

ULTEM™ 4211 resin

Polyether Imide
SABIC Innovative Plastics

Message:
20% Glass fiber filled and PTFE filled, standard flow Polyetherimide (Tg 217C). ECO Conforming.

General Information			
UL YellowCard	E121562-524104		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	PTFE Lubricant		
Features	ECO Compliant		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	10	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	129	MPa	ASTM D638
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	7100	MPa	ASTM D790
Flexural Strength ⁴ (Break, 100 mm Span)	193	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Reverse Notch Izod Impact (3.20 mm)	440	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	212	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	10	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	338 to 360	°C	
Middle Temperature	343 to 366	°C	
Front Temperature	349 to 371	°C	
Nozzle Temperature	349 to 371	°C	
Processing (Melt) Temp	349 to 371	°C	
Mold Temperature	135 to 163	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	

Vent Depth	0.025 to 0.076	mm
NOTE		
1.	Type I, 5.0 mm/min	
2.	Type I, 5.0 mm/min	
3.	2.6 mm/min	
4.	2.6 mm/min	

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