ULTEM™ RESIN CRS5011R

REGION ASIA

DESCRIPTION

Enhanced flow Polyetherimide copolymer (Tg 225C) with internal mold release and enhanced chemical resistance to strong acids, bases, aromatics and ketones. ECO Conforming.

INDUSTRY	SUB INDUSTRY
Automotive	Heavy Truck, Automotive Interiors, Bus, Automotive Under the Hood
Hydrocarbon and Energy	Fossil
Industrial	Defense
Mass Transportation	Aircraft Interiors, Rail

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	100	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	75	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	2900	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	138	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3100	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	100	MPa	ISO 527
Tensile Stress, break, 5 mm/min	85	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	8	%	ISO 527
Tensile Strain, break, 5 mm/min	50	%	ISO 527
Tensile Modulus, 1 mm/min	2900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	110	MPa	ISO 178
Flexural Modulus, 2 mm/min	2900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	2100	J/m	ASTM D 4812
Izod Impact, notched, 23°C	59	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2080	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	30	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m²	ISO 179/1eU

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
THERMAL			
Vicat Softening Temp, Rate B/50	227	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	213	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	201	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	216	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	204	°C	ASTM D 648
CTE, -40°C to 150°C, flow	5.5E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	5.5E-05	1/°C	ASTM E 831
Thermal Conductivity	0.31	W/m-°C	ASTM C177
CTE, 23°C to 150°C, flow	5.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	5.5E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	220	°C	ISO 306
Vicat Softening Temp, Rate B/50	215	°C	ISO 306
Vicat Softening Temp, Rate B/120	215	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	210	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	200	°C	ISO 75/Ae
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	208	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	198	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow	0.4 – 0.7	%	SABIC method
Mold Shrinkage, flow, 3.2 mm	0.4 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.4 – 0.7	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	11	g/10 min	ASTM D 1238
Density	1.28	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	1.2	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.2	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	20	cm³/10 min	ISO 1133
ELECTRICAL			
Dielectric Strength, in oil, 3.2 mm	18	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.2	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0021	-	ASTM D 150
Volume Resistivity	2.5E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	18.1	kV/mm	IEC 60243-1
Dissipation Factor, 50/60 Hz	0.0021	-	IEC 60250
Comparative Tracking Index	150	V	IEC 60112
Comparative Tracking Index, M	100	V	IEC 60112
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	365 – 390	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Nozzle Temperature	360 – 380	°C	
Front - Zone 3 Temperature	365 – 390	°C	
Middle - Zone 2 Temperature	355 – 375	°C	
Rear - Zone 1 Temperature	345 – 365	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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