ULTEM™ RESIN 9075

REGION ASIA

DESCRIPTION

High flow Polyetherimide blend. Meets FAR 25.853 and OSU 65/65 with low toxicity, smoke, and flame evolution. ECO Conforming.

INDUSTRY	SUB INDUSTRY
Industrial	Defense, Additive Manufacturing, Additive Materials
Mass Transportation	Aircraft Interiors, Rail

TYPICAL PROPERTY VALUES

Revision 20190925

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	96	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	85	%	ASTM D 638
Tensile Modulus, 5 mm/min	3300	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	144	MPa	ASTM D 790
Flexural Stress, brk, 2.6 mm/min, 100 mm span	141	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3240	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	69	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2082	J/m	ASTM D 256
Gardner, 23°C	35	J	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	188	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 295°C/6.6 kgf	2.4	g/10 min	ASTM D 1238
Halogen Content	0	%	SABIC method
FLAME CHARACTERISTICS			
FAA Flammability, FAR 25.853 A/B	SECT A-1	-	FAR 25.853
OSU total heat release (2 minute test)	10	kW-min/m²	FAR 25.853
Vertical Burn a (60s) passes at	1	sec	FAR 25.853
Vertical Burn b (12s) passes at	0	sec	FAR 25.853
INJECTION MOLDING			
Drying Temperature	135 – 145	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	10	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 370	°C	
Nozzle Temperature	350 – 370	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	350 – 370	°C	
Middle - Zone 2 Temperature	345 – 365	°C	
Rear - Zone 1 Temperature	340 – 360	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	
PROFILE EXTRUSION			
Drying Temperature	130 – 140	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	295 – 330	°C	
Barrel - Zone 1 Temperature	280 – 300	°C	
Barrel - Zone 2 Temperature	295 – 320	°C	
Barrel - Zone 3 Temperature	305 – 330	°C	
Barrel - Zone 4 Temperature	310 – 335	°C	
Hopper Temperature	80 – 100	°C	
Adapter Temperature	285 – 335	°C	
Die Temperature	275 – 330	°C	
Calibrator Temperature	140 – 170	°C	
Calibrator 2 Temperature	90 – 130	°C	

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