

**QR Resin QR-1220 V**  
(PC+ABS)

LyondellBasell Industries

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>20</b>	g/10min	ASTM D 1238
Temperature	<b>260</b>	°C	-
Load	<b>5</b>	kg	-
Mold Shrinkage, MD	<b>0.006</b>	mm/mm	ASTM D 955

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>55.2</b>	MPa	ASTM D 638
Flexural Modulus	<b>2310</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>530</b>	J/m	ASTM D 256

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
DTUL @ 264 psi	<b>104</b>	°C	ASTM D 648

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1140</b>	kg/m <sup>3</sup>	ASTM D 792

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>74</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Melt temperature	<b>249 - 260</b>	°C	-
Mold temperature	<b>38 - 71</b>	°C	-
Zone 1	<b>227 - 254</b>	°C	-
Zone 2	<b>243 - 271</b>	°C	-
Zone 3	<b>243 - 271</b>	°C	-
Nozzle temperature	<b>243 - 271</b>	°C	-

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Pellets, Black, Natural Color

**Special Characteristics**

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

**Regional Availability**

North America