

Technical Data Sheet

Qr Resin QR-1013

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

QR-1013 is available with UV (V) or Release (R).

General

Additive	• Mold Release	• UV Stabilizer	
Features	• General Purpose		
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 Kg)	13 g/10 min	13 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	9000 psi	62.1 MPa	ASTM D638
Tensile Elongation (Break)	120 %	120 %	ASTM D638
Flexural Modulus	330000 psi	2280 MPa	ASTM D790
Flexural Strength (Yield)	13500 psi	93.1 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	12 ft·lb/in	640 J/m	ASTM D256
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	275 °F	135 °C	
264 Psi (1.8 Mpa), Unannealed	260 °F	127 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	4.0 to 8.0 hr	4.0 to 8.0 hr
Drying Time, Maximum	8.0 hr	8.0 hr
Rear Temperature	520 to 550 °F	271 to 288 °C
Middle Temperature	540 to 570 °F	282 to 299 °C
Front Temperature	540 to 570 °F	282 to 299 °C
Nozzle Temperature	550 to 580 °F	288 to 304 °C
Processing (Melt) Temp	550 to 580 °F	288 to 304 °C
Mold Temperature	170 to 220 °F	77 to 104 °C

Notes

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