

Product Texts

High flow ULTEM for thin wall application

UL Yellow Card Link [E207780-100116345](https://www.ulprospector.com/207780-100116345)

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|-------------------------------------|-------|------------------------|---------------|
| ISO Data | | | |
| Melt volume-flow rate, MVR | 40 | cm ³ /10min | ISO 1133 |
| Temperature | 345 | °C | - |
| Load | 10 | kg | - |
| Thermal conductivity of melt | 0.21 | W/(m K) | - |
| Spec. heat capacity of melt | 1580 | J/(kg K) | - |
| Ejection temperature | 197 | °C | - |
| ASTM Data | | | |
| Melt Flow Index, MFI | 18 | g/10min | ASTM D 1238 |
| Temperature | 337 | °C | - |
| Load | 6.6 | kg | - |

| Mechanical properties | Value | Unit | Test Standard |
|--|-------|-------------------|---------------|
| ISO Data | | | |
| Stress at break | 152 | MPa | ISO 527 |
| Strain at break | 2 | % | ISO 527 |
| Flexural modulus | 9940 | MPa | ISO 178 |
| Izod notched impact strength, +23°C, 4mm | 9 | kJ/m ² | ISO 180/1A |
| ASTM Data | | | |
| Tensile Modulus | 11950 | MPa | ASTM D 638 |
| Tensile Strength at Break | 148 | MPa | ASTM D 638 |
| Elongation at Break | 2 | % | ASTM D 638 |
| Flexural Modulus | 9940 | MPa | ASTM D 790 |
| Izod Impact notched, 1/8 in | 89 | J/m | ASTM D 256 |

| Thermal properties | Value | Unit | Test Standard |
|---|-------|-------|-----------------|
| ISO Data | | | |
| Coeff. of linear therm. expansion, parallel | 15 | E-6/K | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion, normal | 51 | E-6/K | ISO 11359-1/-2 |
| Burning behav. at 1.5 mm nom. thckn. | V-0 | class | IEC 60695-11-10 |
| Thickness tested | 1.5 | mm | - |
| ASTM Data | | | |
| DTUL @ 264 psi | 203 | °C | ASTM D 648 |

| Other properties | Value | Unit | Test Standard |
|------------------|-------|-------------------|---------------|
| Density | 1530 | kg/m ³ | ISO 1183 |
| Density | 1530 | 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

Asia Pacific