

QR Resin QR-1230 V
(PC+ABS)

LyondellBasell Industries

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|--------------|-------------|----------------------|
| ASTM Data | | | |
| Melt Flow Index, MFI | 30 | 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 | 430 | J/m | ASTM D 256 |

| Thermal properties | Value | Unit | Test Standard |
|---------------------------|--------------|-------------|----------------------|
| ASTM Data | | | |
| UL 94 Flame rating | HB | - | UL 94 |
| Thickness tested | 1.5 | mm | - |
| DTUL @ 66 psi | 121 | °C | ASTM D 648 |
| 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 | 107 | °C | - |
| Pre-drying - Time | 4 - 8 | h | - |
| Melt temperature | 249 - 293 | °C | - |
| Mold temperature | 60 - 82 | °C | - |
| Zone 1 | 246 - 277 | °C | - |
| Zone 2 | 249 - 282 | °C | - |
| Zone 3 | 254 - 288 | °C | - |
| Nozzle temperature | 260 - 288 | °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