

QR Resin QR-1235P V

PC

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	35	g/10min	ASTM D 1238
Temperature	260	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	55.8	MPa	ASTM D 638
Flexural Modulus	2410	MPa	ASTM D 790
Izod Impact notched, 1/8 in	530	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	430	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	124	°C	ASTM D 648
DTUL @ 264 psi	107	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1140	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	107	°C	-
Pre-drying - Time	4 - 8	h	-
Melt temperature	249 - 293	°C	-
Mold temperature	60 - 93	°C	-
Zone 1	246 - 282	°C	-
Zone 2	249 - 293	°C	-
Zone 3	260 - 299	°C	-
Nozzle temperature	271 - 299	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Special Characteristics

Platable, High impact or impact modified, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Regional Availability

North America