



# QR-5000-GF20

## Glass Filled Polyetherimide

2301 St. Joseph Industrial Park Drive Evansville, IN 47720 Phone 812/429-0901 Fax 812/429-0905 www.customcompounding.com

Appearance	<u>General Description</u> Natural / Black in Color Custom Colors Available
Features	Good Chemical Resistance High Heat Resistance High Strength and Stiffness
Filler/Additive	20% Glass Fiber

Property	Method	Value	Unit
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.41	
Melt Flow Rate, 337°C / 6.6 kg	ASTM D1238	7	g / 10min
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.004	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	790,000	psi
Flex Strength @ Yield	ASTM D790	30,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.2	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	19,000	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	406	°F
Deflection Temp @ 66 psi	ASTM D648	409	°F

These test results are based on reliable procedures. Due to variable conditions and methods of processing, no guarantees or warranties are expressed or implied including the implied warranty of merchantability and fitness for particular use. The above information is not to be construed as a license or a recommendation to infringe on any patents.

***-Injection Molding***

**Drying Conditions**

Min 4 hours – Max 6 hours      300      °F

**Cylinder**

Rear                                      650-690      °F  
 Middle                                    670-710      °F  
 Front                                      690-730      °F  
 Nozzle                                    680-720      °F

**Mold**

Maximum                                325      °F  
 Minimum                                 275      °F

**Processing Temp**                    690-730      °F

**ISO9001:2000 Registered**



The guidelines listed above are based on specimens at various thicknesses typical in manufacturing. These values are not intended to be used for specification purposes. These are recommended starting parameters. The equipment part design and tooling will influence final process parameters. The percent recycle is dependent on part design, wall thickness, process, and final performance requests.