

ULTEM™ 9075 resin

Polyether Imide
SABIC Innovative Plastics

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

General Information			
Features	ECO Compliant		
	High Flow		
	Low Smoke Emission		
	Low Toxicity		
Agency Ratings	EU Eco		
	FAR 25.853		
	OSU 65/65		
Processing Method	Injection Molding		
	Profile Extrusion		
Multi-Point Data	Elastic Modulus vs Temperature (ASTM D4065)		
	Flexural DMA (ASTM D4065)		
	Instrumented Impact (Energy) (ASTM D3763)		
	Instrumented Impact (Load) (ASTM D3763)		
	Tensile Creep (ASTM D2990)		
	Tensile Fatigue		
	Tensile Stress vs. Strain (ASTM D638)		
	Thermal Conductivity vs. Temperature (ASTM E1530)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (295°C/6.6 kg)	2.4	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.50 to 0.70	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3310	MPa	ASTM D638
Tensile Strength ² (Yield)	96.5	MPa	ASTM D638
Tensile Elongation ³ (Break)	85	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	3240	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790

Yield, 100 mm Span	145	MPa	
Break, 100 mm Span	141	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	69	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	2100	J/m	ASTM D256
Gardner Impact (23°C)	35.3	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	189	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
FAA Flammability ⁶	SECT A-1		FAR 25.853
Halogen Content	0		Internal Method
OSU Total Heat Release ⁷	10.0	kW · min/m ²	FAR 25.853
Vertical Burn Test			FAR 25.853
Test a (60 s), passes at	1.0	sec	
Test b (12 s), passes at	0.0	sec	
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	10	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	338 to 360	°C	
Middle Temperature	343 to 366	°C	
Front Temperature	349 to 371	°C	
Nozzle Temperature	349 to 371	°C	
Processing (Melt) Temp	349 to 371	°C	
Mold Temperature	135 to 163	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
Extrusion	Nominal Value	Unit	
Drying Temperature	130 to 140	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	80.0 to 100	°C	
Cylinder Zone 1 Temp.	280 to 300	°C	
Cylinder Zone 2 Temp.	295 to 320	°C	
Cylinder Zone 3 Temp.	305 to 330	°C	
Cylinder Zone 4 Temp.	310 to 335	°C	
Adapter Temperature	285 to 335	°C	
Melt Temperature	295 to 330	°C	

Die Temperature	275 to 330	°C
Calibration Temp, First	140 to 170	°C
Calibration Temp, Second	90.0 to 130	°C

NOTE

1.	5.0 mm/min
2.	Type I, 5.0 mm/min
3.	Type I, 5.0 mm/min
4.	2.6 mm/min
5.	2.6 mm/min
6.	Method A/B
7.	2 minute test

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