

Technical Data Sheet

Qr Resin QR-1220P

Polycarbonate + ABS
LyondellBasell Industries
Engineering Plastics

General			
Features	• High Heat Resistance • High Impact Resistance	• Low Temperature Impact Resistance • Platable	
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.11	1.11 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 Kg)	20 g/10 min	20 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	7100 psi	49.0 MPa	ASTM D638
Tensile Elongation (Break)	150 %	150 %	ASTM D638
Flexural Modulus	300000 psi	2070 MPa	ASTM D790
Flexural Strength (Yield)	10000 psi	68.9 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 264 Psi (1.8 Mpa), Unannealed	195 °F	90.6 °C	ASTM D648

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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.