

# EXTEM™ RESIN VH1003F

REGION AMERICAS

## DESCRIPTION

Transparent, Thermoplastic Polyimide (TPI) resin with a glass transition temperature (Tg) of 247C. This product has thin wall FR capability and has a UL94 VO listing. This material is RoHS compliant and also halogen free according VDE/DIN 472 part 815. Global Food Contact Approvals.

## TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	96	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	96	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	6	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	50	%	ASTM D638
Tensile Modulus, 5 mm/min	3510	MPa	ASTM D638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	159	MPa	ASTM D790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	155	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	3170	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	95	MPa	ISO 527
Tensile Stress, break, 5 mm/min	78	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	8.5	%	ISO 527
Tensile Strain, break, 5 mm/min	50	%	ISO 527
Tensile Modulus, 1 mm/min	3110	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	123	MPa	ISO 178
Flexural Modulus, 2 mm/min	3080	MPa	ISO 178
Ball Indentation Hardness, H358/30	140	MPa	ISO 2039-1
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D4812
Izod Impact, notched, 23°C	69	J/m	ASTM D256
Izod Impact, notched, -30°C	74	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	33	J	ASTM D3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	242	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	217	°C	ASTM D648
HDT, 0.45 MPa, 6.4 mm, unannealed	237	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	230	°C	ASTM D648
CTE, -40°C to 150°C, flow	5.E-05	1/°C	ASTM E831
CTE, -40°C to 150°C, xflow	5.E-05	1/°C	ASTM E831

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Thermal Conductivity	0.22	W/m·°C	ASTM E1530
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 B/50	242	°C	ISO 306
Vicat Softening Temp, Rate B/120	238	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	228	°C	ISO 75/Af
<b>PHYSICAL</b>			
Specific Gravity	1.3	-	ASTM D792
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 367°C/6.6 kgf	15.5	g/10 min	ASTM D1238
Density	1.3	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/saturated)	1.75	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.6	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	8	cm <sup>3</sup> /10 min	ISO 1133
<b>OPTICAL</b>			
Light Transmission, 2.54 mm	58	%	ASTM D1003
Haze, 2.54 mm	2	%	ASTM D1003
<b>ELECTRICAL</b>			
Dielectric Strength, in oil, 3.2 mm	17	kV/mm	ASTM D149
Relative Permittivity, 100 Hz	3.41	-	ASTM D150
Relative Permittivity, 1 kHz	3.41	-	ASTM D150
Dissipation Factor, 50/60 Hz	0.025	-	IEC 60250
Dissipation Factor, 100 Hz	0.008	-	IEC 60250
Dissipation Factor, 1 kHz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.007	-	IEC 60250
Comparative Tracking Index	175	V	IEC 60112
<b>FLAME CHARACTERISTICS</b>			
Glow Wire Flammability Index 960°C, passes at	3.2	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 3.0 mm	850	°C	IEC 60695-2-13
Oxygen Index (LOI)	45	%	ISO 4589
<b>INJECTION MOLDING</b>			
Drying Temperature	150	°C	
Drying Time	4 – 6	Hrs	
Drying Time (Cumulative)	24	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	380 – 405	°C	
Nozzle Temperature	375 – 400	°C	
Front - Zone 3 Temperature	380 – 405	°C	
Middle - Zone 2 Temperature	370 – 395	°C	
Rear - Zone 1 Temperature	360 – 380	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
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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