

ULTEM™ ATX200R resin

Polyether Imide + PCE

SABIC Innovative Plastics

Message:

High flow Polyetherimide blend with internal mold release. ECO Conforming.

General Information			
Additive	demoulding		
Features	Comply with ECO		
	High liquidity		
Agency Ratings	EU Eco		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	27	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	96.5	MPa	ASTM D638
Tensile Elongation ² (Break)	70	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	3170	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 100 mm Span)	145	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	2100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	191	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	10	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	338 - 360	°C	
Middle Temperature	343 - 366	°C	
Front Temperature	349 - 371	°C	
Nozzle Temperature	349 - 371	°C	
Processing (Melt) Temp	349 - 371	°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.	Type 1, 5.0 mm/min	
2.	Type 1, 5.0 mm/min	
3.	2.6 mm/min	
4.	2.6 mm/min	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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