

Ultem* Resin DH1004

Americas: COMMERCIAL

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	95	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	90	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	85	%	ASTM D 638
Tensile Modulus, 5 mm/min	2900	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	140	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3000	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	97	MPa	ISO 527
Tensile Stress, break, 50 mm/min	80	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	80	%	ISO 527
Flexural Stress, yield, 2 mm/min	136	MPa	ISO 178
Flexural Modulus, 2 mm/min	2800	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	70	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	3300	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	88	J	ASTM D 3763
Instrumented Impact Total Energy, 0°C	99	J	ASTM D 3763
Instrumented Impact Total Energy, -20°C	88	J	ASTM D 3763
Instrumented Impact Ductility, 23°C	100	%	ASTM D 3763
Instrumented Impact Ductility, 0°C	100	%	ASTM D 3763
Instrumented Impact Ductility, -20°C	90	%	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy Impact, notched, 23°C	11	kJ/m ²	ISO 179/2C
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	214	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	204	°C	ASTM D 648
CTE, -20°C to 150°C, flow	5.6E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, xflow	5.5E-05	1/°C	ASTM E 831
Thermal Conductivity	0.19	W/m-°C	ASTM C 177
CTE, 23°C to 150°C, flow	5.E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	5.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate A/50	219	°C	ISO 306
Vicat Softening Temp, Rate B/50	212	°C	ISO 306
Vicat Softening Temp, Rate B/120	212	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	205	°C	ISO 75/Be

HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Ae
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	10	g/10 min	ASTM D 1238
Density	1.28	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 360°C/5.0 kg	14	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS	Value	Unit	Standard
Oxygen Index (LOI)	46	%	ASTM D 2863
NBS Smoke Density, Flaming, Ds 4 min	0.7	-	ASTM E 662

Source GMD, last updated:10/16/2008

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	6 - 8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	355 - 390	°C
Nozzle Temperature	345 - 390	°C
Front - Zone 3 Temperature	345 - 390	°C
Middle - Zone 2 Temperature	335 - 390	°C
Rear - Zone 1 Temperature	330 - 390	°C
Mold Temperature	130 - 160	°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

Source GMD, last updated:10/16/2008

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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