



ULTEM™ Resin PW1000
Europe-Africa-Middle East: COMMERCIAL

Unfilled Standard flow Polyetherimide (Tg 217°C). Specific grade-colors are designed and certified for use in Potable Water applications. KTW, WRAS, ACS, NSF-61 and W270 certified. US FDA and European Food Contact approved.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	105	MPa	ISO 527
Tensile Stress, break, 50 mm/min	85	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	60	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	160	MPa	ISO 178
Flexural Modulus, 2 mm/min	3300	MPa	ISO 178
Hardness, H358/30	140	MPa	ISO 2039-1
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	6	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
Charpy Impact, notched, 23°C	10	kJ/m ²	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.24	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
Vicat Softening Temp, Rate A/50	215	°C	ISO 306
Vicat Softening Temp, Rate B/50	211	°C	ISO 306

(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
THERMAL			
Vicat Softening Temp, Rate B/120	215	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	200	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.7	%	SABIC Method
Density	1.27	g/cm ³	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 360°C/5.0 kg	13	cm ³ /10 min	ISO 1133
ELECTRICAL			
Surface Resistivity, ROA	>	Ohm	IEC 60093
FLAME CHARACTERISTICS			
Oxygen Index (LOI)	47	%	ISO 4589

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	370 - 410	°C
Nozzle Temperature	350 - 405	°C
Front - Zone 3 Temperature	360 - 415	°C
Middle - Zone 2 Temperature	350 - 405	°C
Rear - Zone 1 Temperature	340 - 395	°C
Hopper Temperature	80 - 120	°C
Mold Temperature	140 - 180	°C

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