

ULTEM™ CRS5111 resin

Polyether Imide

SABIC Innovative Plastics

Message:

10% Glass fiber filled, enhanced flow Polyetherimide copolymer (Tg 225C) with enhanced chemical resistance to strong acids, bases, aromatics, and ketones. ECO conforming, UL94 V0 and 5 VA listing.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Features	Comply with ECO		
Agency Ratings	EU Eco		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	6.9	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	4760	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	117	MPa	ASTM D638
Fracture	112	MPa	ASTM D638
Tensile Elongation ³ (Break)	4.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	4900	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	193	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	37	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	360	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	216	°C	ASTM D648
RTI Elec	105	°C	UL 746
RTI Imp	105	°C	UL 746
RTI	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 3		UL 746
Hot-wire Ignition (HWI)	PLC 0		UL 746
Flammability	Nominal Value		Test Method

Flame Rating (1.47 mm)

5VA

UL 94

Injection	Nominal Value	Unit
Drying Temperature	149	°C
Drying Time	4.0 - 6.0	hr
Drying Time, Maximum	24	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 - 60	%
Rear Temperature	343 - 366	°C
Middle Temperature	354 - 377	°C
Front Temperature	366 - 388	°C
Nozzle Temperature	360 - 382	°C
Processing (Melt) Temp	366 - 388	°C
Mold Temperature	135 - 163	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm

NOTE

- | | |
|----|--------------------|
| 1. | 5.0 mm/min |
| 2. | Type 1, 5.0 mm/min |
| 3. | Type 1, 5.0 mm/min |
| 4. | 2.6 mm/min |
| 5. | 2.6 mm/min |
| 6. | Tungsten electrode |

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