

Technical Data Sheet

Qr Resin QR-1000F-GFR10

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

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

Flame Packages Available (0.0625 in min. thickness): 94V-2, 94V-0, 94-5VA

General

Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight		
Features	• Foamable	• High Heat Resistance	
Appearance	• Colors Available	• Natural Color	
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.12	1.12 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)	7500 psi	51.7 MPa	ASTM D638
Flexural Modulus	500000 psi	3450 MPa	ASTM D790
Flexural Strength (Yield)	12800 psi	88.3 MPa	ASTM D790

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Unnotched Izod Impact (73°F (23°C))	14 ft·lb/in	750 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	280 °F	138 °C	
264 Psi (1.8 Mpa), Unannealed	270 °F	132 °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	540 to 590 °F	282 to 310 °C
Middle Temperature	560 to 600 °F	293 to 316 °C
Front Temperature	580 to 620 °F	304 to 327 °C
Nozzle Temperature	580 to 610 °F	304 to 321 °C
Processing (Melt) Temp	580 to 620 °F	304 to 327 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

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