

Technical Data Sheet

Diamaloy QR-1220LG(V)-DX9BLK



Polycarbonate + ABS

Product Description

Diamaloy QR-1220LG(V)-DX9BLK is a Polycarbonate + ABS material and is typically used in Injection Molding applications. Features include: Good Impact Resistance, Low Gloss, and UV Resistant.

Processing Method	Injection Molding
Attribute	Good Impact Resistance; Low Gloss; UV Resistant
Forms	Pellets
Appearance	Black; Colors Available; Natural Color

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (260 °C/5.0 kg)	20	g/10 min	ASTM D1238
Melt Volume Flow Rate	27	cm ³ /10 min	ISO 1133
Density	1.13	g/cm ³	ISO 1183
Density - Specific Gravity	1.14	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	53.1	MPa	ASTM D638
Flexural Strength at Yield	84.1	MPa	ASTM D790
Tensile Stress at Yield	55.9	MPa	ISO 527-2
Flexural Modulus	2210	MPa	ASTM D790
Tensile Elongation at Break	80	%	ASTM D638
Tensile Modulus	2440	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched, (23 °C)	44	kJ/m ²	ISO 179
Unnotched Izod Impact Strength, (23 °C)	45	kJ/m ²	ISO 180
Notched Izod Impact, (23 °C)	530	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (1.80 MPa)	103	°C	ISO 75-2/A
Deflection Temperature Under Load Unannealed (264 psi)	107	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	124	°C	ASTM D648
UL Information			
Flame Rating, (1.5 mm)	HB		UL 94

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	74	°C
Nozzle Temperature	243 to 271	°C
Processing (Melt) Temp	249 to 260	°C
Front Temperature	243 to 271	°C
Middle Temperature	243 to 271	°C
Rear Temperature	227 to 254	°C
Mold Temperature	38 to 71	°C