



QR-5000-GF30

Glass Filled Polyetherimide

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Appearance	<u>General Description</u> Natural Color Custom Colors Available
Features	Good Chemical Resistance High Heat Resistance High Strength and Stiffness
Filler/Additive	30% Glass Fiber

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.5	
Mold Shrink, Linear Flow (0.125)	ASTM D955	0.002-0.004	in/in
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	1,200,000	psi
Flex Strength @ Yield	ASTM D790	30,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.5	ft.lbs/in
Tensile Strength @ Yield	ASTM D638	22,500	psi
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	410	°F
Deflection Temp @ 66 psi	ASTM D648	420	°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

ISO9001:2000 Registered

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



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.