

QR Resin QR-1220HF

Polycarbonate Alloy

QTR, Inc.

Message:

QR-1220HF is available with UV (V) or Release (R)

General Information			
Additive	Mold Release		
	UV Stabilizer		
Features	Good Adhesion		
	Good Impact Resistance		
	High Heat Resistance		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
230°C/3.8 kg	4.0	g/10 min	
260°C/5.0 kg	20	g/10 min	
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.8	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength (Yield)	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	530	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	129	°C	
1.8 MPa, Unannealed	113	°C	
Injection	Nominal Value	Unit	
Drying Temperature	107	°C	
Drying Time	4.0 to 8.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	246 to 282	°C	

Middle Temperature	249 to 293	°C
Front Temperature	260 to 299	°C
Nozzle Temperature	271 to 299	°C
Processing (Melt) Temp	249 to 293	°C
Mold Temperature	60.0 to 93.3	°C

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