

**QR Resin QR-4165**  
(PPE+PS)

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>10</b>	g/10min	ASTM D 1238
Temperature	<b>280</b>	°C	-
Load	<b>2.16</b>	kg	-
Mold Shrinkage, MD	<b>0.006</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>62.1</b>	MPa	ASTM D 638
Flexural Modulus	<b>2480</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>160</b>	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	<b>96</b>	J/m	ASTM D 256
Temperature	<b>-29</b>	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	<b>V-1</b>	-	UL 94
Thickness tested	<b>1.6</b>	mm	-
DTUL @ 264 psi	<b>141</b>	°C	ASTM D 648
Melting Temperature	<b>121</b>	°C	ASTM D 3418

Other properties	Value	Unit	Test Standard
Density	<b>1080</b>	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>104 - 113</b>	°C	-
Pre-drying - Time	<b>4 - 6</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>227 - 249</b>	°C	-
Mold temperature	<b>66 - 93</b>	°C	-
Zone 1	<b>193 - 204</b>	°C	-
Zone 2	<b>216 - 227</b>	°C	-
Zone 3	<b>238 - 249</b>	°C	-
Nozzle temperature	<b>238 - 249</b>	°C	-

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Pellets, Black

**Special Characteristics**

Flame retardant

**Regional Availability**

North America