Technical Data Sheet

QR Resin QR-5020

Polyether Imide + PC
Engineering Plastics

Product Description		
QR-5020 is available with Release (R)		
General		
Additive	• Mold Release	
Features	• Chemical Resistant • Good Mold Release	• Good Toughness • High Heat Resistance
Appearance	• Colors Available	• Natural Color
Forms	• Pellets	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.27	1.27 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	20 g/10 min	20 g/10 min	ASTM D1238
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)	15000 psi	103 MPa	ASTM D638
Flexural Modulus	460000 psi	3170 MPa	ASTM D790
Flexural Strength (Yield)	20000 psi	138 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°F (23°C))	0.80 ft·lb/in	43 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	380 °F	193 °C	

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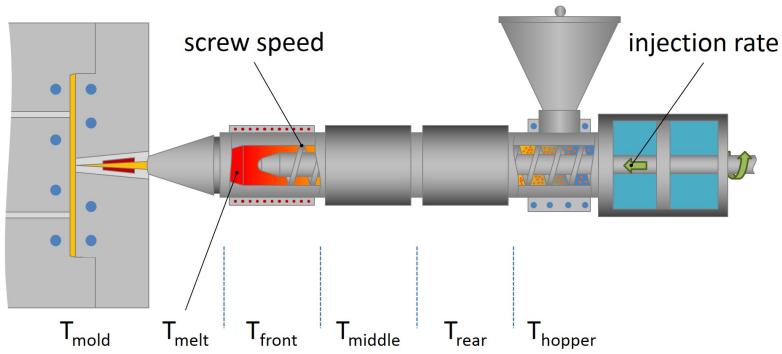

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	300 °F	149 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Drying Time, Maximum	6.0 hr	6.0 hr
Rear Temperature	610 to 650 °F	321 to 343 °C
Middle Temperature	620 to 670 °F	327 to 354 °C
Front Temperature	650 to 700 °F	343 to 371 °C
Nozzle 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.