ULTEM™ RESIN DU242

REGION AMERICAS

DESCRIPTION

Enhanced low temperature impact, high flow Polyetherimide blend. ECO Conforming.

INDUSTRY	SUB INDUSTRY
Consumer	Sport/Leisure, Personal Accessory, Personal Recreation
Industrial	Textile

TYPICAL PROPERTY VALUES

Revision 20181122

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	74	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	67	%	ASTM D 638
Tensile Modulus, 5 mm/min	2580	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	112	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2510	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	181	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2045	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	160	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.24	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	30	g/10 min	ASTM D 1238
INJECTION MOLDING			
Drying Temperature	135	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	12	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	330 – 355	°C	
Nozzle Temperature	325 – 350	°C	
Front - Zone 3 Temperature	330 – 355	°C	
Middle - Zone 2 Temperature	320 – 345	°C	
Rear - Zone 1 Temperature	310 – 330	°C	
Mold Temperature	95 – 135	°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	

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