

ENVIROPLAS® ENV17-NC840

Polyether Imide

ENVIROPLAS®, Inc.

Message:

Injection Molding Grade, 20% Glass Bead Reinforced, Low Moisture Absorption, Excellent Processability, Excellent mechanical

Strength/Stiffness/Dimensional Stability

NC840 = To Be Assigned 5 Digit Number Indicating Natural, Black, or Custom Color.

The ENV17 Series Products Are Available With Mold Release and/or UV Stabilizer.

General Information			
Filler / Reinforcement	Glass beads, 20% filler by weight		
Features	Good dimensional stability		
	Low hygroscopicity		
	Rigidity, high		
	High strength		
	Workability, good		
Appearance	Black		
	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (24 hr)	0.40 - 0.60	%	ASTM D955
Water Absorption			ASTM D570
24 hr	0.15	%	ASTM D570
Balance, 50% RH	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	107	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	4640	MPa	ASTM D790
Flexural Strength	175	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	48	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.18 mm)	180	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831

Flow: -40 to 40°C	4.0E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	4.0E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	316 - 343	°C	
Middle Temperature	316 - 343	°C	
Front Temperature	316 - 343	°C	
Nozzle Temperature	304 - 338	°C	
Mold Temperature	93.3 - 121	°C	
Injection Rate	Fast		
Back Pressure	0.00 - 0.345	MPa	
Screw Speed	50 - 100	rpm	
Injection instructions			
Injection Pressure: LowShot Size to barrel Capacity: 50 - 80%			
NOTE			
1.	0.20 mm/min		

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