ULTEM™ RESIN 9011

REGION AMERICAS

DESCRIPTION

Transparent, high flow Polyetherimide (Tg 217C). ECO Conforming. Improved processability for Fiber extrusion.

TYPICAL PROPERTY VALUES

Revision 20260319

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	105	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	3590	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	165	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	3520	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	105	MPa	ISO 527
Tensile Stress, break, 5 mm/min	85	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6	%	ISO 527
Tensile Strain, break, 5 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
IMPACT			
Izod Impact, unnotched, 23°C	1335	J/m	ASTM D4812
Izod Impact, notched, 23°C	32	J/m	ASTM D256
Izod Impact, notched, -30°C	35	J/m	ASTM D256
Izod Impact, Reverse Notched, 3.2 mm	1175	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/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	3	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	219	°C	ASTM D1525
HDT, 0.45 MPa, 3.2 mm, unannealed	205	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	197	°C	ASTM D648
HDT, 0.45 MPa, 6.4 mm, unannealed	207	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	199	°C	ASTM D648
CTE			
-40°C to 150°C, flow	5.5E-05	1/°C	ASTM E831
-40°C to 150°C, xflow	5.5E-05	1/°C	ASTM E831
23°C to 150°C, flow	5.E-05	1/°C	ISO 11359-2

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	193	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.27	-	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, 337°C/6.6 kgf	17.8	g/10 min	ASTM D1238
Density	1.27	g/cm³	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	25	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS			
Oxygen Index (LOI)	44	%	ASTM D2863
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	

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