



CP10-N0002
Polyether Imide

Good Flow

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Physical	Method	Typical Value	Units
Melt Flow @ 337°C / 6.6 kg	ASTM D1238	19	g/10 min
Specific Gravity	ASTM D792	1.27	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.006	in/in

Impact

Notched Izod Impact (.125 in) 73°F	ASTM D256	0.6	ft-lbs/in
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Mechanical

Tensile Strength @ Yield	ASTM D638	15,700	psi
Tensile Elongation @ Break	ASTM D638	57	%
Flexural Strength	ASTM D790	23,800	psi
Flexural Modulus	ASTM D790	505,000	psi

Thermal

Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	403	°F
.250 in, 264 psi	ASTM D648	388	°F

Flammability

Flame Rating (.0625")	UL 94	V-0
Flame Rating (.100")	UL 94	5VA

Information provided is based on typical values from reliable procedures. Values are based on natural or black materials unless otherwise noted. No guarantees or warranties of any kind are expressed or implied. Users are responsible for determining the suitability of the product for their intended application.

Recommended Processing Parameters

Drying Temperature	300°F
Drying Time	4.0 - 6.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	620 - 740 °F
Middle Temperature	630 - 740 °F
Front Temperature	640 - 740 °F
Nozzle Temperature	640 - 740 °F
Processing (Melt) Temperature	650 - 740 °F
Mold Temperature	270 - 330 °F

CPPT recommended processing parameters are meant to serve as guidelines only and are not intended to be used for specification purposes. Conditions should be adjusted to optimize material performance with the equipment part design and tooling.