

ULTEM™ CRS5201R resin

Polyether Imide

SABIC Innovative Plastics

Message:

20% Glass fiber filled, standard 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,20% Filler by Weight		
Additive	Mold Release		
Features	Acid Resistant		
	Base Resistant		
	Copolymer		
	ECO Compliant		
	Good Chemical Resistance		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	3.1	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	6890	MPa	ASTM D638
Tensile Strength ² (Break)	131	MPa	ASTM D638
Tensile Elongation ³ (Break)	5.0	%	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)	480	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 to 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	343 to 366	°C	
Middle Temperature	354 to 377	°C	

Front Temperature	366 to 388	°C
Nozzle Temperature	360 to 382	°C
Processing (Melt) Temp	366 to 388	°C
Mold Temperature	135 to 163	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE

- | | |
|----|--------------------|
| 1. | 5.0 mm/min |
| 2. | Type I, 5.0 mm/min |
| 3. | Type I, 5.0 mm/min |
| 4. | 2.6 mm/min |
| 5. | 2.6 mm/min |

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