

QR Resin QR-4004
(PPE+PA66)

LyondellBasell Industries

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	4	g/10min	ASTM D 1238
Temperature	280	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.01	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	55.2	MPa	ASTM D 638
Flexural Modulus	2070	MPa	ASTM D 790
Izod Impact notched, 1/8 in	190	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	143	°C	ASTM D 648
DTUL @ 264 psi	124	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1080	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	93 - 107	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	266 - 288	°C	-
Mold temperature	66 - 93	°C	-
Zone 1	249 - 277	°C	-
Zone 2	254 - 282	°C	-
Zone 3	260 - 288	°C	-
Nozzle temperature	271 - 293	°C	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Chemical Resistance

General Chemical Resistance

Regional Availability

North America