

Ultem* Resin ATX200

Asia Pacific: COMMERCIAL

High flow Polyetherimide blend, ECO Conforming, UL 94 V0 Listing

| TYPICAL PROPERTIES ¹ | TYPICAL VALUE | UNIT | STANDARD |
|---|---------------|----------|--------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 5 mm/min | 96 | MPa | ASTM D 638 |
| Tensile Strain, brk, Type I, 5 mm/min | 70 | % | ASTM D 638 |
| Flexural Stress, yld, 2.6 mm/min, 100 mm span | 144 | MPa | ASTM D 790 |
| Flexural Modulus, 2.6 mm/min, 100 mm span | 3170 | MPa | ASTM D 790 |
| IMPACT | | | |
| Izod Impact, unnotched, 23°C | 2082 | J/m | ASTM D 4812 |
| Izod Impact, notched, 23°C | 53 | J/m | ASTM D 256 |
| Izod Impact, Reverse Notched, 3.2 mm | 2136 | J/m | ASTM D 256 |
| THERMAL | | | |
| HDT, 1.82 MPa, 6.4 mm, unannealed | 190 | °C | ASTM D 648 |
| Relative Temp Index, Elec | 115 | °C | UL 746B |
| Relative Temp Index, Mech w/impact | 115 | °C | UL 746B |
| Relative Temp Index, Mech w/o impact | 115 | °C | UL 746B |
| PHYSICAL | | | |
| Specific Gravity | 1.26 | - | ASTM D 792 |
| Mold Shrinkage, flow, 3.2 mm | 0.5 - 0.7 | % | SABIC Method |
| Melt Flow Rate, 337°C/6.6 kgf | 24 | g/10 min | ASTM D 1238 |
| ELECTRICAL | | | |
| Hot Wire Ignition (PLC) | 0 | PLC Code | UL 746A |
| High Ampere Arc Ign, surface (PLC) | 4 | PLC Code | UL 746A |
| Comparative Tracking Index (UL) (PLC) | 4 | PLC Code | UL 746A |
| FLAME CHARACTERISTICS | | | |
| UL Recognized, 94V-2 Flame Class Rating (3) | 0.76 | mm | UL 94 |
| UL Recognized, 94V-0 Flame Class Rating (3) | 1.49 | mm | UL 94 |

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.
3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
4) Own measurement according to UL.

Source, GMD, Last Update:

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| PROCESSING PARAMETERS | TYPICAL VALUE | UNIT |
|-----------------------------|---------------|------|
| Injection Molding | | |
| Drying Temperature | 135 | °C |
| Drying Time | 4 - 6 | hrs |
| Drying Time (Cumulative) | 10 | hrs |
| Maximum Moisture Content | 0.02 | % |
| Melt Temperature | 350 - 370 | °C |
| Nozzle Temperature | 350 - 370 | °C |
| Front - Zone 3 Temperature | 350 - 370 | °C |
| Middle - Zone 2 Temperature | 345 - 365 | °C |
| Rear - Zone 1 Temperature | 340 - 360 | °C |
| Mold Temperature | 135 - 165 | °C |
| Back Pressure | 0.3 - 0.7 | MPa |
| Screw Speed | 40 - 70 | rpm |
| Shot to Cylinder Size | 40 - 60 | % |
| Vent Depth | 0.025 - 0.076 | mm |

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