Technical Data Sheet

Qr Resin QR-10120HF-GY25618

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

Product Description
QR-10120HF-GY25618 is an unfilled, UV and heat stabilized, impact modified, grey, PC/ASA compound that is suitable for injection molding.

General	
Appearance	• Grey
Forms	• Pellets
Processing Method	• Injection Molding

Physical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Density / Specific Gravity	1.17	1.17 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°c/5.0 Kg)	40 g/10 min	40 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	8500 psi	58.6 MPa	ASTM D638
Flexural Modulus	340000 psi	2340 MPa	ASTM D790
Flexural Strength (Yield)	14000 psi	96.5 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°f (23°c))	5.0 ft·lb/in	270 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	280 °F	138 °C	
264 Psi (1.8 Mpa), Unannealed	270 °F	132 °C	

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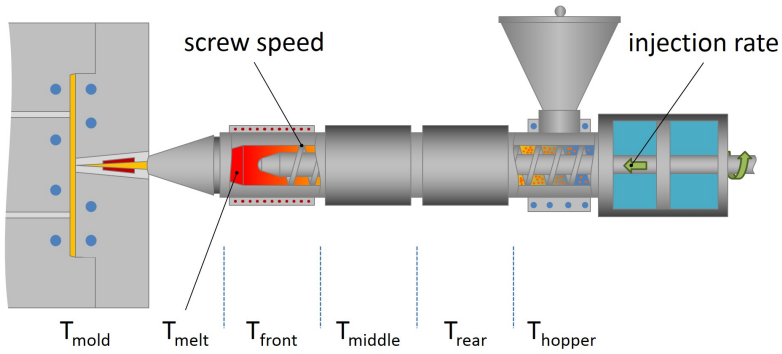

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	540 to 580 °F	282 to 304 °C
Middle Temperature	560 to 600 °F	293 to 316 °C
Front Temperature	580 to 620 °F	304 to 327 °C
Nozzle Temperature	570 to 610 °F	299 to 321 °C
Processing (Melt) Temp	580 to 620 °F	304 to 327 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

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