

**Technical Data Sheet**

**Diamond QR-5020-BKBLK**



Polyetherimide + PC

**Product Description**

QR-5020 is available with Release (R)

<b>Attribute</b>	Good Chemical Resistance; Good Mold Release; Good Toughness; High Heat Resistance
<b>Forms</b>	Pellets
<b>Appearance</b>	Colors Available; Natural Color
<b>Additive</b>	Mold Release

<b>Typical Properties</b>	<b>Nominal Value</b>	<b>Units</b>	<b>Test Method</b>
<b>Physical</b>			
Melt Flow Rate, (337 °C/6.6 kg)	20	g/10 min	ASTM D1238
Density - Specific Gravity	1.27	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield	103	MPa	ASTM D638
Flexural Strength at Yield	138	MPa	ASTM D790
Flexural Modulus	3170	MPa	ASTM D790
<b>Impact</b>			
Notched Izod Impact, (23 °C)	43	J/m	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (264 psi)	193	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	206	°C	ASTM D648

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
Drying Time	4.0 to 6.0	hr
Drying Temperature	149	°C
Nozzle Temperature	338 to 360	°C
Processing (Melt) Temp	343 to 371	°C
Front Temperature	343 to 371	°C
Middle Temperature	327 to 354	°C
Rear Temperature	321 to 343	°C
Mold Temperature	132 to 160	°C
Drying Time, Maximum	6	hr