

**ULTEM™ Resin 3473**

(PEI+PPS)-GF

Saudi Basic Industries Corporation (SABIC)

**Product Texts**

ULTEM 3473 resin is a reinforced blend of polyetherimide (PEI) and polyphenylenesulfide (PPS) that combines the benefits of an amorphous and a semicrystalline material. Features are an excellent combination of reliable metallization, SMT lead free solder capability and providing extreme dimensional stability up to high temperatures. The material is a light weight alternative to Aluminum solutions, RoHS compliant, easy flowing and injection moldable.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	5.5	cm <sup>3</sup> /10min	ISO 1133
Temperature	320	°C	-
Load	5	kg	-
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.0025	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0035	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	15900	MPa	ISO 527
Stress at break	146	MPa	ISO 527
Strain at break	1.65	%	ISO 527
Flexural modulus, 23°C	14500	MPa	ISO 178
Flexural strength	201	MPa	ISO 178
<b>ASTM Data</b>			
Tensile Modulus	15800	MPa	ASTM D 638
Tensile Strength at Break	156	MPa	ASTM D 638
Elongation at Break	1.8	%	ASTM D 638
Flexural Modulus	14500	MPa	ASTM D 790
Flexural Strength	231	MPa	ASTM D 790
Izod Impact notched, 1/8 in	56	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	390	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	250	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	275	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	19	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	25	E-6/K	ISO 11359-1/-2
<b>ASTM Data</b>			
DTUL @ 66 psi	275	°C	ASTM D 648
DTUL @ 264 psi	249	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1680	kg/m <sup>3</sup>	ISO 1183

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	315 - 335	°C	-
Mold temperature	120 - 180	°C	-
Zone 1	270 - 315	°C	-
Zone 2	280 - 325	°C	-
Zone 3	290 - 335	°C	-
Nozzle temperature	300 - 335	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

## ULTEM™ Resin 3473

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### Characteristics

#### Processing

Injection Molding, Compression Molding

#### Applications

Electrical and Electronical

#### Certifications

RoHS compliant

#### Regional Availability

North America, Europe, Asia Pacific, South and Central America