

ULTEM™ ATX200R resin

Polyether Imide + PCE
SABIC Innovative Plastics

Message:
High flow Polyetherimide blend with internal mold release. ECO Conforming, UL94 V0 Listing.

General Information			
UL YellowCard	E121562-221073		
Additive	Mold Release		
Features	ECO Compliant		
	High Flow		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Multi-Point Data	Compressive Stress vs. Strain (ASTM D695)		
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 to 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 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

NOTE

- | | |
|----|--------------------|
| 1. | Type I, 5.0 mm/min |
| 2. | Type I, 5.0 mm/min |
| 3. | 2.6 mm/min |
| 4. | 2.6 mm/min |

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