



Phone: (248) 486-1449 Fax: (248) 486-7966

## Technical Data Sheet

### LCA® PEI CRS5001 Type TYPE

#### Transparent, Standard Flow Polyetherimide Copolymer

Typical Compound Properties	Value / Measure		Test Methods
<b>Physical Properties</b>			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 337 / 6.6	3.5 g/10 min	3.5 dg/min	ASTM D-1238 - (ISO 1133)
Density	1.28 g/cm <sup>3</sup>	1.28 g/cm <sup>3</sup>	ASTM D-792 (ISO 1183)
Linear Mold Shrinkage	0.4 in/in	0.4 mm/mm	ASTM D-955
<b>Mechanical Properties</b>			
Izod Impact - Notched	1.19 ft-lb/in (kJ/m <sup>2</sup> )	64 J/m	ASTM D-256 (ISO 108/1A)
Tensile Strength @ Yield	14,504 psi (Mpa)	100 MPa	ASTM D-638 (ISO 527 - 1,2)
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638 (ISO 527 - 1,2)
Tensile Elongation @ Yield	%	0 %	ASTM D-638 (ISO 527 - 1,2)
Tensile Elongation @ Break	60 %	60 %	ASTM D-638 (ISO 527 - 1,2)
Flexural Strength @ Yield	20,015 psi (Mpa)	138 MPa	ASTM D-790 (ISO 178)
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Modulus	449,617 psi (Mpa)	3,102 MPa	ASTM D-790 (ISO 178)
<b>Thermal Properties</b>			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648 (ISO 75 - 1,2)
@ 264 psi (1820 kPa)	405 Deg. F	207 Deg. C	ASTM D-648 (ISO 75 - 1,2)
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525 (ISO 306)

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

#### General Product Type Information

Flame Rating (1.50mm)	V-0	UL 94
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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> Barrel	Rear	<b>F</b> 343 - 366
	Center	354 - 377
	Front	366 - 388
	Nozzle	360 - 382
	Melt Temp	366 - 388
	Mold Temperature	135 - 163
		<b>C</b>
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<b>Drying</b>		
Type		Dehumidifier
Temperature		149°C
Time		4 - 6 hours
Suggested Moisture		0.02%
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<b>Special Requirements</b>		
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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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