

**ULTEM™ Resin 4000 - Americas**

(PEI+PTFE)-(CD+GF)

Saudi Basic Industries Corporation (SABIC)

**Product Texts**

Glass fiber, PTFE, and Graphite filled, standard flow Polyetherimide (Tg 217C). ECO Conforming, UL94 V0 listing.

UL Yellow Card Link [E121562-221109](https://www.ul.com/yellow-card/E121562-221109)

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	3.1	g/10min	ASTM D 1238
Temperature	337	°C	-
Load	6.6	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Break	82	MPa	ASTM D 638
Elongation at Break	1.2	%	ASTM D 638
Rockwell Hardness	M 85	-	ASTM D 785
Taber Abrasion Resistance	33	mg/1000 cycles	ASTM D 1044
Izod Impact notched, 1/8 in	64	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	160	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
<b>ASTM Data</b>			
Vicat Temperature	233	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1670	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	135	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	350 - 370	°C	-
Mold temperature	135 - 165	°C	-
Zone 1	340 - 360	°C	-
Zone 2	345 - 365	°C	-
Zone 3	350 - 370	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America