

QR Resin QR-4004

Polyphenylene Ether + Nylon 66

QTR, Inc.

Message:

QR Resin QR-4004 is a Polyphenylene Ether + Nylon 66 (PPE+Nylon 66) product. It is available in North America. Primary characteristic: chemical resistant.

General Information			
Features	Good Chemical Resistance		
	Paintable		
Appearance	Black		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	55.2	MPa	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength (Yield)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	190	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	143	°C	
1.8 MPa, Unannealed	124	°C	
Injection	Nominal Value	Unit	
Drying Temperature	93.3 to 107	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	249 to 277	°C	
Middle Temperature	254 to 282	°C	
Front Temperature	260 to 288	°C	
Nozzle Temperature	271 to 293	°C	
Processing (Melt) Temp	266 to 288	°C	
Mold Temperature	65.6 to 93.3	°C	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT