

QR Resin QR-1310IM R
(PC+Polyester)

LyondellBasell Industries

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

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

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

Other properties	Value	Unit	Test Standard
Density	1210	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	260 - 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

Delivery form

Pellets, Black, Natural Color

Additives

Release agent

Special Characteristics

High impact or impact modified

Chemical Resistance

General Chemical Resistance

Regional Availability

North America