

Technical Data Sheet



Qr Resin QR-1220HF

Polycarbonate Alloy
LyondellBasell Industries
Engineering Plastics

Product Description

QR-1220HF is available with UV (V) or Release (R)

General

Material Status	• Commercial: Active		
Availability	• North America		
Additive	• Mold Release	• UV Stabilizer	
Features	• Good Adhesion	• Good Impact Resistance	• High Heat Resistance
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.14	1.14 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
230°C/3.8 kg	4.0 g/10 min	4.0 g/10 min	
260°C/5.0 kg	20 g/10 min	20 g/10 min	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8100 psi	55.8 MPa	ASTM D638
Flexural Modulus	350000 psi	2410 MPa	ASTM D790
Flexural Strength (Yield)	13000 psi	89.6 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	10 ft·lb/in	530 J/m	ASTM D256
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	265 °F	129 °C	
264 psi (1.8 MPa), Unannealed	235 °F	113 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	165 °F	74 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	440 to 490 °F	227 to 254 °C
Middle Temperature	470 to 520 °F	243 to 271 °C
Front Temperature	470 to 520 °F	243 to 271 °C
Nozzle Temperature	470 to 520 °F	243 to 271 °C
Processing (Melt) Temp	480 to 500 °F	249 to 260 °C
Mold Temperature	100 to 160 °F	38 to 71 °C

Notes

These are typical property values not to be construed as specification limits.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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