

Qr Resin QR-5000-GF30

Polyether Imide  
LyondellBasell Industries  
Engineering Plastics

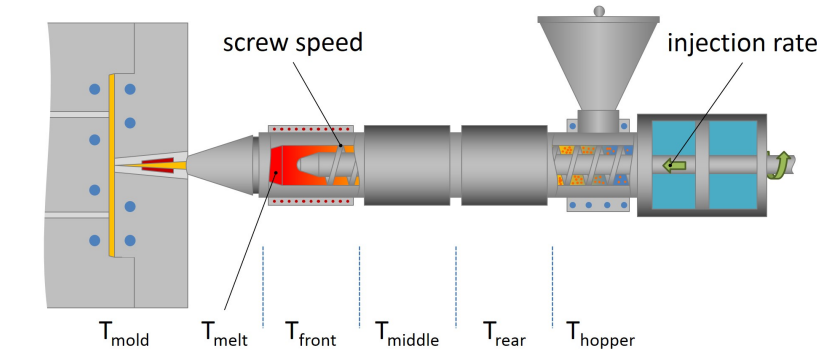
| General                |                                                                                 |  |  |
|------------------------|---------------------------------------------------------------------------------|--|--|
| Filler / Reinforcement | • Glass Fiber, 30% Filler by Weight                                             |  |  |
| Features               | • Chemical Resistant • High Stiffness<br>• High Heat Resistance • High Strength |  |  |
| Appearance             | • Colors Available • Natural Color                                              |  |  |
| Forms                  | • Pellets                                                                       |  |  |

| Physical                          | Nominal Value (English) | Nominal Value (SI) | Test Method |
|-----------------------------------|-------------------------|--------------------|-------------|
| Density / Specific Gravity        | 1.50                    | 1.50 g/cm³         | ASTM D792   |
| Mechanical                        | Nominal Value (English) | Nominal Value (SI) | Test Method |
| Tensile Strength (Yield)          | 22500 psi               | 155 MPa            | ASTM D638   |
| Flexural Modulus                  | 1.20E+6 psi             | 8270 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)) | 1.5 ft·lb/in            | 80 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     | 420 °F                  | 216 °C             |             |
| 264 Psi (1.8 Mpa), Unannealed     | 410 °F                  | 210 °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.

