

**QR Resin QR-1310IM V**  
(PC+Polyester)

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>10</b>	g/10min	ASTM D 1238
Temperature	<b>260</b>	°C	-
Load	<b>5</b>	kg	-
Mold Shrinkage, MD	<b>0.009</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>51.7</b>	MPa	ASTM D 638
Flexural Modulus	<b>2070</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>750</b>	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	<b>430</b>	J/m	ASTM D 256
Temperature	<b>-40</b>	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 66 psi	<b>110</b>	°C	ASTM D 648
DTUL @ 264 psi	<b>98.9</b>	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	<b>1210</b>	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>110</b>	°C	-
Pre-drying - Time	<b>4 - 6</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>260 - 277</b>	°C	-
Mold temperature	<b>66 - 88</b>	°C	-
Zone 1	<b>243 - 266</b>	°C	-
Zone 2	<b>249 - 271</b>	°C	-
Zone 3	<b>254 - 277</b>	°C	-
Nozzle temperature	<b>254 - 271</b>	°C	-

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Pellets, Black, Natural Color

**Special Characteristics**

High impact or impact modified, U.V. stabilized or stable to weather

**Chemical Resistance**

General Chemical Resistance

**Regional Availability**

North America