

QR Resin QR-1013

Polycarbonate

QTR, Inc.

Message:

QR-1013 is available with UV (V) or Release (R).

General Information			
Additive	Mold Release		
	UV Stabilizer		
Features	General Purpose		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	13	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Tensile Elongation (Break)	120	%	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength (Yield)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	135	°C	
1.8 MPa, Unannealed	127	°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0 to 8.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	271 to 288	°C	
Middle Temperature	282 to 299	°C	
Front Temperature	282 to 299	°C	
Nozzle Temperature	288 to 304	°C	

Processing (Melt) Temp	288 to 304	°C
Mold Temperature	76.7 to 104	°C

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Recommended distributors for this material

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