

Technical Data Sheet

Qr Resin QR-1018IM

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

QR-1018IM is available with UV (V) or Release (R).

General

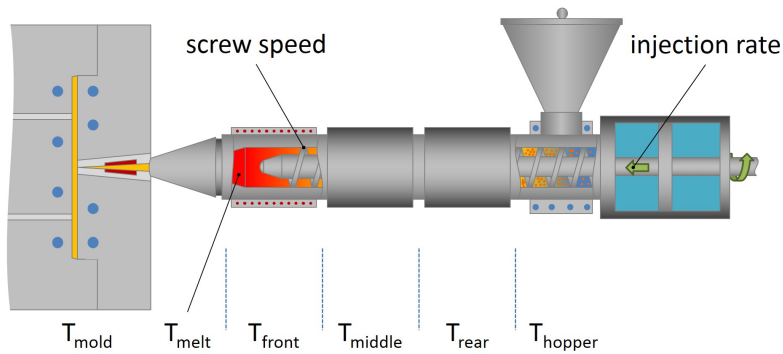
Additive	• Impact Modifier	• Mold Release	• UV Stabilizer
Features	• Good Flow	• Good Processability	• High Impact Resistance
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

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)	18 g/10 min	18 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8300 psi	57.2 MPa	ASTM D638
Tensile Elongation (Break)	110 %	110 %	ASTM D638
Flexural Modulus	320000 psi	2210 MPa	ASTM D790
Flexural Strength (Yield)	12700 psi	87.6 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), Annealed	270 °F	132 °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 550 °F	266 to 288 °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.