

Ultem* Resin 4211

Americas: COMMERCIAL

20% Glass fiber filled and PTFE filled, standard flow Polyetherimide (Tg 217C). ECO Conforming.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	129	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	193	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	7100	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, Reverse Notched, 3.2 mm	437	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	212	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.48	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	10.3	g/10 min	ASTM D 1238

Source GMD, last updated:01/13/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	135	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	10	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 370	°C
Nozzle Temperature	350 - 370	°C
Front - Zone 3 Temperature	350 - 370	°C
Middle - Zone 2 Temperature	345 - 365	°C
Rear - Zone 1 Temperature	340 - 360	°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

Source GMD, last updated:01/13/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.

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