

ULTEM™ RESIN DU242

REGION AMERICAS

DESCRIPTION

Enhanced low temperature impact, high flow Polyetherimide blend. ECO Conforming.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	74	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	67	%	ASTM D 638
Tensile Modulus, 5 mm/min	2580	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	112	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2510	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	181	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2045	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	160	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.24	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	30	g/10 min	ASTM D 1238
INJECTION MOLDING			
Drying Temperature	135	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	12	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	330 – 355	°C	
Nozzle Temperature	325 – 350	°C	
Front - Zone 3 Temperature	330 – 355	°C	
Middle - Zone 2 Temperature	320 – 345	°C	
Rear - Zone 1 Temperature	310 – 330	°C	
Mold Temperature	95 – 135	°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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