

Technical Data Sheet

Qr Resin QR-1015

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

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

General

Features	• High Impact Resistance
Appearance	• 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)	15 g/10 min	15 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	9000 psi	62.1 MPa	ASTM D638
Flexural Modulus	330000 psi	2280 MPa	ASTM D790
Flexural Strength (Yield)	13000 psi	89.6 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	490 to 530 °F	254 to 277 °C
Middle Temperature	510 to 570 °F	266 to 299 °C
Front Temperature	530 to 570 °F	277 to 299 °C
Nozzle Temperature	520 to 560 °F	271 to 293 °C
Processing (Melt) Temp	520 to 560 °F	271 to 293 °C
Mold Temperature	160 to 200 °F	71 to 93 °C

Notes

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