



ULTEM™ Resin LTX300B
Americas: COMMERCIAL

Standard flow Polyetherimide blend with low toxicity, smoke, and flame evolution. ECO Compliant, UL94 V0 listing.

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	88	%	ASTM D 638
Tensile Modulus, 5 mm/min	34000	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	32600	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	217	cm-kgf/cm	ASTM D 256
Gardner, 23°C	359	cm-kgf	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	190	°C	ASTM D 648
Relative Temp Index, Elec	140	°C	UL 746B
Relative Temp Index, Mech w/impact	115	°C	UL 746B
Relative Temp Index, Mech w/o impact	140	°C	UL 746B
PHYSICAL			
Specific Gravity	1.27	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.3 - 0.5	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	1.6	g/10 min	ASTM D 1238
Halogen Content	0	%	SABIC Method
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A

(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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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.76	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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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