

Plaslube® PEI 4000

 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
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber
Additive	<ul style="list-style-type: none"> Lubricant
Features	<ul style="list-style-type: none"> Lubricated
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.61		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.39E+6	psi	ASTM D638
Tensile Strength (Yield)	20000	psi	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Flexural Modulus	780000	psi	ASTM D790
Flexural Strength	26000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	275	°F
Drying Time	4.0	hr
Rear Temperature	650 to 710	°F
Middle Temperature	660 to 720	°F
Front Temperature	670 to 730	°F
Nozzle Temperature	680 to 740	°F
Processing (Melt) Temp	660 to 750	°F
Mold Temperature	250 to 325	°F
Injection Rate	Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

