

QR Resin QR-1815 R
(PC+PBT)

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	15	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.008	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	55.2	MPa	ASTM D 638
Flexural Modulus	1830	MPa	ASTM D 790
Izod Impact notched, 1/8 in	530	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	106	°C	ASTM D 648
DTUL @ 264 psi	98.9	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1220	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4 - 8	h	-
Melt temperature	243 - 277	°C	-
Mold temperature	66 - 88	°C	-
Zone 1	243 - 266	°C	-
Zone 2	249 - 271	°C	-
Zone 3	254 - 277	°C	-
Nozzle temperature	254 - 271	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets, Natural Color

Regional Availability

North America