

**QR Resin QR-1000-GFR30 R**

PC-GF30

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	15	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.002	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Yield	130	MPa	ASTM D 638
Flexural Modulus	6830	MPa	ASTM D 790
Izod Impact unnotched, 1/8 in	800	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 66 psi	153	°C	ASTM D 648
DTUL @ 264 psi	146	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1440	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	121	°C	-
Pre-drying - Time	3 - 6	h	-
Melt temperature	316 - 343	°C	-
Mold temperature	82 - 116	°C	-
Zone 1	282 - 304	°C	-
Zone 2	293 - 316	°C	-
Zone 3	304 - 338	°C	-
Nozzle temperature	304 - 338	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Natural Color

**Additives**

Release agent

**Special Characteristics**

Flame retardant

**Regional Availability**

North America