



ULTEM™ Resin HU1010
Americas: COMMERCIAL

Transparent, enhanced flow Polyetherimide (Tg 217C). ECO Conforming. 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	1120	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1070	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	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	36500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1770	kgf/cm ²	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1680	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	34900	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	35800	kgf/cm ²	ASTM D 790
Hardness, Rockwell M	109	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	ASTM D 1044
Tensile Stress, yield, 5 mm/min	105	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6	%	ISO 527
Tensile Strain, break, 5 mm/min	60	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	160	MPa	ISO 178
Flexural Modulus, 2 mm/min	3300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	136	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	3	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	118	cm-kgf/cm	ASTM D 256



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IMPACT			
Gardner, 23°C	345	cm-kgf	ASTM D 3029
Instrumented Impact Total Energy, 23°C	336	cm-kgf	ASTM D 3763
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	3	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	218	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	207	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	198	°C	ASTM D 648
CTE, -40°C to 40°C, xflow	5.E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, flow	5.58E-05	1/°C	ASTM E 831
Thermal Conductivity	0.22	W/m-°C	ASTM C 177
CTE, -40°C to 40°C, flow	5.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	211	°C	ISO 306
Vicat Softening Temp, Rate B/120	212	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	193	°C	ISO 75/Af
Relative Temp Index, Elec	170	°C	UL 746B
Relative Temp Index, Mech w/impact	170	°C	UL 746B
Relative Temp Index, Mech w/o impact	170	°C	UL 746B
PHYSICAL			
Specific Gravity	1.27	-	ASTM D 792
Water Absorption, equilibrium, 23C	1.25	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	17.8	g/10 min	ASTM D 1238



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PHYSICAL			
Density	1.27	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1.25	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.7	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	25	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 1.6 mm	32.7	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	28	kV/mm	ASTM D 149
Relative Permittivity, 1 kHz	3.15	-	ASTM D 150
Dissipation Factor, 1 kHz	0.0013	-	ASTM D 150
Dissipation Factor, 2450 MHz	0.0025	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating (3)	0.71	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.75	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Oxygen Index (LOI)	44	%	ASTM D 2863
NBS Smoke Density, Flaming, Ds 4 min	2	-	ASTM E 662



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 400	°C
Nozzle Temperature	345 - 400	°C
Front - Zone 3 Temperature	345 - 400	°C
Middle - Zone 2 Temperature	340 - 400	°C
Rear - Zone 1 Temperature	330 - 400	°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