



Wednesday, August 30, 2023

PRL PEI-G10

Polymer Resources Ltd. - Polyether Imide

Units

English ▼

Action

Legend ([Open](#))



General Information

General		
Material Status	• Commercial: Active	
Availability	• North America	
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight	
Additive	• Flame Retardant	
Features	• Flame Retardant • High Heat Resistance	
RoHS Compliance	• RoHS Compliant	
UL File Number	• E113219	
Forms	• Pellets	
Processing Method	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	5.0 to 22	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.21	%	ASTM D570
Water Absorption (Equilibrium, 73°F)	1.2	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (0.125 in)	660000	psi	ASTM D638
Tensile Strength (Yield, 0.125 in)	16500	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	16500	psi	ASTM D638
Tensile Elongation (Break, 0.125 in)	6.0	%	ASTM D638
Flexural Modulus (0.125 in)	740000	psi	ASTM D790
Flexural Strength (0.125 in)	27000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (73°F, 0.125 in)	9.0	ft·lb/in	ASTM D4812
Reverse Notch Izod Impact (73°F, 0.125 in)	7.5	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	114		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	405	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	400	°F	ASTM D648
Vicat Softening Temperature	430	°F	ASTM D1525 ²
CLTE - Flow (-4 to 302°F)	1.8E-5	in/in/°F	ASTM E831
RTI Elec			UL 746B
0.06 in	221	°F	
0.12 in	221	°F	
RTI Imp			UL 746B
0.06 in	221	°F	
0.12 in	221	°F	
RTI Str			UL 746B
0.06 in	221	°F	
0.12 in	221	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+17	ohms·cm	ASTM D257
Dielectric Strength (0.0625 in, in Oil)	690	V/mil	ASTM D149

Dielectric Constant (1 kHz)	3.50	ASTM D150
Dissipation Factor		ASTM D150
1 kHz	1.4E-3	
2.00 GHz	4.6E-3	
Flammability	Nominal Value	Unit Test Method
Flame Rating		UL 94
0.06 in, ALL	V-0	
0.12 in, ALL	V-0	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	290 to 300	°F
Drying Time	4.0 to 6.0	hr
Drying Time, Maximum	24	hr
Rear Temperature	630 to 750	°F
Middle Temperature	640 to 750	°F
Front Temperature	650 to 750	°F
Processing (Melt) Temp	640 to 750	°F
Mold Temperature	225 to 350	°F

Notes

¹ Typical properties: these are not to be construed as specifications.
² Rate B (120°C/h), Loading 2 (50 N)

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