+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
+852-6957-5415 (HongKong)

ULTEM™ Resin D9065

Americas: COMMERCIAL

Polyetherimide blend. Meets FAR 25.853 and OSU 65/65 with low toxicity, smoke, and flame evolution. ECO Conforming.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	890	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	890	kgf/cm²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	31600	kgf/cm²	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1260	kgf/cm²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	31600	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	15	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	9	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	206	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	691	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -30	594	cm-kgf	ASTM D 3763
PHYSICAL			
Specific Gravity	1.32	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	15.6	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
OSU total heat release (2 minute test)	10	kW-min/m²	FAR 25.853
OSU peak heat release rate (5 minute test)	50	kW/m²	FAR 25.853

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	135	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	340 - 360	°C
Nozzle Temperature	330 - 355	°C
Front - Zone 3 Temperature	340 - 360	°C
Middle - Zone 2 Temperature	325 - 350	°C
Rear - Zone 1 Temperature	315 - 340	°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