

Electrafil® PEI 1311

 Techmer Polymer Modifiers - *Polyetherimide*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	20000	psi	ASTM D638
Tensile Elongation (Break)	2.1	%	ASTM D638

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	275	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	650 to 710	°F
Middle Temperature	660 to 720	°F
Front Temperature	670 to 720	°F
Nozzle Temperature	680 to 735	°F
Processing (Melt) Temp	660 to 730	°F
Mold Temperature	250 to 325	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

