

Technical Data Sheet

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 | <ul style="list-style-type: none"> Mold Release UV Stabilizer |
| Features | <ul style="list-style-type: none"> Good Impact Resistance Good Mold Release High Heat Resistance Low Temperature Impact Resistance |
| Appearance | <ul style="list-style-type: none"> Black Colors Available Natural Color |
| Forms | <ul style="list-style-type: none"> 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 | |

Technical Data Sheet

Qr Resin QR-1235

Polycarbonate Alloy
LyondellBasell Industries
Engineering Plastics



| 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.