



ULTEM™ Resin 9075
Americas: COMMERCIAL

High flow Polyetherimide blend. Meets FAR 25.853 and OSU 65/65 with low toxicity, smoke, and flame evolution. ECO Conforming.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	980	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	85	%	ASTM D 638
Tensile Modulus, 5 mm/min	33700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1470	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 2.6 mm/min, 100 mm span	1440	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	33000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	212	cm-kgf/cm	ASTM D 256
Gardner, 23°C	359	cm-kgf	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	188	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	2.4	g/10 min	ASTM D 1238
Halogen Content	0	%	SABIC Method
FLAME CHARACTERISTICS			
FAA Flammability, FAR 25.853 A/B	SECT A-1	-	FAR 25.853
OSU total heat release (2 minute test)	10	kW-min/m ²	FAR 25.853
Vertical Burn a (60s) passes at	1	sec	FAR 25.853
Vertical Burn b (12s) passes at	0	sec	FAR 25.853

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
(4) Internal measurements according to UL standards.
(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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
Profile Extrusion		
Drying Temperature	130 - 140	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 330	°C
Barrel - Zone 1 Temperature	280 - 300	°C
Barrel - Zone 2 Temperature	295 - 320	°C
Barrel - Zone 3 Temperature	305 - 330	°C
Barrel - Zone 4 Temperature	310 - 335	°C
Hopper Temperature	80 - 100	°C
Adapter Temperature	285 - 335	°C
Die Temperature	275 - 330	°C
Calibrator Temperature	140 - 170	°C

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