



Technical Data Sheet

Polyflam QR-1235FR-BK SF

Polycarbonate Alloy

Product Description

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

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