

Qr Resin QR-1235

Polycarbonate Alloy
LyondellBasell Industries
Engineering Plastics

Product Description

PC/ABS Alloy
QR-1235 is available with UV (V) or Release (R).

General

Additive	- Mold Release - UV Stabilizer
Features	- Good Impact Resistance - Good Mold Release - High Heat Resistance - Low Temperature Impact Resistance
Appearance	- Black - Colors Available - Natural Color
Forms	Pellets

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.14	1.14 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
230°C/3.8 Kg	10 g/10 min	10 g/10 min	
260°C/5.0 Kg	35 g/10 min	35 g/10 min	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8100 psi	55.8 MPa	ASTM D638
Flexural Modulus	350000 psi	2410 MPa	ASTM D790
Flexural Strength (Yield)	13000 psi	89.6 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
-22°F (-30°C)	8.0 ft·lb/in	430 J/m	
73°F (23°C)	10 ft·lb/in	530 J/m	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	255 °F	124 °C	
264 Psi (1.8 Mpa), Unannealed	225 °F	107 °C	



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	225 °F	107 °C
Drying Time	4.0 to 8.0 hr	4.0 to 8.0 hr
Drying Time, Maximum	8.0 hr	8.0 hr
Rear Temperature	475 to 540 °F	246 to 282 °C
Middle Temperature	480 to 560 °F	249 to 293 °C
Front Temperature	500 to 570 °F	260 to 299 °C
Nozzle Temperature	520 to 570 °F	271 to 299 °C
Processing (Melt) Temp	480 to 560 °F	249 to 293 °C
Mold Temperature	140 to 200 °F	60 to 93 °C

Notes

These are typical property values not to be construed as specification limits.

