

Technical Data Sheet

Polyflam QR-1235FR-BK SF



Polycarbonate Alloy

Product Description

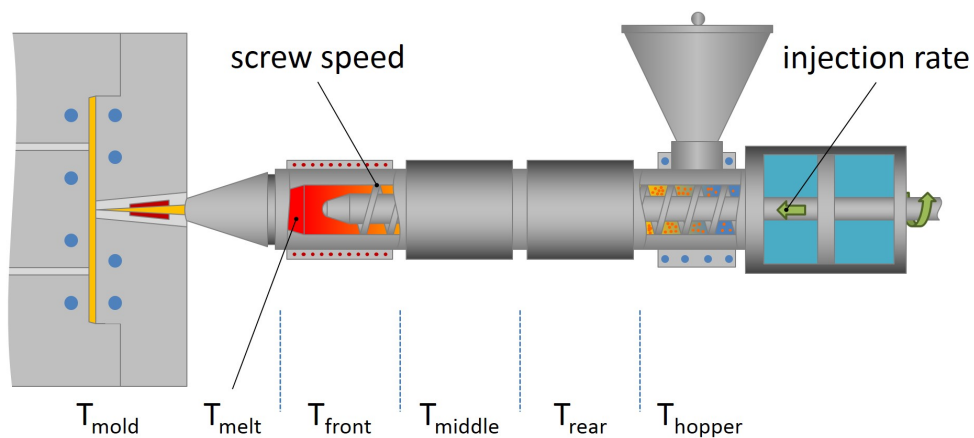
PC/ABS AlloyQR-1235 is available with UV (V) or Release (R).

Regulatory Status

For regulatory compliance information, see QR-1235FR-BK SF [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

Status	Discontinued
Availability	North America
Attribute	Good Impact Resistance; Good Mold Release; High Heat Resistance; Low Temperature Impact Resistance
Forms	Pellets
Appearance	Black; Colors Available; Natural Color
Additive	Mold Release; UV Stabilizer

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate			
(230 °C/3.8 kg)	10	g/10 min	ASTM D1238
(260 °C/5.0 kg)	35	g/10 min	ASTM D1238
Density - Specific Gravity	1.14	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	55.8	MPa	ASTM D638
Flexural Strength at Yield	89.6	MPa	ASTM D790
Flexural Modulus	2410	MPa	ASTM D790
Impact			
Notched Izod Impact			
(23 °C)	530	J/m	ASTM D256
(-30 °C)	430	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	107	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	124	°C	ASTM D648



Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 8.0	hr
Drying Temperature	107	°C
Nozzle Temperature	271 to 299	°C
Processing (Melt) Temp	249 to 293	°C
Front Temperature	260 to 299	°C
Middle Temperature	249 to 293	°C
Rear Temperature	246 to 282	°C
Mold Temperature	60 to 93	°C
Drying Time, Maximum	8	hr

Notes

These are typical property values not to be construed as specification limits. The typical values for this product may have been tested on a natural grade.

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.

Company Information

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

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