ULTEM™ RESIN 1285

REGION AMERICAS

DESCRIPTION

Transparent Polyetherimide blend. ECO Conforming. US FDA and EU Food Contact Compliant in recognized colors.

TYPICAL PROPERTY VALUES

Revision 20260330

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	110	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	82	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D638
Tensile Modulus, 5 mm/min	3370	MPa	ASTM D638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	165	MPa	ASTM D790
Flexural Modulus, 2.6 mm/min, 100 mm span	3370	MPa	ASTM D790
IMPACT			
Izod Impact, notched, 23°C	26	J/m	ASTM D256
Izod Impact, Reverse Notched, 3.2 mm	950	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	40	J	ASTM D3763
THERMAL			
Vicat Softening Temp, Rate B/50	181	°C	ASTM D1525
HDT, 1.82 MPa, 6.4 mm, unannealed	165	°C	ASTM D648
CTE, -40°C to 40°C, flow	4.86E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	4.86E-05	1/°C	ASTM E831
PHYSICAL			
Specific Gravity	1.29	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.6 – 0.7	%	SABIC method
Melt Flow Rate			
295°C/6.6 kgf	8.1	g/10 min	ASTM D1238
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4 – 8	Hrs	
Drying Time (Cumulative)	24	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	300 – 330	°C	
Nozzle Temperature	300 – 330	°C	
Front - Zone 3 Temperature	295 – 325	°C	
Middle - Zone 2 Temperature	290 – 320	°C	
Rear - Zone 1 Temperature	280 – 315	°C	
Mold Temperature	95 – 150	°C	
Back Pressure	0.7 – 1.4	MPa	
Screw Speed	50 – 100	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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