

ULTEM™ RESIN MD130

REGION AMERICAS

DESCRIPTION

Transparent, standard flow Polyetherimide (Tg 217C). ECO Conforming. US FDA and EU Food Contact compliant.

TYPICAL PROPERTY VALUES

Revision 20230607

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	90	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D638
Tensile Modulus, 5 mm/min	3580	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	160	MPa	ASTM D790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	165	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	3550	MPa	ASTM D790
Flexural Modulus, 2.6 mm/min, 100 mm span	3510	MPa	ASTM D790
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	SABIC method
Tensile Stress, yield, 50 mm/min	105	MPa	ISO 527
Tensile Stress, break, 50 mm/min	85	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	60	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	160	MPa	ISO 178
Flexural Modulus, 2 mm/min	3300	MPa	ISO 178
Ball Indentation Hardness, H358/30	140	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched, 23°C	1335	J/m	ASTM D4812
Izod Impact, notched, 23°C	53	J/m	ASTM D256
Izod Impact, notched, -30°C	55	J/m	ASTM D256
Izod Impact, Reverse Notched, 3.2 mm	1335	J/m	ASTM D256
Gardner, 23°C	36	J	ASTM D3029
Instrumented Dart Impact Total Energy, 23°C	38	J	ASTM D3763
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 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	10	kJ/m ²	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	218	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	208	°C	ASTM D648

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CTE, -20°C to 150°C, flow	5.58E-05	1/°C	ASTM E831
CTE, -20°C to 150°C, xflow	5.4E-05	1/°C	ASTM E831
Thermal Conductivity	0.22	W/m.°C	ASTM C177
Thermal Conductivity	0.24	W/m.°C	ISO 8302
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
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	215	°C	ISO 306
Vicat Softening Temp, Rate B/50	211	°C	ISO 306
Vicat Softening Temp, Rate B/120	212	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	200	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.27	-	ASTM D792
Water Absorption, (23°C/24hrs)	0.25	%	ASTM D570
Water Absorption, (23°C/Saturated)	1.25	%	ASTM D570
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	9	g/10 min	ASTM D1238
Poisson's Ratio	0.3	-	ASTM E132
Density	1.27	g/cm ³	ISO 1183
Water Absorption, (23°C/saturated)	1.25	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.7	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	13	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+17	Ω.cm	ASTM D257
Dielectric Strength, in air, 1.6 mm	32.7	kV/mm	ASTM D149
Dielectric Strength, in oil, 1.6 mm	27.9	kV/mm	ASTM D149
Dielectric Strength, in oil, 3.2 mm	19.6	kV/mm	ASTM D149
Relative Permittivity, 100 Hz	3.15	-	ASTM D150
Relative Permittivity, 1 kHz	3.15	-	ASTM D150
Dissipation Factor, 100 Hz	0.0015	-	ASTM D150
Dissipation Factor, 1 kHz	0.0012	-	ASTM D150
Dissipation Factor, 2450 MHz	0.0025	-	ASTM D150
Volume Resistivity	1.E+15	Ω.cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ω	IEC 60093
Dielectric Strength, in oil, 0.8 mm	33	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	25	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	16	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.9	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.0005	-	IEC 60250
Dissipation Factor, 1 MHz	0.006	-	IEC 60250
Dissipation Factor, 2450 MHz	0.0025	-	IEC 60250
Comparative Tracking Index	150	V	IEC 60112
Comparative Tracking Index, M	100	V	IEC 60112
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
FLAME CHARACTERISTICS			
Glow Wire Flammability Index 960°C, passes at	3.2	mm	IEC 60695-2-12
Oxygen Index (LOI)	47	%	ISO 4589
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	
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	
EXTRUSION BLOW MOLDING			
Drying Temperature	140 – 150	°C	
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	
Barrel - Zone 4 Temperature	330 – 355	°C	
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	

ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

MORE INFORMATION

For curve data and CAE cards, please visit and register at <https://materialfinder.sabic-specialties.com>



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