

Product Texts

High flow ULTEM blends for thin wall application

UL Yellow Card Link [E207780-100116344](https://www.ulprospector.com/usa/Products/207780-100116344)

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	30	cm ³ /10min	ISO 1133
Temperature	345	°C	-
Load	10	kg	-
ASTM Data			
Melt Flow Index, MFI	14.7	g/10min	ASTM D 1238
Temperature	337	°C	-
Load	6.6	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Stress at break	171	MPa	ISO 527
Strain at break	2.5	%	ISO 527
Flexural modulus	9400	MPa	ISO 178
Izod notched impact strength, +23°C, 4mm	10	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	11600	MPa	ASTM D 638
Tensile Strength at Break	172	MPa	ASTM D 638
Elongation at Break	2.6	%	ASTM D 638
Flexural Modulus	9320	MPa	ASTM D 790
Izod Impact notched, 1/8 in	95	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	204	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1520	kg/m ³	ISO 1183
Density	1520	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	150	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	350 - 400	°C	-
Mold temperature	135 - 165	°C	-
Zone 1	330 - 400	°C	-
Zone 2	340 - 400	°C	-
Zone 3	345 - 400	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America