

QR Resin QR-1220 R
(PC+ABS)

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	20	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	55.2	MPa	ASTM D 638
Flexural Modulus	2310	MPa	ASTM D 790
Izod Impact notched, 1/8 in	530	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	104	°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	74	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	249 - 260	°C	-
Mold temperature	38 - 71	°C	-
Zone 1	227 - 254	°C	-
Zone 2	243 - 271	°C	-
Zone 3	243 - 271	°C	-
Nozzle temperature	243 - 271	°C	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black, Natural Color

Additives

Release agent

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Regional Availability

North America