

Product Texts

High Temperature, Transparent, Polyetherimide Blend with Improved Ductility and Enhanced Hydrostability.

UL Yellow Card Link [E121562-100737020](https://www.ulprospector.com/usa/121562-100737020)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	14	cm ³ /10min	ISO 1133
Temperature	360	°C	-
Load	5	kg	-
Density of melt	1140	kg/m ³	-
Thermal conductivity of melt	0.2	W/(m K)	-
Spec. heat capacity of melt	1730	J/(kg K)	-
Ejection temperature	207	°C	-
ASTM Data			
Melt Flow Index, MFI	10	g/10min	ASTM D 1238
Temperature	337	°C	-
Load	6.6	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3100	MPa	ISO 527
Yield stress	97	MPa	ISO 527
Yield strain	7	%	ISO 527
Stress at break	80	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2800	MPa	ISO 178
Izod impact strength, +23°C, 4mm	N	kJ/m ²	ISO 180/1U
Izod impact strength, -30°C, 4mm	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	6	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C, 4mm	6	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	2900	MPa	ASTM D 638
Tensile Strength at Yield	95	MPa	ASTM D 638
Tensile Strength at Break	90	MPa	ASTM D 638
Elongation at Yield	7	%	ASTM D 638
Elongation at Break	85	%	ASTM D 638
Flexural Modulus	3000	MPa	ASTM D 790
Izod Impact notched, 1/8 in	70	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Vicat softening temperature, A	219	°C	ISO 306
Vicat softening temperature, B	212	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	212	°C	ISO 306
Coeff. of linear therm. expansion, parallel	63	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	63	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
ASTM Data			
Thermal Conductivity, solid state	0.0274	W/(m K)	ASTM C 177

Other properties	Value	Unit	Test Standard
Density	1280	kg/m ³	ISO 1183
Density	1280	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	150	°C	-
Pre-drying - Time	6 - 8	h	-

ULTEM™ Resin DH1004 - Americas

PEI

Saudi Basic Industries Corporation (SABIC)

Processing humidity	≤0.02	%	-
Melt temperature	355 - 390	°C	-
Mold temperature	130 - 160	°C	-
Zone 1	330 - 390	°C	-
Zone 2	335 - 390	°C	-
Zone 3	345 - 390	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America

Special Characteristics

Transparent