Technical Data Sheet

Qr Resin QR-5000-GF20

Polyether Imide
LyondellBasell Industries
Engineering Plastics

General			
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• Chemical Resistant • High Heat Resistance	• High Stiffness • High Strength	
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.41	1.41 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°c/6.6 Kg)	7.0 g/10 min	7.0 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	19000 psi	131 MPa	ASTM D638
Flexural Modulus	790000 psi	5450 MPa	ASTM D790
Flexural Strength (Yield)	30000 psi	207 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°f (23°c))	1.2 ft·lb/in	64 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	409 °F	209 °C	
264 Psi (1.8 Mpa), Unannealed	406 °F	208 °C	

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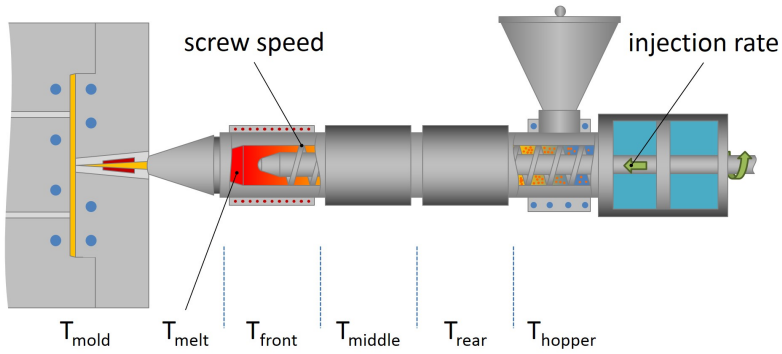

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	300 °F	149 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	650 to 690 °F	343 to 366 °C
Middle Temperature	670 to 710 °F	354 to 377 °C
Front Temperature	690 to 730 °F	366 to 388 °C
Nozzle Temperature	680 to 720 °F	360 to 382 °C
Processing (Melt) Temp	690 to 730 °F	366 to 388 °C
Mold Temperature	275 to 325 °F	135 to 163 °C

Notes

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