

**QR Resin QR-1220LG(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>53.1</b>  | MPa         | ASTM D 638           |
| Elongation at Break          | <b>80</b>    | %           | ASTM D 638           |
| Flexural Modulus             | <b>2210</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>          |              |             |                      |
| UL 94 Flame rating        | <b>HB</b>    | -           | UL 94                |
| Thickness tested          | <b>1.5</b>   | mm          | -                    |
| DTUL @ 66 psi             | <b>124</b>   | °C          | ASTM D 648           |
| DTUL @ 264 psi            | <b>107</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

**Regional Availability**

North America