

ULTEM™ 1110 resin

Polyether Imide
SABIC Innovative Plastics

Message:
Enhanced flow Polyetherimide (Tg 217C). ECO Conforming.

General Information			
Features	Comply with ECO		
	Good liquidity		
Agency Ratings	EU Eco		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3720	MPa	ASTM D638
Tensile Strength ² (Yield)	110	MPa	ASTM D638
Tensile Elongation ³ (Break)	70	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	3720	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	165	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Reverse Notch Izod Impact (3.20 mm)	1600	J/m	ASTM D256
Dart Drop Impact (23°C)	23.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	199	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.750 mm	V-0		UL 94
3.00 mm	5VA		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	332 - 399	°C	
Middle Temperature	338 - 399	°C	

Front Temperature	343 - 399	°C
Nozzle Temperature	343 - 399	°C
Processing (Melt) Temp	349 - 399	°C
Mold Temperature	135 - 163	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm

NOTE

1. 5.0 mm/min
2. Type 1, 5.0 mm/min
3. Type 1, 5.0 mm/min
4. 2.6 mm/min
5. 2.6 mm/min

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