

ULTEM™ RESIN 1000E

REGION ASIA

DESCRIPTION

Transparent, standard flow Polyetherimide (Tg 217C) with internal mold release. ECO Conforming. US FDA and EU Food Contact compliant, NSF 51 Listing. Effective June, 2007 this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HU1000E.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES TYPICAL VALUES UNITS TEST METHODS MECHANICAL Tensile Strain, July, Type I, 5 mm/min 10 MS ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 17 ASTM D 638 ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 60 \$ ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3380 MPa ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 MPa ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 MPa ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 MPa ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 MPa ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 MPa ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 MPa ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 July ASTM D 638 Tensile Strain, July, Type I, 5 mm/min 3580 July ASTM D 648 Tensile Strain, July, Type I, 5 mm/min 218 Yuly ASTM D 648 </th <th></th> <th></th> <th></th> <th></th>				
Tensile Stress, yld, Type 1, 5 mm/min 10 MPB ASTM D638 Tensile Strain, yld, Type 1, 5 mm/min 7 4 ASTM D638 Tensile Modulus, 5 mm/min 380 MPB ASTM D638 Flexural Stress, yld, 2,6 mm/min, 100 mm span 165 MPB ASTM D790 Bloward Modulus, 2,6 mm/min, 100 mm span 310 MPB ASTM D4190 BMPACT Very Card Modulus, 2,6 mm/min, 100 mm span 3135 Jm ASTM D4182 Bod Impact, unnotched, 23°C 3335 Jm MPB ASTM D4812 Brown Louis	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Tensile Strain, jul., Type I, 5 mm/min 7 8 ASTM D 638 Tensile Strain, jul., Type I, 5 mm/min 60 % ASTM D 638 Tensile Strain, jul., Type I, 5 mm/min 60 MPa ASTM D 638 Tensile Strain, jul., Type I, 5 mm/min 165 MPa ASTM D 790 Elexural Modulus, 2.6 mm/min, 100 mm span 310 MPa ASTM D 790 IPlexural Modulus, 2.6 mm/min, 100 mm span 310 MPa ASTM D 790 INPACT US MPa ASTM D 4812 ASTM D 4812 Lood Impact, unnotched, 23°C 33 Jl/m ASTM D 4812 ASTM D 4812 Lood Impact, notched, 23°C 32 Jl/m ASTM D 4812 ASTM D 4812 Lood Impact, unnotched, 23°C 28 C ASTM D 4812 ASTM D 4812 HOT, 43.8 MPa, 64 mm, unannealed 210 2 ASTM D 484 ASTM D 484 LOTE, 20°C to 150°C, flow 5.88-05 Jl/c ASTM D 484 ASTM D 484 CE, 20°C to 150°C, flow 2 2 ASTM D 792 ASTM D 792 Well Case Plance 1<	MECHANICAL			
Tensile Strain, brik, Type I, 5 mm/min 60 % ASTM D 638 Tensile Strain, brik, Type I, 5 mm/min 3580 MPa ASTM D 638 Flexural Stress, Vid. 2.6 mm/min, 100 mm span 1650 MPa ASTM D 790 IBexural Modulus, 2.6 mm/min, 100 mm span 3510 WPa ASTM D 790 IMPACT V V V Isod Impact, unnotched, 23°C 1335 Jm ASTM D 648 Isod Impact, unnotched, 23°C 218 C ASTM D 1525 IMPACT V ASTM D 1525 ASTM D 648 HERMAL 218 °C ASTM D 648 HDT, 1.32 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 HDT, 1.32 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 TEE, 20°C to 150°C, flow 54605 10°C ASTM D 648 TEE, 20°C to 150°C, flow 52600 40°C ASTM D 792 Weber Absorption, 24 hours 0.2 \$MM Pa ASTM D 792 Weber Absorption, 24 hours 0.5 30°C ASTM D 173 Poisson's Ratio<	Tensile Stress, yld, Type I, 5 mm/min	110	MPa	ASTM D 638
Tensile Modulus, 5 mm/min 3580 MPa ASTM D 638 Flexural Stress, yid, 2.6 mm/min, 100 mm span 165 MPa ASTM D 790 Flexural Modulus, 2.6 mm/min, 100 mm span 3510 MPa ASTM D 790 IMPACT USATION TO MINION TO MIN	Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span 165 MPa ASTM D 790 Ikward Modulus, 2.6 mm/min, 100 mm span 3510 MPa ASTM D 790 Ikward Tournethed, 23°C 335 I/m ASTM D 4812 Tool olimpact, unotched, 23°C 33 I/m ASTM D 4812 Total Softening Temp, Rate 8/50 38 °C ASTM D 1525 HDT, 4.5 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 HDT, 1.52 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 HDT, 1.52 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 TETE, 20°C to 150°C, filow 5.58€05 11°C ASTM D 648 TETE, 20°C to 150°C, filow 5.58€05 11°C ASTM D 670 Tempal Conductivity 22 Varian ASTM D 79 Water Absorption, equilibrium, 23C 1.27 ASTM D 70 Mater Absorption, equilibrium, 23C 2.5 3 3 ASTM D 70 Mater Mostrytion, equilibrium, 23C 2.5 3 3 ASTM D 70 Mostrytion, Robert Salva 4 4 <td>Tensile Strain, brk, Type I, 5 mm/min</td> <td>60</td> <td>%</td> <td>ASTM D 638</td>	Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Reward Modulus, 2.6 mm/min, 100 mm span 3510 MPa ATM D 790 IMPACT Very March (1974) ASTM D 4812 ASTM D 582 ASTM D 684	Tensile Modulus, 5 mm/min	3580	MPa	ASTM D 638
IMPACT Izod Impact, unnotched, 23°C 1335 J/m ASTM D 4812 Izod Impact, notched, 23°C 53 J/m ASTM D 256 THEKRUL V V ASTM D 1525 HDT, 0.45 MPa, 6.4 mm, unannealed 210 ° ASTM D 548 HDT, 1.62 MPa, 6.4 mm, unannealed 210 ° ASTM D 648 HDT, 1.62 MPa, 6.4 mm, unannealed 210 ° ASTM D 648 CTE, 20°C to 150°C, flow 558.05 J° ASTM E 831 CTE, 20°C to 150°C, flow 546.05 J° ASTM E 831 Thermal Conductivity 22 Wm² ASTM E 831 The 20°C to 150°C, flow 1.27 ASTM E 831 ASTM E 931 Web 21 4.28 4.29 ASTM E 931 ASTM E 931 The 20°C to 150°C, flow 1.27 4.29 ASTM E 931 ASTM E 931 Web 21 4.27 4.29 ASTM D 92 ASTM E 931 ASTM D 92 Web 21 4.27 4.29 4.29 ASTM D 932 ASTM D 932 ASTM D 932 ASTM D 932	Flexural Stress, yld, 2.6 mm/min, 100 mm span	165	MPa	ASTM D 790
ized Impact, unnotched, 23°C1335JmASTM D 4812total Impact, notched, 23°C33JmASTM D 256THERMALVicat Softening Temp, Rate By50218°CASTM D 1525BDT, 0.45 MPa, 6.4 mm, unannealed210°CASTM D 648HDT, 0.45 MPa, 6.4 mm, unannealed210°CASTM D 648CTE, 20°C to 150°C, flow5.860.51°CASTM E 831CTE, 20°C to 150°C, xflow5.460.51°CASTM E 31Thermal Conductivity2.23.7ASTM C 77WEEL SOUTH TO THE WIST TO THE WIS	Flexural Modulus, 2.6 mm/min, 100 mm span	3510	MPa	ASTM D 790
Ize di mact, notched, 23°C 51 19 ASTM D 256 THERMAL Vicat Softening Temp, Rate B/50 218 °C ASTM D 1525 HDT, 0.45 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 HDT, 0.45 MPa, 6.4 mm, unannealed 20 °C ASTM D 648 CTE, 20°C to 150°C, flow 3540 G 1°C ASTM E 81 CTE, 20°C to 150°C, flow 3540 G 3570 G ASTM E 31 CTE, 20°C to 150°C, flow 3540 G 3570 G ASTM E 31 CTE, 20°C to 150°C, flow 3540 G 3570 G ASTM E 31 CTE, 20°C to 150°C, flow 3540 G 3570 G ASTM E 31 CTE, 20°C to 150°C, flow 3540 G 3570 G ASTM E 31 ASTM E 31 3540 G 3570 G	IMPACT			
THERMAL Vicat Softening Temp, Rate B/SO 218 °C ASTM D 1525 HDT, 0.45 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 HDT, 1.82 MPa, 6.4 mm, unannealed 201 °C ASTM D 648 CTE, -20°C to 150°C, flow 5.58-05 1/°C ASTM E 831 CTE, -20°C to 150°C, flow 5.46-05 1/°C ASTM C 831 Thermal Conductivity 0.2 Wim°c ASTM C 77 PMYSICA V ASTM D 792 Water Absorption, 24 hours 2.2 % ASTM D 570 Water Absorption, equilibrium, 23C 1.25 % ASTM D 570 Water Absorption, equilibrium, 23C 1.2 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 0.5 - 0.7 % ASTM D 1238 Poisson's Ratio 3 3.6 3 (1) min ASTM D 1238 Poisson's Ratio 4 6 ASTM D 1238 1 Poisson's Ratio 3 0.1 0.1 0.1 0.1 0.1 0.1 0.1 0.1 0	Izod Impact, unnotched, 23°C	1335	J/m	ASTM D 4812
Vicial Softening Temp, Rate B/50 218 °C ASTM D 1525 HDT, 0.45 MPa, 6.4 mm, unannealed 210 °C ASTM D 648 HDT, 1.82 MPa, 6.4 mm, unannealed 201 °C ASTM D 648 CTE, 20°C to 150°C, flow 5.58.05 1/°C ASTM E 831 CTE, 20°C to 150°C, flow 5.40.05 1/°C ASTM C 831 CTE, 20°C to 150°C, flow 5.40.05 1/°C ASTM C 831 CTE, 20°C to 150°C, flow 5.40.00 1/°C ASTM C 831 Thermal Conductivity 2.22 Win"C ASTM C 77 PVESTCA V ASTM D 792 Water Absorption, 24 hours 2.25 \$ ASTM D 570 Water Absorption, equilibrium, 23C 1.25 \$ ASTM D 570 Mold Shrinkage, flow, 3.2 mm 1.2 \$ ASTM D 1238 Poisson's Ratio 1.2 \$ \$ ASTM D 1238 Poisson's Ratio 1.2 \$ \$ ASTM D 1238 Poisson's Ratio 1.2 \$ \$ ASTM D 1238 Poisson's Ratio	Izod Impact, notched, 23°C	53	J/m	ASTM D 256
HDT, 0.45 MPa, 6.4 mm, unannealed 201 °C ASTM D 648 HDT, 1.82 MPa, 6.4 mm, unannealed 201 °C ASTM D 648 CTE, 20°C to 150°C, flow 558-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 548-05 I/°C ASTM E 81 CTE, 20°C to 150°C, flow 648-05 I/°C ASTM E 81 CTE, 20°C to 150°C AS	THERMAL			
HDT. 1.82 MPa, 6.4 mm, unannealed 201 °C ASTM D 648 CTE, -20°C to 150°C, filow 5.58.05 1/°C ASTM E 831 CTE, -20°C to 150°C, xiflow 5.46.05 1/°C ASTM E 831 Thermal Conductivity 2.22 Wrm.°C ASTM D 772 PHYSICAL Specific Gravity 1.27 × ASTM D 792 Water Absorption, 24 hours 0.25 % ASTM D 792 Water Absorption, equilibrium, 23C 1.25 % ASTM D 792 Mold Shrinkage, flow, 3.2 mm 0.5 – 0.7 % ASTM D 193 Poisson's Ratio 0.5 – 0.7 % ASTM D 1238 Poisson's Ratio 40 – 150 % ASTM D 1238 EXTRUSION BLOW MOLDING Lyright Temperature 4 – 6 hrs Drying Time (Cumulative) 4 – 6 hrs Maximum Moisture Content 201 – 0.02 % Melt Temperature (Parison) 30 – 355 °C Barel - Zone 1 Temperature 30 – 355 °C Barel	Vicat Softening Temp, Rate B/50	218	°C	ASTM D 1525
CE20°Cto 150°C, flow 5.58-05 1,°C ASTME 831 CE20°Cto 150°C, xflow 5.400 5.400 1,°C ASTME 831 CE20°Cto 150°C, xflow 5.400 5.400 1,°C ASTME 831 CE20°Cto 150°C, xflow 5.400 1,°C ASTME 177 CE20°C	HDT, 0.45 MPa, 6.4 mm, unannealed	210	°C	ASTM D 648
CFE, 20°C to 150°C, xflow 5.4E.05 1,°C ASTM E 831 Thermal Conductivity 0.22 ym°C ASTM C177 PHYSICAL Specific Gravity 1.27 2 ASTM D 792 Water Absorption, 24 hours 0.25 % ASTM D 570 Water Absorption, equilibrium, 23C 1.25 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 0.5 − 0.7 % ASTM D 1238 Poisson's Ratio 1.2 2 y10 min ASTM D 1238 Physical Structure (1904) 1.2 2 y10 min ASTM D 1238 ASTM D 1238 EXTRUSION BLOW MOLDING 2 STM E 132 ASTM E 132 TEMP S 132 ASTM E 132 TEMP S 132	HDT, 1.82 MPa, 6.4 mm, unannealed	201	°C	ASTM D 648
Thermal Conductivity 0.22 W/m.°C ASM C177 PHYSICAL Specific Gravity 1.27 3 ASTM D 792 Water Absorption, 24 hours 0.25 % ASTM D 570 Water Absorption, equilibrium, 23C 1.25 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 0.5 − 0.7 % ASTM D 1238 Poisson's Ratio 0.36 2 √ ASTM D 1238 EXTRUSION BLOW MOLDING Drying Time 140 − 150 °C C Drying Time (Cumulative) 4 − 6 hrs C C Maximum Moisture Content 0.01 − 0.02 % C C Melt Temperature (Parison) 320 − 355 °C C C Break-Zone 1 Temperature 300 − 355 °C C C Break-Zone 2 Temperature 300 − 355 °C C C Break-Zone 3 Temperature 300 − 355 °C C C Break-Zone 3 Temperature 300 − 355 °C C C	CTE, -20°C to 150°C, flow	5.58E-05	1/°C	ASTM E 831
PHYSICAL Specific Gravity 1.27 ASTM D 792 Water Absorption, 24 hours 0.25 \$CTM D 570 Water Absorption, equilibrium, 23C 1.25 \$SABIC method Mold Shrinkage, flow, 3.2 mm 0.5 − 0.7 \$SABIC method Melt Flow Rate, 33°C/6.6 kgf 12 37 mm ASTM D 1238 Poisson's Ratio 30 ASTM D 1238 *** EXTRUSION BLOW MOLDING Urying Time 140 − 150 C *** Drying Time (Cumulative) 4 − 6 hrs *** Maximum Moisture Content 30 − 0.02 *** ** Melt Temperature (Parison) 30 − 355 C *** Breaf-Zone 1 Temperature 30 − 355 C ** Breaf-Zone 2 Temperature 30 − 355 C **	CTE, -20°C to 150°C, xflow	5.4E-05	1/°C	ASTM E 831
Specific Gravity1.27ASTM D 792Water Absorption, 24 hours0.25\$ASTM D 570Water Absorption, equilibrium, 23C1.25\$ASTM D 570Mold Shrinkage, flow, 3.2 mm0.5 - 0.7\$ASTM D 1238Poisson's Ratio120.7 minASTM D 1238EXTRUSION BLOW MOLDING**ASTM D 1238Drying Temperature140 - 150****Drying Time (Cumulative)4 - 6hrsMaximum Moisture Content0.01 - 0.02****Melt Temperature (Parison)320 - 355****Barrel - Zone 1 Temperature300 - 355****Barrel - Zone 2 Temperature300 - 355****Barrel - Zone 3 Temperature300 - 355****Barrel - Zone 4 Temperature300 - 355****Barrel - Zone 5 Temperature300 - 355****Barrel - Zone 5 Temperature300 - 355****Barrel - Zone 5 Temperature3	Thermal Conductivity	0.22	W/m-°C	ASTM C177
Water Absorption, 24 hours 0.25 % ASTM D 570 Water Absorption, equilibrium, 23C 1.25 % ASTM D 570 Mold Shrinkage, flow, 3.2 mm 0.5 – 0.7 % SABIC method Melt Flow Rate, 337°C/6.6 kgf 12 g/10 min ASTM D 1238 Poisson's Ratio 0.36 - ASTM D 1238 EXTRUSION BLOW MOLDING C ASTM E 132 Drying Temperature 140 – 150 °C C Drying Time (Cumulative) 4 – 6 hrs C Maximum Moisture Content 0.01 – 0.02 % L L Melt Temperature (Parison) 320 – 355 °C L <	PHYSICAL			
Water Absorption, equilibrium, 23C1.25%ASTM D 570Mold Shrinkage, flow, 3.2 mm0.5 – 0.7%SABIC methodMelt Flow Rate, 33°C/6.6 kgf12g/10 minASTM D 1238Poisson's Ratio0.36-ASTM E 132EXTRUSION BLOW MOLDINGDrying Temperature140 – 150°CDrying Time4 – 6hrsDrying Time (Cumulative)44hrsMaximum Moisture Content0.01 – 0.02%Melt Temperature (Parison)320 – 355°CBarrel - Zone 1 Temperature325 – 350°CBarrel - Zone 2 Temperature330 – 355°CBarrel - Zone 3 Temperature330 – 355°C	Specific Gravity	1.27	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm Mold Shrinkage,	Water Absorption, 24 hours	0.25	%	ASTM D 570
Melt Flow Rate, 337°C/6.6 kgf Poisson's Ratio Poisson's Ratio Poisson's Ratio Poisson's Ratio Porjing Temperature Porjing Time (Cumulative) Porjing	Water Absorption, equilibrium, 23C	1.25	%	ASTM D 570
Poisson's Ratio 0.36 - ASTM E 132 EXTRUSION BLOW MOLDING Drying Temperature 140 - 150 °C Drying Time (Cumulative) 4-6 hrs Maximum Moisture Content 0.01 - 0.02 % Melt Temperature (Parison) 320 - 355 °C Barrel - Zone 1 Temperature 330 - 355 °C Barrel - Zone 2 Temperature 330 - 355 °C Barrel - Zone 3 Temperature 330 - 355 °C Barrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C Carrel - Zone 3 Temperature 330 - 355 °C	Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
EXTRUSION BLOW MOLDINGDrying Temperature140 – 150°CDrying Time4 – 6hrsDrying Time (Cumulative)24hrsMaximum Moisture Content0.01 – 0.02%Melt Temperature (Parison)320 – 355°CBarrel - Zone 1 Temperature325 – 350°CBarrel - Zone 2 Temperature330 – 355°CBarrel - Zone 3 Temperature330 – 355°C	Melt Flow Rate, 337°C/6.6 kgf	12	g/10 min	ASTM D 1238
Drying Temperature 140 – 150 °C Drying Time 4 – 6 hs Drying Time (Cumulative) 24 hs Maximum Moisture Content 0.01 – 0.02 % Melt Temperature (Parison) 320 – 355 °C Barrel - Zone 1 Temperature 325 – 350 °C Barrel - Zone 2 Temperature 330 – 355 °C Barrel - Zone 3 Temperature 330 – 355 °C	Poisson's Ratio	0.36	-	ASTM E 132
Drying Time 4-6 hrs Drying Time (Cumulative) 24 hrs Maximum Moisture Content 0.01 - 0.02 % Melt Temperature (Parison) 320 - 355 °C Barrel - Zone 1 Temperature 325 - 350 °C Barrel - Zone 2 Temperature 330 - 355 °C Barrel - Zone 3 Temperature 330 - 355 °C	EXTRUSION BLOW MOLDING			
Drying Time (Cumulative)24hrsMaximum Moisture Content0.01 – 0.02%Melt Temperature (Parison)320 – 355°CBarrel - Zone 1 Temperature325 – 350°CBarrel - Zone 2 Temperature330 – 355°CBarrel - Zone 3 Temperature330 – 355°C	Drying Temperature	140 – 150	°C	
Maximum Moisture Content 0.01 – 0.02 % Melt Temperature (Parison) 320 – 355 °C Barrel - Zone 1 Temperature 325 – 350 °C Barrel - Zone 2 Temperature 330 – 355 °C Barrel - Zone 3 Temperature 330 – 355 °C	Drying Time	4 – 6	hrs	
Melt Temperature (Parison) 320 – 355 °C Barrel - Zone 1 Temperature 325 – 350 °C Barrel - Zone 2 Temperature 330 – 355 °C Barrel - Zone 3 Temperature 330 – 355 °C	Drying Time (Cumulative)	24	hrs	
Barrel - Zone 1 Temperature 325 – 350 °C Barrel - Zone 2 Temperature 330 – 355 °C Barrel - Zone 3 Temperature 330 – 355 °C	Maximum Moisture Content	0.01 – 0.02	%	
Barrel - Zone 2 Temperature 330 – 355 °C Barrel - Zone 3 Temperature 330 – 355 °C	Melt Temperature (Parison)	320 – 355	°C	
Barrel - Zone 3 Temperature 330 – 355 °C	Barrel - Zone 1 Temperature	325 – 350	°C	
·	Barrel - Zone 2 Temperature	330 – 355	°C	
Barrel - Zone 4 Temperature 330 – 355 °C	Barrel - Zone 3 Temperature	330 – 355	°C	
	Barrel - Zone 4 Temperature	330 – 355	°C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Adapter - Zone 5 Temperature	330 – 355	°C	
Head - Zone 6 - Top Temperature	330 – 355	°C	
Head - Zone 7 - Bottom Temperature	330 – 355	°C	
Screw Speed	10 – 70	rpm	
Mold Temperature	65 – 175	°C	
Die Temperature	325 – 355	°C	

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.