

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

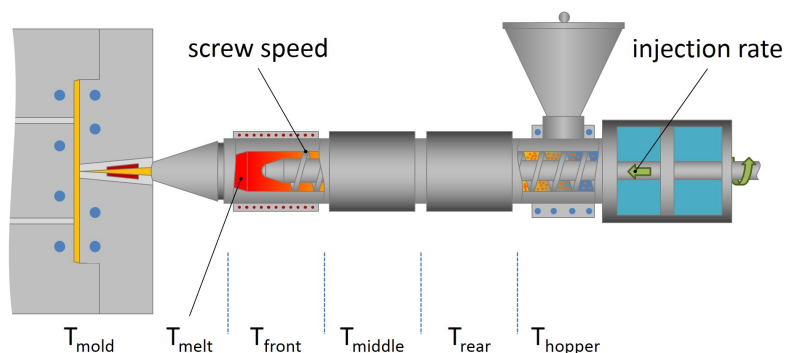
Additive	• Mold Release	• UV Stabilizer
Features	• Good Impact Resistance • Good Mold Release	• High Heat Resistance • Low Temperature Impact Resistance
Appearance	• Black	• Colors Available • Natural Color
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.14	1.14 g/cm ³	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.