

Generic PI, TP

Thermoplastic Polyimide

Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.31 - 1.52	g/cm ³	ASTM D792
23°C	1.31 - 1.52	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (367°C/6.6 kg)	4.0 - 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.89 - 1.1	%	ASTM D955
Water Absorption			
23°C, 24 hr	0.60 - 0.62	%	ASTM D570
Saturated, 23°C	2.3	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	3390 - 3880	MPa	ASTM D638
23°C	3100 - 10500	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	103 - 156	MPa	ASTM D638
Yield, 23°C	101 - 147	MPa	ISO 527-2
Fracture, 23°C	96.0 - 156	MPa	ASTM D638
Fracture, 23°C	70.0 - 147	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	3.0 - 9.1	%	ASTM D638
Yield, 23°C	2.0 - 9.0	%	ISO 527-2
Fracture, 23°C	3.0 - 20	%	ASTM D638
Fracture, 23°C	2.0 - 19	%	ISO 527-2
Flexural Modulus			
23°C	2760 - 8960	MPa	ASTM D790
23°C	2850 - 3000	MPa	ISO 178
Flexural Stress			
23°C	150 - 200	MPa	ISO 178
Yield, 23°C	168 - 206	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	20 - 24	kJ/m ²	ISO 179
Notched Izod Impact			

23°C	42 - 87	J/m	ASTM D256
23°C	4.2 - 10	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	250 - 264	°C	ASTM D648
1.8 MPa, not annealed	233 - 256	°C	ASTM D648
1.8 MPa, not annealed	224 - 233	°C	ISO 75-2/A
Vicat Softening Temperature			
--	257 - 267	°C	ASTM D1525
--	248 - 263	°C	ISO 306
Linear thermal expansion coefficient			
Flow	1.6E-5 - 5.7E-5	cm/cm/°C	ASTM D696
Flow	1.6E-5 - 4.6E-5	cm/cm/°C	ASTM E831
Lateral	4.7E-5 - 5.3E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	4.4E+12 - 1.4E+16	ohms	ASTM D257
Volume Resistivity (23°C)	8.2E+13 - 1.4E+18	ohms·cm	ASTM D257
Dielectric Strength (23°C)	41 - 310	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Rear Temperature	370 - 385	°C	
Middle Temperature	383 - 398	°C	
Front Temperature	392 - 405	°C	
Nozzle Temperature	388 - 405	°C	
Processing (Melt) Temp	393 - 408	°C	
Mold Temperature	163 - 164	°C	
Screw Speed	55 - 85	rpm	
Injection instructions			

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