

QR Resin QR-1018-FR

Polycarbonate

QTR, Inc.

Message:

Flame Packages Available (0.0625 in min. thickness): 94V-2, 94V-0, 94-5VA

General Information			
Features	High Impact Resistance		
Appearance	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18	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
Flexural Modulus	2230	MPa	ASTM D790
Flexural Strength (Yield)	89.6	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	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	260 to 282	°C	
Middle Temperature	271 to 293	°C	
Front Temperature	282 to 304	°C	
Nozzle Temperature	277 to 299	°C	
Processing (Melt) Temp	282 to 299	°C	
Mold Temperature	71.1 to 93.3	°C	

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