

ULTEM™ RESIN CRS5011

REGION ASIA

DESCRIPTION

Transparent, Enhanced flow Polyetherimide copolymer (Tg 225C) with enhanced chemical resistance to strong acids, bases, aromatics, and ketones. ECO conforming, UL94 V0 listing.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	99	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	2890	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	137	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3100	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	58	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2082	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	204	°C	ASTM D 648
Relative Temp Index, Elec	160	°C	UL 746B
Relative Temp Index, Mech w/impact	155	°C	UL 746B
Relative Temp Index, Mech w/o impact	160	°C	UL 746B
PHYSICAL			
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.7	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	11	g/10 min	ASTM D 1238
ELECTRICAL			
Dielectric Strength, in oil, 3.2 mm	17.9	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.2	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0021	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating	1.47	mm	UL 94
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	365 – 390	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Nozzle Temperature	360 – 380	°C	
Front - Zone 3 Temperature	365 – 390	°C	
Middle - Zone 2 Temperature	355 – 375	°C	
Rear - Zone 1 Temperature	345 – 365	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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