



ULTEM™ Resin HU1004
Americas: COMMERCIAL

High Temperature, Transparent, Polyetherimide Blend with Improved Ductility and Enhanced Hydrostability. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant. EtO and steam sterilizable.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	960	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	910	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	85	%	ASTM D 638
Tensile Modulus, 5 mm/min	29500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1420	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	30500	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	97	MPa	ISO 527
Tensile Stress, break, 50 mm/min	80	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	7	%	ISO 527
Tensile Strain, break, 50 mm/min	80	%	ISO 527
Flexural Stress, yield, 2 mm/min	136	MPa	ISO 178
Flexural Modulus, 2 mm/min	2800	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	336	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	948	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, 0°C	1009	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -20°C	948	cm-kgf	ASTM D 3763
Instrumented Impact Ductility, 23°C	100	%	ASTM D 3763
Instrumented Impact Ductility, 0°C	100	%	ASTM D 3763
Instrumented Impact Ductility, -20°C	90	%	ASTM D 3763



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
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 Impact, notched, 23°C	11	kJ/m ²	ISO 179/2C
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	214	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	204	°C	ASTM D 648
CTE, -20°C to 150°C, flow	5.6E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, xflow	5.5E-05	1/°C	ASTM E 831
Thermal Conductivity	0.19	W/m-°C	ASTM C 177
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	219	°C	ISO 306
Vicat Softening Temp, Rate B/50	212	°C	ISO 306
Vicat Softening Temp, Rate B/120	212	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	205	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	10	g/10 min	ASTM D 1238
Density	1.28	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 360°C/5.0 kg	14	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.75	mm	UL 94



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Oxygen Index (LOI)	46	%	ASTM D 2863
NBS Smoke Density, Flaming, Ds 4 min	0.7	-	ASTM E 662



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	6 - 8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	355 - 390	°C
Nozzle Temperature	345 - 390	°C
Front - Zone 3 Temperature	345 - 390	°C
Middle - Zone 2 Temperature	335 - 390	°C
Rear - Zone 1 Temperature	330 - 390	°C
Mold Temperature	130 - 160	°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