

QR Resin QR-1310IM

Polycarbonate + Polyester

QTR, Inc.

Message:

QR-1310IM is available with UV (V) or Release (R).

General Information			
Additive	Mold Release		
	UV Stabilizer		
Features	Good Chemical Resistance		
	Good Mold Release		
	Low Temperature Impact Resistance		
Appearance	Black		
	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) (250°C/5.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	51.7	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	430	J/m	
23°C	750	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	110	°C	
1.8 MPa, Unannealed	98.9	°C	
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Max Moisture	0.020	%	

Rear Temperature	243 to 266	°C
Middle Temperature	249 to 271	°C
Front Temperature	254 to 277	°C
Nozzle Temperature	254 to 271	°C
Processing (Melt) Temp	260 to 277	°C
Mold Temperature	65.6 to 87.8	°C

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Recommended distributors for this material

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