

**QR Resin QR-1012 R**

PC

LyondellBasell Industries

| Processing/Physical Characteristics | Value | Unit    | Test Standard |
|-------------------------------------|-------|---------|---------------|
| <b>ASTM Data</b>                    |       |         |               |
| Melt Flow Index, MFI                | 12    | g/10min | ASTM D 1238   |
| Temperature                         | 300   | °C      | -             |
| Load                                | 1.2   | kg      | -             |
| Mold Shrinkage, MD                  | 0.006 | mm/mm   | ASTM D 955    |

| Mechanical properties       | Value | Unit | Test Standard |
|-----------------------------|-------|------|---------------|
| <b>ASTM Data</b>            |       |      |               |
| Tensile Strength at Yield   | 62.1  | MPa  | ASTM D 638    |
| Flexural Modulus            | 2340  | MPa  | ASTM D 790    |
| Izod Impact notched, 1/8 in | 640   | J/m  | ASTM D 256    |

| Thermal properties | Value | Unit | Test Standard |
|--------------------|-------|------|---------------|
| <b>ASTM Data</b>   |       |      |               |
| DTUL @ 66 psi      | 138   | °C   | ASTM D 648    |
| DTUL @ 264 psi     | 132   | °C   | ASTM D 648    |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1200  | kg/m <sup>3</sup> | ASTM D 792    |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---------------------------------------------|-----------|------|---------------|
| Pre-drying - Temperature                    | 121       | °C   | -             |
| Pre-drying - Time                           | 2 - 4     | h    | -             |
| Melt temperature                            | 293 - 316 | °C   | -             |
| Mold temperature                            | 71 - 93   | °C   | -             |
| Zone 1                                      | 271 - 293 | °C   | -             |
| Zone 2                                      | 282 - 310 | °C   | -             |
| Zone 3                                      | 293 - 316 | °C   | -             |
| Nozzle temperature                          | 288 - 310 | °C   | -             |

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Natural Color

**Additives**

Release agent

**Special Characteristics**

High impact or impact modified

**Regional Availability**

North America