

Witcom PEI 6G/3L1

Polyether Imide

Witcom Engineering Plastics B.V.

Message:

Witcom PEI 6G/3L1 is a polyetherimide (PEI) product that contains a 30% glass fiber reinforced material. It can be processed by injection molding and is available in Europe.
Features include:
flame retardant/rated flame
Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant (15%)		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.61	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.20 - 0.40	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	0.80	%	ISO 62
Equilibrium, 23°C, 50% RH	0.40	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	165	MPa	ISO 527-2
Tensile Strain (Break)	1.0 - 3.0	%	ISO 527-2
Flexural Modulus	8500	MPa	ISO 178
Flexural Stress	210	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	210	°C	ISO 75-2/A
CLTE - Flow	2.1E-5	cm/cm/°C	ISO 11359-2
RTI Imp (3.00 mm)	170	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Comparative Tracking Index	150	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	V-0		ISO 1210
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	

Drying Time	4.0 - 6.0	hr
Suggested Max Moisture	0.020	%
Processing (Melt) Temp	370 - 410	°C
Mold Temperature	140 - 180	°C
Injection Rate	Fast	
Back Pressure	0.00 - 1.00	MPa

Injection instructions

Screw speed: 0.1 - 0.2 m/sInjection pressure: Keep to a minimumHold pressure: Keep to a minimum

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