ULTEM™ RESIN 1110

REGION AMERICAS

DESCRIPTION

Enhanced flow Polyetherimide (Tg 217C). ECO Conforming.

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	110	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	70	%	ASTM D 638
Tensile Modulus, 5 mm/min	3720	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	165	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3720	MPa	ASTM D 790
IMPACT			
Izod Impact, Reverse Notched, 3.2 mm	1602	J/m	ASTM D 256
Gardner, 23°C	23	J	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	198	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.36	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	16	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.75	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 400	°C	
Nozzle Temperature	345 – 400	°C	
Front - Zone 3 Temperature	345 – 400	°C	
Middle - Zone 2 Temperature	340 – 400	°C	
Rear - Zone 1 Temperature	330 – 400	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

DISCLAIMER