



ULTEM™ Resin LTX300A
Americas: COMMERCIAL

High flow Polyetherimide blend with low toxicity, smoke and flame evolution. ECO Compliant, UL94 V0 listing in recognized colors.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	980	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	860	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	30	%	ASTM D 638
Tensile Modulus, 5 mm/min	33700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1470	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	33000	kgf/cm ²	ASTM D 790
Taber Abrasion, CS-17, 1 kg	15	mg/1000cy	SABIC Method
Tensile Stress, yield, 5 mm/min	90	MPa	ISO 527
Tensile Stress, break, 5 mm/min	75	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6	%	ISO 527
Tensile Strain, break, 5 mm/min	25	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	130	MPa	ISO 178
Flexural Modulus, 2 mm/min	3200	MPa	ISO 178
Hardness, H358/30	127	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched, 23°C	214	cm-kgf/cm	ASTM D 4812
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	356	cm-kgf	ASTM D 3029
Instrumented Impact Total Energy, 23°C	407	cm-kgf	ASTM D 3763

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(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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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	210	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	201	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	187	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	204	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	189	°C	ASTM D 648
CTE, -40°C to 150°C, flow	5.E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	5.E-05	1/°C	ASTM E 831
Thermal Conductivity	0.26	W/m-°C	ISO 8302
CTE, 23°C to 150°C, flow	5.E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	5.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	210	°C	ISO 306
Vicat Softening Temp, Rate B/50	200	°C	ISO 306
Vicat Softening Temp, Rate B/120	200	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	200	°C	ISO 75/Be

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	185	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.6 - 0.8	%	SABIC Method
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
Density	1.3	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	1.25	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.7	%	ISO 62
Melt Volume Rate, MVR at 340°C/5.0 kg	15	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	0.75	mm	UL 94 by SABIC-IP

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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

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