

## Technical Data Sheet

# Qr Resin QR-1022-FR

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

|                   |                                    |
|-------------------|------------------------------------|
| 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               | 1.21                    | 1.21 g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (300°C/1.2 Kg) | 20 g/10 min             | 20 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                         | 322000 psi              | 2220 MPa               | ASTM D790   |
| Flexural Strength (Yield)                | 12900 psi               | 88.9 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            | 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       | 500 to 540 °F           | 260 to 282 °C      |
| Middle Temperature     | 520 to 560 °F           | 271 to 293 °C      |
| Front Temperature      | 540 to 580 °F           | 282 to 304 °C      |
| Nozzle Temperature     | 530 to 570 °F           | 277 to 299 °C      |
| Processing (Melt) Temp | 540 to 570 °F           | 282 to 299 °C      |
| Mold Temperature       | 160 to 200 °F           | 71 to 93 °C        |

### Notes

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