

# ULTEM™ RESIN 1285

REGION ASIA

## DESCRIPTION

Transparent Polyetherimide blend. ECO Conforming. US FDA and EU Food Contact Compliant in recognized colors.

## TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	110	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	82	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D638
Tensile Modulus, 5 mm/min	3370	MPa	ASTM D638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	165	MPa	ASTM D790
Flexural Modulus, 2.6 mm/min, 100 mm span	3370	MPa	ASTM D790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	26	J/m	ASTM D256
Izod Impact, Reverse Notched, 3.2 mm	950	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	40	J	ASTM D3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	181	°C	ASTM D1525
HDT, 1.82 MPa, 6.4 mm, unannealed	165	°C	ASTM D648
CTE, -40°C to 40°C, flow	4.86E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	4.86E-05	1/°C	ASTM E831
<b>PHYSICAL</b>			
Specific Gravity	1.29	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm	0.6 – 0.7	%	SABIC method
Melt Flow Rate, 295°C/6.6 kgf	8.1	g/10 min	ASTM D1238
<b>INJECTION MOLDING</b>			
Drying Temperature	120 – 150	°C	
Drying Time	4 – 8	Hrs	
Drying Time (Cumulative)	24	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	300 – 330	°C	
Nozzle Temperature	300 – 330	°C	
Front - Zone 3 Temperature	295 – 325	°C	
Middle - Zone 2 Temperature	290 – 320	°C	
Rear - Zone 1 Temperature	280 – 315	°C	
Mold Temperature	95 – 150	°C	
Back Pressure	0.7 – 1.4	MPa	
Screw Speed	50 – 100	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	



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