

Technical Data Sheet

Qr Resin QR-1220LG(V)

Polycarbonate + ABS
LyondellBasell Industries
Engineering Plastics

General			
Features	• Good Impact Resistance	• Low Gloss	• UV Resistant
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

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) (260°C/5.0 Kg)	20 g/10 min	20 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	7700 psi	53.1 MPa	ASTM D638
Tensile Elongation (Break)	80 %	80 %	ASTM D638
Flexural Modulus	320000 psi	2210 MPa	ASTM D790
Flexural Strength (Yield)	12200 psi	84.1 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	255 °F	124 °C	
264 Psi (1.8 Mpa), Unannealed	225 °F	107 °C	

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94

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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
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.