

ULTEM™ CRS5211R resin

Polyether Imide

SABIC Innovative Plastics

Message:

20% Glass fiber filled, enhanced flow Polyetherimide copolymer (Tg 225C) with internal mold release and enhanced chemical resistance to strong acids, bases, aromatics, and ketones. ECO conforming.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	demoulding		
Features	Comply with ECO		
	Copolymer		
	Good chemical resistance		
Agency Ratings	EU Eco		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	5.5	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	6890	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	138	MPa	ASTM D638
Fracture	145	MPa	ASTM D638
Tensile Elongation ³ (Break)	3.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	6890	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	214	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	75	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	460	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	218	°C	ASTM D648
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 |

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Recommended distributors for this material

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