Technical Data Sheet

Qr Resin QR-1200-GF20

Polycarbonate + ABS
LyondellBasell Industries
Engineering Plastics

General			
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• General Purpose	• High Heat Resistance	
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.26 to 1.30	1.26 to 1.30 g/cm³	ASTM D792
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	> 10800 psi	> 74.5 MPa	ASTM D638
Flexural Modulus	> 870000 psi	> 6000 MPa	ASTM D790
Flexural Strength (Yield)	> 18900 psi	> 130 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°f (23°c))	> 1.4 ft·lb/in	> 75 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	> 266 °F	> 130 °C	
264 Psi (1.8 Mpa), Unannealed	> 240 °F	> 116 °C	

Additional Information	Nominal Value (English)	Nominal Value (SI)	Test Method
Glass Fiber Content	18 to 22 %	18 to 22 %	ASTM D5630

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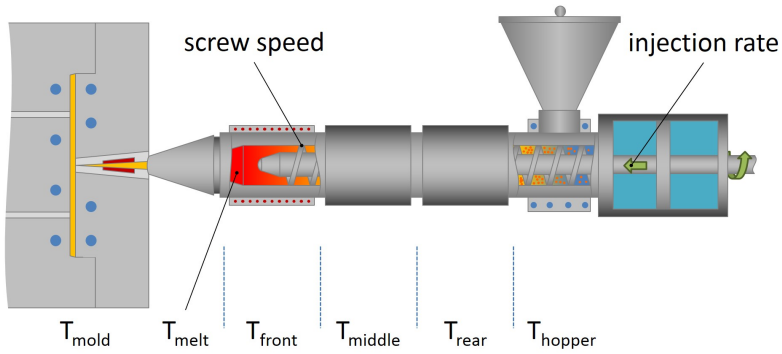

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	190 °F	88 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	480 to 500 °F	249 to 260 °C
Middle Temperature	490 to 510 °F	254 to 266 °C
Front Temperature	500 to 520 °F	260 to 271 °C
Nozzle Temperature	510 to 530 °F	266 to 277 °C
Processing (Melt) Temp	480 to 530 °F	249 to 277 °C
Mold Temperature	100 to 150 °F	38 to 66 °C

Notes

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