

## Ultem\* Resin CRS5011R

Americas: COMMERCIAL

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

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
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	Value	Unit	Standard
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/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
THERMAL	Value	Unit	Standard
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 C 177
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
<b>PHYSICAL</b>	<b>Value</b>	<b>Unit</b>	<b>Standard</b>
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2)	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/cm <sup>3</sup>	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	cm <sup>3</sup> /10 min	ISO 1133
<b>ELECTRICAL</b>	<b>Value</b>	<b>Unit</b>	<b>Standard</b>
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

Source GMD, last updated:11/06/2003

## Processing

Parameter	Value	Unit
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
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

Source GMD, last updated:11/06/2003

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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