



QR-4000-GF30

Nylon/PPE Alloy

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Appearance Features	<u>General Description</u>
	Custom Colors Available Good Chemical Resistance High Heat Resistance Good Stiffness
Filler/Additive	30% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.33	
Melt Flow Rate	ASTM D1238	N/A	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	1,240,000	psi
Flex Strength @ Yield	ASTM D790	34,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.8	ft.lbs/in
- Low Temp (-22°F)	ASTM D256	1.2	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	22,500	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	465	°F
Deflection Temp @ 66 psi	ASTM D648	490	°F

These test results are based on reliable procedures. Due to variable conditions and methods of processing, no guarantees or warranties are expressed or implied including the implied warranty of merchantability and fitness for particular use. The above information is not to be construed as a license or a recommendation to infringe on any patents.

-Injection Molding

Drying Conditions

Min 3 hours – Max 4 hours	225	°F
Cylinder		
Rear	510-580	°F
Middle	520-580	°F
Front	530-580	°F
Nozzle	540-580	°F
Mold		
Maximum	250	°F
Minimum	170	°F
Processing Temp	540-580	°F

ISO 9001:2000 Registered



QTR, Inc.

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.