

# 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	

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