

ULTEM™ RESIN CRS5211R

REGION ASIA

DESCRIPTION

20% Glass fiber filled, enhanced flow Polyetherimide copolymer (Tg 225C) with internal mold release and enhanced chemical resistance to strong acids, bases, aromatics, and ketones. ECO conforming.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	137	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	144	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	6890	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	213	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	6890	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	74	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	459	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	218	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.45	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	5.5	g/10 min	ASTM D 1238
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	
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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