

ULTEM™ RESIN 1010R

REGION ASIA

DESCRIPTION

Enhanced flow Polyetherimide (Tg 217C) with internal mold release. ECO Conforming, UL94 V0 and 5VA listing.

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	110	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	3580	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	165	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3510	MPa	ASTM D 790
Hardness, Rockwell M	109	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	1335	J/m	ASTM D 4812
Izod Impact, notched, 23°C	32	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	1495	J/m	ASTM D 256
Gardner, 23°C	33	J	ASTM D 3029
THERMAL			
Vicat Softening Temp, Rate B/50	218	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	207	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	198	°C	ASTM D 648
CTE, -20°C to 150°C, flow	5.58E-05	1/°C	ASTM E 831
Thermal Conductivity	0.22	W/m-°C	ASTM C177
Relative Temp Index, Elec	170	°C	UL 746B
Relative Temp Index, Mech w/impact	170	°C	UL 746B
Relative Temp Index, Mech w/o impact	170	°C	UL 746B
PHYSICAL			
Specific Gravity	1.27	-	ASTM D 792
Water Absorption, 24 hours	0.25	%	ASTM D 570
Water Absorption, equilibrium, 23C	1.25	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.5 – 0.7	%	SABIC method

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Melt Flow Rate, 337°C/6.6 kgf	17.8	g/10 min	ASTM D 1238
ELECTRICAL			
Volume Resistivity	1.E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 1.6 mm	32.7	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	28	kV/mm	ASTM D 149
Relative Permittivity, 1 kHz	3.15	-	ASTM D 150
Dissipation Factor, 1 kHz	0.0013	-	ASTM D 150
Dissipation Factor, 2450 MHz	0.0025	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.75	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Oxygen Index (LOI)	44	%	ASTM D 2863
NBS Smoke Density, Flaming, Ds 4 min	2	-	ASTM E 662
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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