



ULTEM™ Resin ATX3562R
Americas: COMMERCIAL

50% Glass fiber and mineral filled, high flow Polyetherimide blend with internal mold release and enhanced dimensional stability. ECO Conforming.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1270	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1270	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	152300	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1830	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	131500	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	121	MPa	ISO 527
Tensile Stress, break, 5 mm/min	121	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	1.4	%	ISO 527
Tensile Strain, break, 5 mm/min	1.4	%	ISO 527
Tensile Modulus, 1 mm/min	14690	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	172	MPa	ISO 178
Flexural Modulus, 2 mm/min	13550	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	11	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	122	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A



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IMPACT			
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	184	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	183	°C	ASTM D 648
CTE, -40°C to 150°C, flow	1.6E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	3.8E-05	1/°C	ASTM E 831
CTE, 23°C to 150°C, flow	1.6E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	3.8E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	187	°C	ISO 306
Vicat Softening Temp, Rate B/120	195	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	195	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	182	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.69	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.3	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.3 - 0.5	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	20	g/10 min	ASTM D 1238
Density	1.69	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.04	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	20	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	6.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	2.1E+15	Ohm	ASTM D 257



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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