

**QR Resin QR-1000F-GFR20 R**

PC-GF20

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>15</b>	g/10min	ASTM D 1238
Temperature	<b>300</b>	°C	-
Load	<b>1.2</b>	kg	-
Mold Shrinkage, MD	<b>0.004</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>58.6</b>	MPa	ASTM D 638
Flexural Modulus	<b>5100</b>	MPa	ASTM D 790
Izod Impact unnotched, 1/8 in	<b>430</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 @ 66 psi	<b>143</b>	°C	ASTM D 648
DTUL @ 264 psi	<b>135</b>	°C	ASTM D 648

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1190</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>121</b>	°C	-
Pre-drying - Time	<b>3 - 6</b>	h	-
Melt temperature	<b>310 - 332</b>	°C	-
Mold temperature	<b>93 - 121</b>	°C	-
Zone 1	<b>288 - 316</b>	°C	-
Zone 2	<b>299 - 327</b>	°C	-
Zone 3	<b>310 - 332</b>	°C	-
Nozzle temperature	<b>310 - 327</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Natural Color

**Additives**

Release agent

**Special Characteristics**

Flame retardant, Heat stabilized or stable to heat

**Features**

Foamable

**Regional Availability**

North America