

ULTEM™ D9065 resin

Polyether Imide
SABIC Innovative Plastics

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

General Information	
Features	ECO Compliant
	Low Smoke Emission
	Low Toxicity
Agency Ratings	EU Eco
	FAR 25.853
	OSU 65/65
Processing Method	Injection Molding
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831)
	Flexural DMA (ASTM D4065)
	Tensile Creep (ASTM D2990)
	Tensile Stress vs. Strain (ASTM D638)

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	16	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	3100	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	88.3	MPa	
Break	88.3	MPa	
Tensile Elongation ³ (Break)	100	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	3100	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	124	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	96	J/m	
23°C	150	J/m	
Reverse Notch Izod Impact (3.20 mm)	2000	J/m	ASTM D256

Instrumented Dart Impact			ASTM D3763
-30°C, Energy at Peak Load	58.3	J	
23°C, Energy at Peak Load	67.8	J	
Flammability	Nominal Value	Unit	Test Method
OSU Peak Heat Release Rate ⁶	50.0	kW/m ²	FAR 25.853
OSU Total Heat Release ⁷	10.0	kW · min/m ²	FAR 25.853
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	316 to 338	°C	
Middle Temperature	327 to 349	°C	
Front Temperature	338 to 360	°C	
Nozzle Temperature	332 to 354	°C	
Processing (Melt) Temp	338 to 360	°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	
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.	5 minute test		
7.	2 minute test		

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