Technical Data Sheet

Qr Resin QR-5000-GF10

Polyether Imide
LyondellBasell Industries
Engineering Plastics

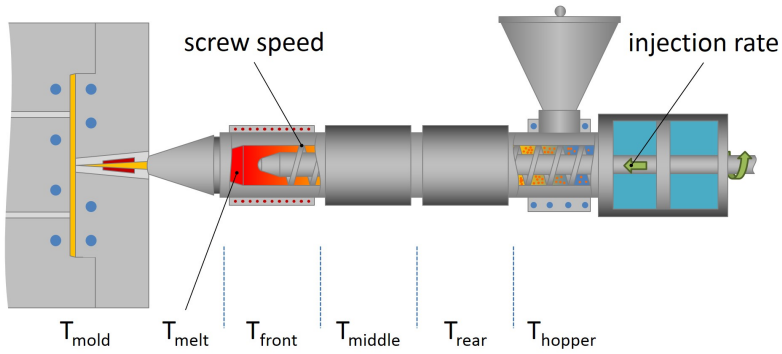
General			
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight		
Features	• Chemical Resistant • Good Dimensional Stability	• High Heat Resistance • High Rigidity	
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.33	1.33 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°c/6.6 Kg)	8.0 g/10 min	8.0 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	15000 psi	103 MPa	ASTM D638
Flexural Modulus	550000 psi	3790 MPa	ASTM D790
Flexural Strength (Yield)	21000 psi	145 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°f (23°c))	1.0 ft·lb/in	53 J/m	ASTM D256
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	402 °F	206 °C	
264 Psi (1.8 Mpa), Unannealed	396 °F	202 °C	

Technical Data Sheet

Qr Resin QR-5000-GF10

Polyether Imide
LyondellBasell Industries
Engineering Plastics



Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	300 °F	149 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	610 to 650 °F	321 to 343 °C
Middle Temperature	620 to 670 °F	327 to 354 °C
Front Temperature	650 to 700 °F	343 to 371 °C
Nozzle Temperature	640 to 680 °F	338 to 360 °C
Processing (Melt) Temp	650 to 700 °F	343 to 371 °C
Mold Temperature	270 to 320 °F	132 to 160 °C

Notes

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