

Technical Data Sheet

## Qr Resin QR-1815IM(LT)V

Polycarbonate + PBT  
LyondellBasell Industries  
Engineering Plastics

### Product Description

QR-1815IM(LT)V is available with UV (V) Stabilizer.

### General

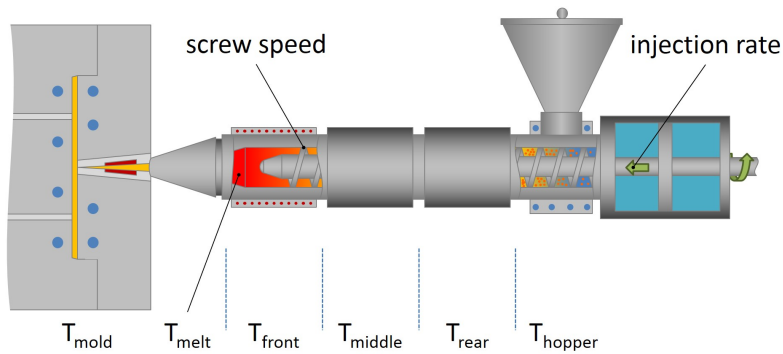
|            |                      |                    |                                     |
|------------|----------------------|--------------------|-------------------------------------|
| Additive   | • Impact Modifier    | • UV Stabilizer    |                                     |
| Features   | • Chemical Resistant | • Impact Modified  | • Low Temperature Impact Resistance |
| Appearance | • Black              | • Colors Available | • Natural Color                     |
| Forms      | • Pellets            |                    |                                     |

| Physical                                 | Nominal Value (English) | Nominal Value (SI)     | Test Method |
|------------------------------------------|-------------------------|------------------------|-------------|
| Density / Specific Gravity               | 1.19                    | 1.19 g/cm <sup>3</sup> | 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)                 | 7500 psi                | 51.7 MPa               | ASTM D638   |
| Tensile Elongation (Break)               | 150 %                   | 150 %                  | ASTM D638   |
| Flexural Modulus                         | 275000 psi              | 1900 MPa               | ASTM D790   |
| Flexural Strength (Yield)                | 11000 psi               | 75.8 MPa               | ASTM D790   |
| Impact                                   | Nominal Value (English) | Nominal Value (SI)     | Test Method |
| Notched Izod Impact                      |                         |                        | ASTM D256   |
| -22°F (-30°C)                            | 8.0 ft·lb/in            | 430 J/m                |             |
| 73°F (23°C)                              | 13 ft·lb/in             | 690 J/m                |             |
| Thermal                                  | Nominal Value (English) | Nominal Value (SI)     | Test Method |
| Deflection Temperature Under Load        |                         |                        | ASTM D648   |
| 66 Psi (0.45 Mpa), Unannealed            | 220 °F                  | 104 °C                 |             |
| 264 Psi (1.8 Mpa), Unannealed            | 195 °F                  | 90.6 °C                |             |

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| Injection              | Nominal Value (English) | Nominal Value (SI) |
|------------------------|-------------------------|--------------------|
| Drying Temperature     | 230 °F                  | 110 °C             |
| Drying Time            | 4.0 to 6.0 hr           | 4.0 to 6.0 hr      |
| Drying Time, Maximum   | 6.0 hr                  | 6.0 hr             |
| Rear Temperature       | 470 to 510 °F           | 243 to 266 °C      |
| Middle Temperature     | 480 to 520 °F           | 249 to 271 °C      |
| Front Temperature      | 480 to 520 °F           | 249 to 271 °C      |
| Nozzle Temperature     | 480 to 520 °F           | 249 to 271 °C      |
| Processing (Melt) Temp | 490 to 530 °F           | 254 to 277 °C      |
| Mold Temperature       | 100 to 180 °F           | 38 to 82 °C        |

### Notes

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