



ULTEM™ Resin AUT195

Americas: COMMERCIAL

High flow Polyetherimide blend for automotive lighting applications where highly metallized, reflective surfaces are required. Haze onset temperature of 195C (SABIC test method).

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	70	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1470	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	32300	kgf/cm ²	ASTM D 790
Tensile Modulus, 1 mm/min	3000	MPa	ISO 527
Flexural Modulus, 2 mm/min	3100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	212	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	217	cm-kgf/cm	ASTM D 256
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
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	190	°C	ASTM D 648
Thermal Conductivity	0.23	W/m-°C	ISO 8302
CTE, 23°C to 150°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	6.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/120	205	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	195	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	180	°C	ISO 75/Ae
Metallized Haze Onset	195	°C	SABIC Method



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Specific Gravity	1.26	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2) (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	24	g/10 min	ASTM D 1238
Density	1.27	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.9	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.5	%	ISO 62
Melt Volume Rate, MVR at 340°C/5.0 kg	16	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	130 - 140	°C
Drying Time	3 - 4	hrs
Melt Temperature	340 - 380	°C
Nozzle Temperature	340 - 360	°C
Front - Zone 3 Temperature	340 - 360	°C
Middle - Zone 2 Temperature	330 - 350	°C
Rear - Zone 1 Temperature	320 - 340	°C
Hopper Temperature	80 - 100	°C
Mold Temperature	125 - 140	°C