

RTP VLF 82109

Polyether Imide

RTP Company

Message:

"Warning: The status of this material is 'Commercial: Limited Issue'
The data for this material has not been recently verified.
Please contact RTP Company for current information prior to specifying this grade."

General Information			
Filler / Reinforcement	Long glass fiber, 50% filler by weight		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.68	g/cm ³	ISO 1183
Moisture Content	0.020	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	17000	MPa	ISO 527-2
Tensile Stress	195	MPa	ISO 527-2
Tensile Strain (Yield)	1.0	%	ISO 527-2
Flexural Modulus	17000	MPa	ISO 178
Flexural Stress	290	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ¹	20	kJ/m ²	ISO 180/1A
Additional Information			
All data listed is for natural or black colored materials. Pigments can affect properties.Desiccant Type Dryer Required.Additional Processing Details: Use a reverse barrel profile. To maximize fiber length, the following injection barrel, screw, and tip designs should be followed. L/D ratio 16/1 - 22/1, Compression ratio 2:1, Flight depth 5 mm minimum, in feed section, Screw diameter 16.5 - 20 mm minimum, Compression section length 12 - 13 diameters, Check ring valve assembly - free flow type no restrictions, Nozzle orifice 6 mm diameter. Feed throat from hopper to machine must have sufficient opening to prevent bridging of long pellet composition.			
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	135	°C	
Drying Time - Desiccant Dryer	4.0	hr	
Dew Point	-30.0	°C	
Processing (Melt) Temp	350 - 380	°C	
Mold Temperature	120 - 160	°C	
Injection Pressure	70.0 - 125	MPa	
NOTE			

1. 4mm thickness

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