

ULTEM™ RESIN ATX200R

REGION ASIA

DESCRIPTION

High flow Polyetherimide blend with internal mold release. ECO Conforming, UL94 V0 Listing.

TYPICAL PROPERTY VALUES

Revision 20180906

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	96	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	70	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	144	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3170	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2136	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	190	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.26	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	26.5	g/10 min	ASTM D 1238
INJECTION MOLDING			
Drying Temperature	135	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	10	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 370	°C	
Nozzle Temperature	350 – 370	°C	
Front - Zone 3 Temperature	350 – 370	°C	
Middle - Zone 2 Temperature	345 – 365	°C	
Rear - Zone 1 Temperature	340 – 360	°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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