

ULTEM™ CRS5311 resin

Polyether Imide

SABIC Innovative Plastics

Message:

30% 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 5VA listing.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Comply with ECO		
	Copolymer		
	Good chemical resistance		
	alkali resistance		
	acid resistance		
Agency Ratings	EU Eco		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.20 - 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			ASTM D256
Natural, Tints	160	J/m	ASTM D256
23°C	96	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	510	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	219	°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
	V-0	

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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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