

Technical Data Sheet

Diamaloy QR-1310IM(V)R-BKBLK

Polycarbonate + Polyester



Product Description

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

Regulatory Status

For regulatory compliance information, see QR-1310IM(V)R-BKBLK [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

Status	Commercial: Active
Availability	North America
Processing Method	Injection Molding
Attribute	Good Chemical Resistance; Good Mold Release; Low Temperature Impact Resistance
Forms	Pellets
Appearance	Black; Colors Available; Natural Color
Additive	Mold Release; UV Stabilizer

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (250 °C/5.0 kg)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.21	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	51.7	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Impact			
Notched Izod Impact			
(23 °C)	750	J/m	ASTM D256
(-40 °C)	430	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	98.9	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	110	°C	ASTM D648



Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	110	°C
Suggested Max Moisture	0.02	%
Nozzle Temperature	254 to 271	°C
Processing (Melt) Temp	260 to 277	°C
Front Temperature	254 to 277	°C
Middle Temperature	249 to 271	°C
Rear Temperature	243 to 266	°C
Mold Temperature	66 to 88	°C
Drying Time, Maximum	6	hr

Notes

These are typical property values not to be construed as specification limits. The typical values for this product may have been tested on a natural grade.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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