

Technical Data Sheet

# Qr Resin QR-1235-FR

Polycarbonate + ABS  
 LyondellBasell Industries  
 Engineering Plastics

**Product Description**

Available with UV (V) or Release (R).  
 Flame Packages Available (0.0625 in min. thickness): 94V-2, 94V-0, 94-5VA

**General**

Features	• Good Processability	• High Heat Resistance
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.18	1.18 g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 Kg)	35 g/10 min	35 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	9000 psi	62.1 MPa	ASTM D638
Flexural Modulus	385000 psi	2650 MPa	ASTM D790
Flexural Strength (Yield)	13800 psi	95.1 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	8.0 ft·lb/in	430 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	215 °F	102 °C	
264 Psi (1.8 Mpa), Unannealed	200 °F	93.3 °C	

Technical Data Sheet

# Qr Resin QR-1235-FR

Polycarbonate + ABS  
 LyondellBasell Industries  
 Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	200 °F	93 °C
Drying Time	3.0 to 6.0 hr	3.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	490 to 510 °F	254 to 266 °C
Middle Temperature	430 to 520 °F	221 to 271 °C
Front Temperature	460 to 540 °F	238 to 282 °C
Nozzle Temperature	530 to 570 °F	277 to 299 °C
Processing (Melt) Temp	480 to 540 °F	249 to 282 °C
Mold Temperature	140 to 180 °F	60 to 82 °C

**Notes**

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