

ULTEM™ CRS5301 resin

Polyether Imide

SABIC Innovative Plastics

Message:

30% Glass fiber filled, standard flow Polyetherimide copolymer (Tg 225C) with enhanced chemical resistance to strong acids, bases, aromatics, and ketones. ECO conforming, UL94 V0 and 5VA listing.

General Information			
UL YellowCard	E121562-221120		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Acid Resistant		
	Base Resistant		
	Copolymer		
	ECO Compliant		
	Good Chemical Resistance		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Multi-Point Data	Specific Heat vs. Temperature (ASTM D3417)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	1.8	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.40	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	8960	MPa	ASTM D638
Tensile Strength ² (Break)	165	MPa	ASTM D638
Tensile Elongation ³ (Break)	3.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	8960	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	234	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	560	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	221	°C	ASTM D648
RTI Elec	105	°C	UL 746
RTI Imp	105	°C	UL 746
RTI Str	105	°C	UL 746
Electrical	Nominal Value	Test Method	
Arc Resistance ⁶	PLC 5	ASTM D495	
Comparative Tracking Index (CTI)	PLC 4	UL 746	

High Amp Arc Ignition (HAI)	PLC 4	UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 4	UL 746
Hot-wire Ignition (HWI)	PLC 2	UL 746
Flammability	Nominal Value	Test Method
	V-0	

Flame Rating (1.47 mm)	5VA	UL 94
Injection	Nominal Value	Unit
Drying Temperature	149	°C
Drying Time	4.0 to 6.0	hr
Drying Time, Maximum	24	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	343 to 366	°C
Middle Temperature	354 to 377	°C
Front Temperature	366 to 388	°C
Nozzle Temperature	360 to 382	°C
Processing (Melt) Temp	366 to 388	°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.	5.0 mm/min	
2.	Type I, 5.0 mm/min	
3.	Type I, 5.0 mm/min	
4.	2.6 mm/min	
5.	2.6 mm/min	
6.	Tungsten Electrode	

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