Technical Data Sheet

LyondellBasell

Qr Resin QR-1013

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description			
QR-1013 is availible with UV (V) or Release (R).			
General			
Material Status	• Commercial: Active		
Availability	• North America		
Additive	• Mold Release	• UV Stabilizer	
Features	• General Purpose		
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.20	1.20 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	13 g/10 min	13 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	9000 psi	62.1 MPa	ASTM D638
Tensile Elongation (Break)	120 %	120 %	ASTM D638
Flexural Modulus	330000 psi	2280 MPa	ASTM D790
Flexural Strength (Yield)	13500 psi	93.1 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	275 °F	135 °C	
264 psi (1.8 MPa), Unannealed	260 °F	127 °C	

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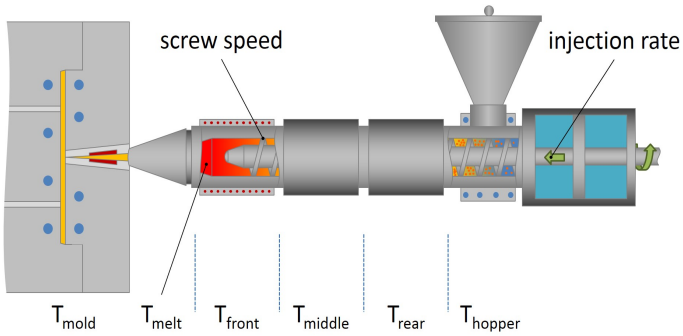

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	4.0 to 8.0 hr	4.0 to 8.0 hr
Drying Time, Maximum	8.0 hr	8.0 hr
Rear Temperature	520 to 550 °F	271 to 288 °C
Middle Temperature	540 to 570 °F	282 to 299 °C
Front Temperature	540 to 570 °F	282 to 299 °C
Nozzle Temperature	550 to 580 °F	288 to 304 °C
Processing (Melt) Temp	550 to 580 °F	288 to 304 °C
Mold Temperature	170 to 220 °F	77 to 104 °C

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit http://www.lyb.com/.

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