

Technical Data Sheet

Diamond QR-5020-BKBLK

Polyetherimide + PC

Product Description

QR-5020 is available with Release (R)

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

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

Injection Parameters	Nominal Value	Units
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