

QR Resin QR-1335IM(V)
(PC+PET)

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	0.009	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	58.6	MPa	ASTM D 638
Elongation at Break	130	%	ASTM D 638
Flexural Modulus	2070	MPa	ASTM D 790
Flexural Strength	79.3	MPa	ASTM D 790
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	124	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1210	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	260 - 277	°C	-
Mold temperature	66 - 88	°C	-
Zone 1	249 - 271	°C	-
Zone 2	254 - 277	°C	-
Zone 3	260 - 282	°C	-
Nozzle temperature	254 - 277	°C	-

Characteristics

Processing

Injection Molding

Chemical Resistance

General Chemical Resistance

Delivery form

Pellets, Black, Natural Color

Regional Availability

North America

Special Characteristics

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