



QR-4000-GF10

Nylon/PPE Alloy

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Appearance	<u>General Description</u> Black Color Custom Colors Available
Features	Good Chemical Resistance High Heat Resistance Good Stiffness
Filler/Additive	10% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.17	
Melt Flow Rate	ASTM D1238	N/A	g/10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.006	in/in
<i>-Mechanical</i>			
Flexural Modulus	ASTM D790	420,000	psi
Flexural Strength @ Yield	ASTM D790	22,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.3	ft.lbs/in
- Low Temp (-20°F)	ASTM D256	1.0	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	9,600	psi
Tensile Elongation(Strain)@ Break	ASTM D638	10	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	350	°F
Deflection Temp @ 66 psi	ASTM D648	450	°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 8 hours 225 °F

Cylinder

Rear 510-570 °F

Middle 520-570 °F

Front 530-570 °F

Nozzle 540-570 °F

Mold

Maximum 240 °F

Minimum 170 °F

Processing Temp 540-570 °F

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.