

**Product Texts**

High flow Polyetherimide (Tg 217°C) with low level of transparent mold release. Very low outgassing and plateout for optimally reduced need for mold cleaning. May be beneficial for automotive lighting applications where highly metallized, reflective surfaces are required. Haze onset temperature of 204°C (SABIC IP method).

| Processing/Physical Characteristics | Value | Unit                   | Test Standard |
|-------------------------------------|-------|------------------------|---------------|
| <b>ISO Data</b>                     |       |                        |               |
| Melt volume-flow rate, MVR          | 25    | cm <sup>3</sup> /10min | ISO 1133      |
| Temperature                         | 360   | °C                     | -             |
| Load                                | 5     | kg                     | -             |

| Mechanical properties                    | Value | Unit              | Test Standard |
|--|-------|-------------------|---------------|
| <b>ISO Data</b>                          |       |                   |               |
| Tensile Modulus                          | 3200  | MPa               | ISO 527       |
| Yield stress                             | 105   | MPa               | ISO 527       |
| Yield strain                             | 6     | %                 | ISO 527       |
| Stress at break                          | 85    | MPa               | ISO 527       |
| Strain at break                          | 50    | %                 | ISO 527       |
| Flexural modulus                         | 3300  | MPa               | ISO 178       |
| Charpy notched impact strength, +23°C    | 3     | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Izod impact strength, +23°C, 4mm         | N     | kJ/m <sup>2</sup> | ISO 180/1U    |
| Izod impact strength, -30°C, 4mm         | N     | kJ/m <sup>2</sup> | ISO 180/1U    |
| Izod notched impact strength, +23°C, 4mm | 5     | kJ/m <sup>2</sup> | ISO 180/1A    |
| Izod notched impact strength, -30°C, 4mm | 5     | kJ/m <sup>2</sup> | ISO 180/1A    |

| Thermal properties                       | Value | Unit | Test Standard |
|--|-------|------|---------------|
| <b>ISO Data</b>                          |       |      |               |
| Temp. of deflection under load, 1.80 MPa | 193   | °C   | ISO 75-1/-2   |
| Vicat softening temperature, A           | 215   | °C   | ISO 306       |
| Vicat softening temperature, B           | 211   | °C   | ISO 306       |
| Vicat softening temperature, 120°C/h 50N | 212   | °C   | ISO 306       |

| Other properties    | Value | Unit              | Test Standard  |
|---------------------|-------|-------------------|----------------|
| Water absorption    | 1.25  | %                 | Sim. to ISO 62 |
| Humidity absorption | 0.7   | %                 | Sim. to ISO 62 |
| Density             | 1270  | kg/m <sup>3</sup> | ISO 1183       |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 150       | °C   | -             |
| Pre-drying - Time                           | 4 - 6     | h    | -             |
| Processing humidity                         | ≤0.02     | %    | -             |
| Melt temperature                            | 350 - 400 | °C   | -             |
| Mold temperature                            | 135 - 165 | °C   | -             |
| Zone 1                                      | 330 - 400 | °C   | -             |
| Zone 2                                      | 340 - 400 | °C   | -             |
| Zone 3                                      | 345 - 400 | °C   | -             |
| Screw speed                                 | 40 - 70   | rpm  | -             |
| Back pressure                               | 0.3 - 0.7 | MPa  | -             |

**Characteristics**

**Processing**

Injection Molding

**Applications**

Automotive

**Special Characteristics**

Transparent

**Regional Availability**

Europe