

Technical Data Sheet

**Qr Resin QR-1305IM(LT)**

Polycarbonate + Polyester
LyondellBasell Industries
Engineering Plastics

General

Material Status	• Commercial: Active		
Availability	• North America		
Features	• Chemical Resistant • Good Impact Resistance	• Good Melt Strength • Good Thermal Stability	• Low Temperature Impact Resistance
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

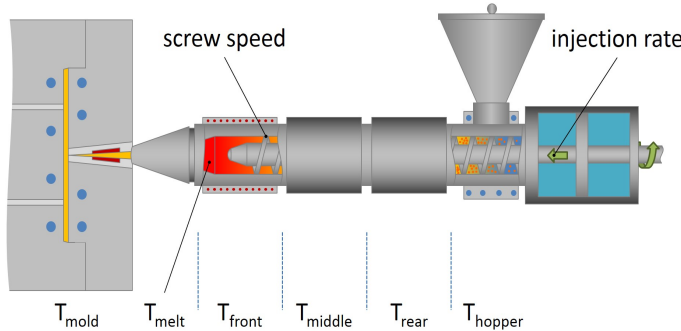
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	5.0 g/10 min	5.0 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8000 psi	55.2 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 264 psi (1.8 MPa), Unannealed	235 °F	113 °C	ASTM D648

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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.

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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