

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.

TYPICAL PROPERTY VALUES

Revision 20180905

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/m ²	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	
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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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