CP10-N0009

Polyether Imide

Standard flow PEI copolymer w/ enhanced chemical resistance

CrossPoint Polymer Technologies

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Physical	Method	Typical Value	Units
Melt Flow @ 337°C / 6.6 kg	ASTM D1238	4.5	g/10 min
Specific Gravity	ASTM D792	1.28	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.006	in/in
Impact			
Notched Izod Impact (.125 in) 73°F	ASTM D256	1.0	ft-lbs/in
Mechanical			
Tensile Strength @ Yield	ASTM D638	14,200	psi
Tensile Elongation @ Break	ASTM D638	58	%
Flexural Strength @ Yield	ASTM D790	19,500	psi
Flexural Modulus	ASTM D790	445,000	psi
Thermal			
Deflection Temperature Under Load .25 in, 264 psi	ASTM D648	403	°F
Flammability			
Flame Rating (.0625")		V-0	

Recommended Processing Parameters

Drying Temperature	300°F
Drying Time	4.0 - 6.0 Hours
Suggested Maximum Moisture Content	0.02%
Rear Temperature	640 - 680 °F
Middle Temperature	660 - 700 °F
Front Temperature	680 - 720 °F
Nozzle Temperature	670 - 710 °F
Processing (Melt) Temperature	680 - 720 °F
Mold Temperature	280 - 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.