

**ULTEM™ Resin 4211 - Asia**

(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.ulprospector.com/ulcard/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**

Asia Pacific