



QR-4004 Nylon/PPE Alloy

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Appearance	<u>General Description</u>
Features	Available in Black
Filler/Additive	Paintable
	Chemical Resistant
	No

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.08	
Melt Flow Rate, 280°C/ 2.16 kg	ASTM D1238	4	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.01	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	3.5	ft.lbs/in
- Low Temp (°F)	ASTM D256	N/A	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	8,000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	255	°F
Deflection Temp @ 66 psi	ASTM D648	290	°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 4 hours – Max 6 hours	200-225	°F
Cylinder		
Rear	480-530	°F
Middle	490-540	°F
Front	500-550	°F
Nozzle	520-560	°F
Mold		
Maximum	200	°F
Minimum	150	°F
Processing Temp	510-550	°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.