



QR-4000-(S) Nylon/PPE Alloy

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Paintable Good Chemical Resistance Highly Ductile Good Dimensional Stability High Thermal Stability
Filler/Additive	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.09	
Melt Flow Rate, 280°C/ 2.16 kg	ASTM D1238	9	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.010	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	300,000	psi
Flex Strength @ Yield	ASTM D790	12,500	psi
Notched Izod Impact, 73°F	ASTM D256	1.5	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,000	psi
Tensile Elongation @ Break	ASTM D638	50	%
<i>-Thermal</i>			
Deflection Temp @ 66 psi	ASTM D648	310	°F

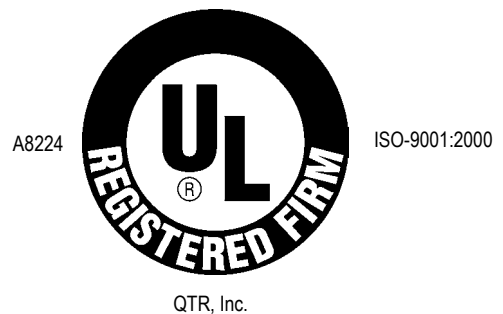
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-Injection Molding

Drying Conditions

Min 4 hours – Max 6 hours	200-225	°F
Cylinder		
Rear	500-570	°F
Middle	510-570	°F
Front	520-570	°F
Nozzle	530-570	°F
Mold		
Maximum	200	°F
Minimum	150	°F
Processing Temp	530-570	°F
Maximum Moisture Content	0.02	%

ISO9001:2000 Registered



The guidelines listed above are based on specimens at various thicknesses typical in manufacturing. These values are not intended to be used for specification purposes. These are recommended starting parameters. The equipment part design and tooling will influence final process parameters. The percent recycle is dependent on part design, wall thickness, process, and final performance requests.