

QR Resin QR-1000-GF10 R

PC-GF10

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	15	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	65.5	MPa	ASTM D 638
Flexural Modulus	3120	MPa	ASTM D 790
Izod Impact notched, 1/8 in	64	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	143	°C	ASTM D 648
DTUL @ 264 psi	141	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1260	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	121	°C	-
Pre-drying - Time	3 - 6	h	-
Melt temperature	304 - 327	°C	-
Mold temperature	82 - 116	°C	-
Zone 1	282 - 310	°C	-
Zone 2	293 - 316	°C	-
Zone 3	304 - 327	°C	-
Nozzle temperature	304 - 321	°C	-

Characteristics**Processing**

Injection Molding

Additives

Release agent

Delivery form

Pellets, Natural Color

Regional Availability

North America