



Technical Data Sheet

Qr Resin QR-1220HF

Polycarbonate Alloy
LyondellBasell Industries
Engineering Plastics

Product Description

QR-1220HF is available with UV (V) or Release (R)

General

Additive	• Mold Release	• UV Stabilizer	
Features	• Good Adhesion	• Good Impact Resistance	• High Heat 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	4.0 g/10 min	4.0 g/10 min	
260°c/5.0 Kg	20 g/10 min	20 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 (73°f (23°c))	10 ft·lb/in	530 J/m	ASTM D256
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	265 °F	129 °C	
264 Psi (1.8 Mpa), Unannealed	235 °F	113 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	165 °F	74 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	440 to 490 °F	227 to 254 °C
Middle Temperature	470 to 520 °F	243 to 271 °C
Front Temperature	470 to 520 °F	243 to 271 °C
Nozzle Temperature	470 to 520 °F	243 to 271 °C
Processing (Melt) Temp	480 to 500 °F	249 to 260 °C
Mold Temperature	100 to 160 °F	38 to 71 °C

Notes

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