Wednesday, May 13, 2026

Plaslube® PEI 4000

Techmer Polymer Modifiers - *Polyetherimide*

Units SI

Action **Legend (Open)**

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• Lubricant
Features	• Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.61	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.40	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	9580	MPa	ASTM D638
Tensile Strength (Yield)	138	MPa	ASTM D638
Tensile Elongation (Break)	2.2	%	ASTM D638
Flexural Modulus	5380	MPa	ASTM D790
Flexural Strength	179	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	64	J/m	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	135	°C
Drying Time	4.0	hr
Rear Temperature	343 to 377	°C
Middle Temperature	349 to 382	°C
Front Temperature	354 to 388	°C
Nozzle Temperature	360 to 393	°C
Processing (Melt) Temp	349 to 399	°C
Mold Temperature	121 to 163	°C
Injection Rate	Moderate	
Back Pressure	0.172 to 0.517	MPa
Screw Speed	Moderate	

Notes

[1] Typical properties: these are not to be construed as specifications.

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