

QR Resin QR-4000-GF30

Polyphenylene Ether + PS + PA
Engineering Plastics

General			
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Features	• Chemical Resistant	• Good Stiffness	• High Heat Resistance
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.33	1.33 g/cm ³	ASTM D792
Molding Shrinkage - Flow (0.125 in (3.18 mm))	6.0E-3 in/in	0.60 %	ASTM D955

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	22500 psi	155 MPa	ASTM D638
Flexural Modulus	1.24E+6 psi	8550 MPa	ASTM D790
Flexural Strength (Yield)	34000 psi	234 MPa	ASTM D790

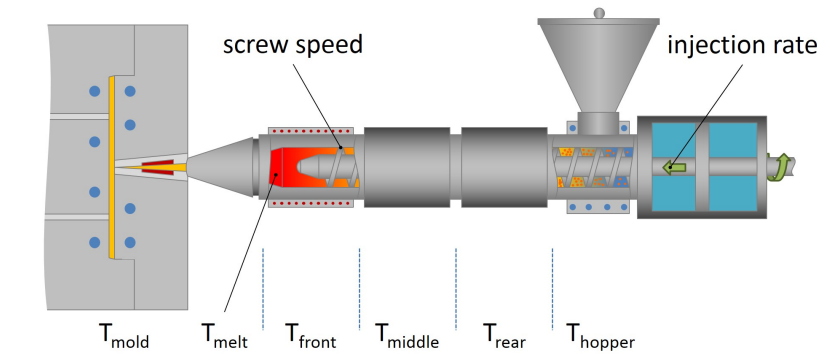
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
-22°F (-30°C)	1.2 ft·lb/in	64 J/m	
73°F (23°C)	1.8 ft·lb/in	96 J/m	

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	490 °F	254 °C	
264 psi (1.8 MPa), Unannealed	465 °F	241 °C	



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	225 °F	107 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Drying Time, Maximum	4.0 hr	4.0 hr
Rear Temperature	510 to 580 °F	266 to 304 °C
Middle Temperature	520 to 580 °F	271 to 304 °C
Front Temperature	530 to 580 °F	277 to 304 °C
Nozzle Temperature	540 to 580 °F	282 to 304 °C
Processing (Melt) Temp	540 to 580 °F	282 to 304 °C
Mold Temperature	170 to 250 °F	77 to 121 °C

Notes

These are typical property values not to be construed as specification limits.

