

**ULTEM™ Resin 4211 - Americas**

(PEI+PTFE)-GF20

Saudi Basic Industries Corporation (SABIC)

**Product Texts**

20% Glass fiber filled and PTFE filled, standard flow Polyetherimide (Tg 217C). ECO Conforming.

UL Yellow Card Link [E121562-524104](https://www.ul.com/yellowcard/E121562-524104)

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	10.3	g/10min	ASTM D 1238
Temperature	337	°C	-
Load	6.6	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Yield	129	MPa	ASTM D 638
Elongation at Break	3	%	ASTM D 638

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-

Other properties	Value	Unit	Test Standard
Density	1480	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	135	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	350 - 370	°C	-
Mold temperature	135 - 165	°C	-
Zone 1	340 - 360	°C	-
Zone 2	345 - 365	°C	-
Zone 3	350 - 370	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America