



ULTEM™ RESIN 4002

REGION AMERICAS

DESCRIPTION

PTFE filled, standard flow Polyetherimide (Tg 217°C). ECO Conforming, UL 94 V0 and 5VA listing in recognized colors.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	105	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	85	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	40	%	ASTM D 638
Tensile Modulus, 5 mm/min	3460	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	155	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3550	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	100	MPa	ISO 527
Tensile Stress, break, 50 mm/min	80	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	25	%	ISO 527
Tensile Modulus, 1 mm/min	3300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	130	MPa	ISO 178
Flexural Modulus, 2 mm/min	3100	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	117	J/m	ASTM D 256
Izod Impact, notched, -30°C	120	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	380	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	11	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	219	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	197	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	200	°C	ASTM D 648
CTE, -40°C to 150°C, flow	3.9E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	4.E-05	1/°C	ASTM E 831
CTE, 23°C to 150°C, flow	3.9E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	4.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	215	°C	ISO 306
Vicat Softening Temp, Rate B/120	210	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.33	-	ASTM D 792



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage on Tensile Bar, flow	0.6 – 0.8	%	SABIC method
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	9.5	g/10 min	ASTM D 1238
Density	1.33	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	1.1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.6	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	13	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating	0.4	mm	UL 94
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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