

Technical Data Sheet

Qr Resin QR-1815

Polycarbonate + PBT
LyondellBasell Industries
Engineering Plastics

Product Description

QR-1815 is available with UV (V) or Release (R).

General

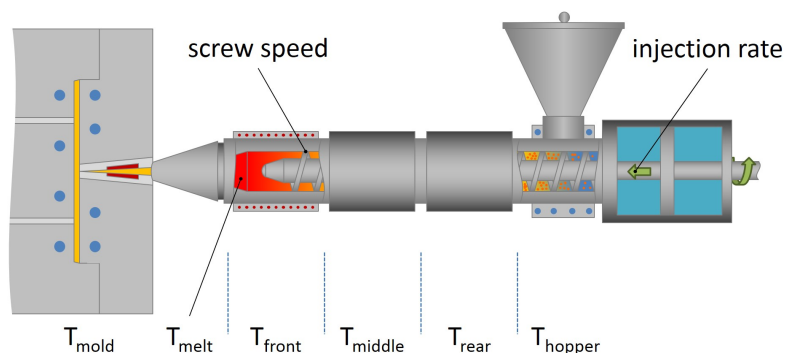
Additive	• Mold Release	• UV Stabilizer
Features	• Good Mold Release	
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.22	1.22 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 Kg)	15 g/10 min	15 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8000 psi	55.2 MPa	ASTM D638
Flexural Modulus	266000 psi	1830 MPa	ASTM D790
Flexural Strength (Yield)	13100 psi	90.1 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	10 ft·lb/in	530 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	223 °F	106 °C	
264 Psi (1.8 Mpa), Unannealed	210 °F	98.9 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	230 °F	110 °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	470 to 510 °F	243 to 266 °C
Middle Temperature	480 to 520 °F	249 to 271 °C
Front Temperature	490 to 530 °F	254 to 277 °C
Nozzle Temperature	490 to 520 °F	254 to 271 °C
Processing (Melt) Temp	470 to 530 °F	243 to 277 °C
Mold Temperature	150 to 190 °F	66 to 88 °C

Notes

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