

QR Resin QR-1235-FR R
(PC+ABS)

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	0.005	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	62.1	MPa	ASTM D 638
Flexural Modulus	2650	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	102	°C	ASTM D 648
DTUL @ 264 psi	93.3	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1180	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	93	°C	-
Pre-drying - Time	3 - 6	h	-
Melt temperature	249 - 282	°C	-
Mold temperature	60 - 82	°C	-
Zone 1	254 - 266	°C	-
Zone 2	221 - 271	°C	-
Zone 3	238 - 282	°C	-
Nozzle temperature	277 - 299	°C	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Natural Color

Additives

Release agent

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Regional Availability

North America