



ULTEM™ Resin 4211
Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1310	kgf/cm ²	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	1960	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	72400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, Reverse Notched, 3.2 mm	44	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	212	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.48	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	10.3	g/10 min	ASTM D 1238



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PROCESSING PARAMETERS	TYPICAL 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