

## Technical Data Sheet



## Qr Resin QR-1230

Polycarbonate + ABS  
LyondellBasell Industries  
Engineering Plastics

### Product Description

QR-1230 is available with UV (V) or Release (R).

### General

|                   |                                                 |                                                               |                 |
|-------------------|-------------------------------------------------|---------------------------------------------------------------|-----------------|
| Material Status   | • Commercial: Active                            |                                                               |                 |
| Availability      | • North America                                 |                                                               |                 |
| Additive          | • Mold Release                                  | • UV Stabilizer                                               |                 |
| Features          | • Good Impact Resistance<br>• Good Mold Release | • High Heat Resistance<br>• Low Temperature Impact Resistance |                 |
| Appearance        | • Black                                         | • Colors Available                                            | • Natural Color |
| Forms             | • Pellets                                       |                                                               |                 |
| Processing Method | • Injection Molding                             |                                                               |                 |

| Physical                          | Nominal Value (English) | Nominal Value (SI)     | Test Method |
|-----------------------------------|-------------------------|------------------------|-------------|
| Density / Specific Gravity        | 1.14                    | 1.14 g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR)         |                         |                        | ASTM D1238  |
| 230°C/3.8 kg                      | 6.0 g/10 min            | 6.0 g/10 min           |             |
| 260°C/5.0 kg                      | 30 g/10 min             | 30 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)) | 8.0 ft-lb/in            | 430 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     | 250 °F                  | 121 °C                 |             |
| 264 psi (1.8 MPa), Unannealed     | 220 °F                  | 104 °C                 |             |

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| Injection              | Nominal Value (English) | Nominal Value (SI) |
|------------------------|-------------------------|--------------------|
| Drying Temperature     | 225 °F                  | 107 °C             |
| Drying Time            | 4.0 to 8.0 hr           | 4.0 to 8.0 hr      |
| Drying Time, Maximum   | 8.0 hr                  | 8.0 hr             |
| Rear Temperature       | 475 to 530 °F           | 246 to 277 °C      |
| Middle Temperature     | 480 to 540 °F           | 249 to 282 °C      |
| Front Temperature      | 490 to 550 °F           | 254 to 288 °C      |
| Nozzle Temperature     | 500 to 550 °F           | 260 to 288 °C      |
| Processing (Melt) Temp | 480 to 560 °F           | 249 to 293 °C      |
| Mold Temperature       | 140 to 180 °F           | 60 to 82 °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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