



Phone: (517) 295-4196 Fax: (517) 295-4918

## Technical Data Sheet

### LCA® PEI 2200 Type Black

### 20% Glass Filled Polyetherimide

Typical Compound Properties	Value / Measure		Test Methods
<b>Physical Properties</b>			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 300 / 1.2	5 - 22 g/10 min		ASTM D-1238
Density	1.42 g/cm <sup>3</sup>	1.42 g/cm <sup>3</sup>	ASTM D-792
Linear Mold Shrinkage	0.20 - 0.50 in/in	0.20 - 0.50 mm/mm	ASTM D-955
<b>Mechanical Properties</b>			
Izod Impact - Notched	1.29 ft-lb/in (kJ/m)	69 J/m	ASTM D-256
Tensile Strength @ Yield	20,015 psi (Mpa)	138 MPa	ASTM D-638
Tensile Strength @ Break	20,015 psi (Mpa)	138 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	4 %	4 %	ASTM D-638
Flexural Strength @ Yield	32,053 psi (Mpa)	221 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus	990,600 psi (Mpa)	6,835 MPa	ASTM D-790
<b>Thermal Properties</b>			
DTUL @ 66 psi (455 kPa)	410 Deg. F	210 Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	404 Deg. F	207 Deg. C	ASTM D-648
Vicat Softening Temperature	430 Deg. F	221 Deg. C	ASTM D-1525

All tests are performed on dry as molded ASTM (ISO) test bars.

#### General Product Type Information

Flame Rating (3.0 mm)	UL94	V-0 @ 1.50mm V-0 @ 3.00mm
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The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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#### Typical Processing Conditions

Process Variable	Description	Values	
<b>Temperatures</b>		<b>F</b>	<b>C</b>
	Barrel	Rear	332 - 399
		Center	338 - 399
		Front	343 - 399
		Nozzle	343 - 399
		Melt Temp	338 - 399
		Mold Temp	107 - 177

#### Drying

Type	Dehumidifier
Temperature	143 - 149°C
Time	4 - 6 hours

#### Special Requirements

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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