

Technical Data Sheet

**Qr Resin QR-1310IM**

Polycarbonate + Polyester
LyondellBasell Industries
Engineering Plastics

Product Description

QR-1310IM is available with UV (V) or Release (R).

General

Material Status	• Commercial: Active		
Availability	• North America		
Additive	• Mold Release	• UV Stabilizer	
Features	• Chemical Resistant	• Good Mold Release	• Low Temperature Impact Resistance
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	10 g/10 min	10 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	7500 psi	51.7 MPa	ASTM D638
Flexural Modulus	300000 psi	2070 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
-40°F (-40°C)	8.0 ft·lb/in	430 J/m	
73°F (23°C)	14 ft·lb/in	750 J/m	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	230 °F	110 °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 6.0 hr	4.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
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	500 to 530 °F	260 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.

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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