

QR Resin QR-1000F-GFR10

Polycarbonate

QTR, Inc.

Message:

Available with UV (V) or Release (R).
Flame Packages Available (0.0625 in min. thickness): 94V-2, 94V-0, 94-5VA

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	Foamable		
	High Heat Resistance		
Appearance	Colors Available		
	Natural Color		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10 to 20	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	51.7	MPa	ASTM D638
Flexural Modulus	3450	MPa	ASTM D790
Flexural Strength (Yield)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (23°C)	750	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	138	°C	
1.8 MPa, Unannealed	132	°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 6.0	hr	
Drying Time, Maximum	6.0	hr	
Rear Temperature	282 to 310	°C	
Middle Temperature	293 to 316	°C	
Front Temperature	304 to 327	°C	
Nozzle Temperature	304 to 321	°C	
Processing (Melt) Temp	304 to 327	°C	
Mold Temperature	82.2 to 116	°C	

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Recommended distributors for this material

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