

ULTEM™ 4211 resin

Polyether Imide

SABIC Innovative Plastics

Message:

20% Glass fiber filled, standard flow Polyetherimide (Tg 217C). ECO Conforming.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Comply with ECO		
Agency Ratings	EU Eco		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	10	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	129	MPa	ASTM D638
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	7100	MPa	ASTM D790
Flexural Strength ⁴ (Break, 100 mm Span)	193	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Reverse Notch Izod Impact (3.20 mm)	440	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	212	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	10	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	338 - 360	°C	
Middle Temperature	343 - 366	°C	
Front Temperature	349 - 371	°C	
Nozzle Temperature	349 - 371	°C	
Processing (Melt) Temp	349 - 371	°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.	Type 1, 5.0 mm/min
2.	Type 1, 5.0 mm/min
3.	2.6 mm/min
4.	2.6 mm/min

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Recommended distributors for this material

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