



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.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1010	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	760	kgf/cm ²	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	29500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1400	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	31600	kgf/cm ²	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	214	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	212	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	305	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A



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IMPACT			
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
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 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





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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.4 - 0.7	%	SABIC Method
Mold Shrinkage, flow, 3.2 mm (5)	0.4 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	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 ³	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 ³ /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	0.002	-	IEC 60250
Comparative Tracking Index	150	V	IEC 60112
Comparative Tracking Index, M	100	V	IEC 60112





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PROCESSING PARAMETERS	TYPICAL 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

