Technical Data Sheet

Qr Resin QR-4165

Polyphenylene Ether + PS
LyondellBasell Industries
Engineering Plastics

Product Description		
Flame Package available as: 94V-0 (0.24")/ 94V-1 (0.0625")		
General		
Features	• Flame Retardant	• Good Toughness
Appearance	• Black	• Grey
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.08	1.08 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°c/2.16 Kg)	10 g/10 min	10 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	9000 psi	62.1 MPa	ASTM D638
Flexural Modulus	360000 psi	2480 MPa	ASTM D790
Flexural Strength (Yield)	14000 psi	96.5 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256
-20°f (-29°c)	1.8 ft·lb/in	96 J/m	
73°f (23°c)	3.0 ft·lb/in	160 J/m	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	285 °F	141 °C	
264 Psi (1.8 Mpa), Unannealed	250 °F	121 °C	

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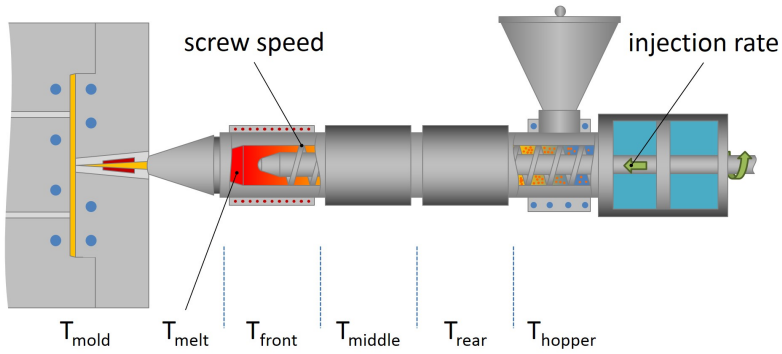

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	220 to 235 °F	104 to 113 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Suggested Max Moisture	0.02 %	0.02 %
Rear Temperature	380 to 400 °F	193 to 204 °C
Middle Temperature	420 to 440 °F	216 to 227 °C
Front Temperature	460 to 480 °F	238 to 249 °C
Nozzle Temperature	460 to 480 °F	238 to 249 °C
Processing (Melt) Temp	440 to 480 °F	227 to 249 °C
Mold Temperature	150 to 200 °F	66 to 93 °C

Notes

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