ULTEM™ RESIN D9065

REGION ASIA

DESCRIPTION

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

TYPICAL PROPERTY VALUES

Revision 20190828

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	88	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	88	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	3100	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	124	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3100	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	149	J/m	ASTM D 256
Izod Impact, notched, -30°C	96	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2029	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	67	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	58	J	ASTM D 3763
PHYSICAL			
Specific Gravity	1.32	-	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, 337°C/6.6 kgf	15.6	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
OSU total heat release (2 minute test)	10	kW-min/m²	FAR 25.853
OSU peak heat release rate (5 minute test)	50	kW/m²	FAR 25.853
INJECTION MOLDING			
Drying Temperature	135	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	340 – 360	°C	
Nozzle Temperature	330 – 355	°C	
Front - Zone 3 Temperature	340 – 360	°C	
Middle - Zone 2 Temperature	325 – 350	°C	
Rear - Zone 1 Temperature	315 – 340	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vent Depth	0.025 – 0.076	mm	

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