

Technical Data Sheet

Qr Resin QR-10120HF-GY25618

Polycarbonate + ASA
LyondellBasell Industries
Engineering Plastics

Product Description

QR-10120HF-GY25618 is an unfilled, UV and heat stabilized, impact modified, grey, PC/ASA compound that is suitable for injection molding.

General

Appearance	• Grey
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.17	1.17 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 Kg)	40 g/10 min	40 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	8500 psi	58.6 MPa	ASTM D638
Flexural Modulus	340000 psi	2340 MPa	ASTM D790
Flexural Strength (Yield)	14000 psi	96.5 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	5.0 ft·lb/in	270 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	280 °F	138 °C	
264 Psi (1.8 Mpa), Unannealed	270 °F	132 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °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	540 to 580 °F	282 to 304 °C
Middle Temperature	560 to 600 °F	293 to 316 °C
Front Temperature	580 to 620 °F	304 to 327 °C
Nozzle Temperature	570 to 610 °F	299 to 321 °C
Processing (Melt) Temp	580 to 620 °F	304 to 327 °C
Mold Temperature	180 to 240 °F	82 to 116 °C

Notes

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