

# ULTEM™ RESIN DU442

REGION AMERICAS

## DESCRIPTION

High Flow, white colorable , UV Stabilized, impact resistant Polyetherimide blend. ECO Conforming.

## TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	66	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	10	%	ASTM D638
Tensile Modulus, 5 mm/min	2990	MPa	ASTM D638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	107	MPa	ASTM D790
Flexural Modulus, 2.6 mm/min, 100 mm span	3060	MPa	ASTM D790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	214	J/m	ASTM D256
Izod Impact, Reverse Notched, 3.2 mm	1490	J/m	ASTM D256
<b>THERMAL</b>			
HDT, 1.82 MPa, 6.4 mm, unannealed	130	°C	ASTM D648
<b>PHYSICAL</b>			
Specific Gravity	1.26	-	ASTM D792
Mold Shrinkage, flow, 24 hrs	0.4 – 0.7	%	ASTM D955
Melt Flow Rate, 295°C/6.6 kgf	34	g/10 min	ASTM D1238
<b>INJECTION MOLDING</b>			
Drying Temperature	125	°C	
Drying Time	4 – 6	Hrs	
Drying Time (Cumulative)	12	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 305	°C	
Nozzle Temperature	280 – 305	°C	
Front - Zone 3 Temperature	280 – 305	°C	
Middle - Zone 2 Temperature	280 – 305	°C	
Rear - Zone 1 Temperature	280 – 305	°C	
Mold Temperature	90 – 110	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	50 – 70	%	
Vent Depth	0.025 – 0.076	mm	

## 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.



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