

Technical Data Sheet

Qr Resin QR-1305IM(LT)

Polycarbonate + Polyester
LyondellBasell Industries
Engineering Plastics

General			
Features	• Chemical Resistant • Good Impact Resistance	• Good Melt Strength • Good Thermal Stability	• Low Temperature Impact Resistance
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 Kg)	5.0 g/10 min	5.0 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8000 psi	55.2 MPa	ASTM D638
Tensile Elongation (Break)	120 %	120 %	ASTM D638
Flexural Modulus	300000 psi	2070 MPa	ASTM D790
Flexural Strength (Yield)	12000 psi	82.7 MPa	ASTM D790

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
-22°F (-30°C)	9.0 ft·lb/in	480 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
264 Psi (1.8 Mpa), Unannealed	235 °F	113 °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
Suggested Max Moisture	0.02 %	0.02 %
Rear Temperature	480 to 520 °F	249 to 271 °C
Middle Temperature	490 to 530 °F	254 to 277 °C
Front Temperature	500 to 540 °F	260 to 282 °C
Nozzle Temperature	490 to 530 °F	254 to 277 °C
Processing (Melt) Temp	500 to 540 °F	260 to 282 °C
Mold Temperature	150 to 220 °F	66 to 104 °C

Notes

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