb/in	1200 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	310 °F	154 °C	
264 Psi (1.8 Mpa), Unannealed	295 °F	146 °C	

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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	560 to 600 °F	293 to 316 °C
Middle Temperature	580 to 620 °F	304 to 327 °C
Front Temperature	600 to 640 °F	316 to 338 °C
Nozzle Temperature	590 to 630 °F	310 to 332 °C
Processing (Melt) Temp	600 to 640 °F	316 to 338 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

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