EnTor 130GF

PEI

Product Description
Molding Grade PEI

General Properties	
Appearance	Black
Processing Methods	Injection Molding, Profile Extrusion
Applications	Automotive, Electrical, Metallizable

Mechanical Properties	Test Method	English Units		S.I. Units	
Tensile Strength @ Yield	ASTM D638	24,000	psi	166	MPa
Tensile Elongation at Break	ASTM D638	3	%	3	%
Flexural Modulus	ASTM D790	1,250,000	psi	8,621	MPa
Notched Izod Impact (73°F)	ASTM D256	1.0	ft-lb/in	53	J/m
CLTE	ASTM E831	3.00E-10	in/(in, °F)	5.40E-10	mm/(mm, °C)

Physical Properties		Test Method	English Units		S.I. Units	
Specific Gravity		ASTM D792	1.51	sp gr	1.51	sp gr
Melt Flow	337/6.6	ASTM D1238	5.0	g/10min	5.0	g/10min
Mold Shrink - Flow: 0.126 in (3.20 mm)		ASTM D955	0.004	in/in	0.004	mm/mm
Filler Content			30.0	%	30.0	%
Flame Rating	0.125	UL 94	5VA		5VA	
Flame Rating	0.062	UL 94	V-0		V-0	

Thermal Properties	Test Method	English Units		S.I. Units	
Heat Deflection Temperature @ 264 psi	ASTM D648	410	°F	210	°C

Injection Molding	Value	
Drying Temperature	300	°F
Drying Time	4.0 - 6.0	hrs
Maximum Drying Time	8.0	hrs
Suggested Maximum Moisture	0.02	%
Rear Barrel Temperatures	630 - 750	°F
Middle Barrel Temperatures	640 - 750	°F
Front Barrel Temperatures	650 - 750	°F
Nozzle Temperature	650 - 750	°F
Melt (processing) Temperatures	660 - 750	°F
Mold Temperatures	275 - 325	°F