

ULTEM™ 1285 resin

Polyether Imide

SABIC Innovative Plastics

Message:

Transparent Polyetherimide blend. ECO Conforming. US FDA and EU Food Contact compliant in recognized colors.

General Information			
Features	Comply with ECO		
	Compliance of Food Exposure		
Agency Ratings	EU Eco		
	FDA Food Exposure, Not Rated		
	European food contact, not rated		
RoHS Compliance	RoHS compliance		
Appearance	Clear/transparent		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (320°C/5.0 kg)	16.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 - 0.70	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.50	%	ISO 62
Equilibrium, 23°C, 50% RH	0.17	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	160	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3300	MPa	ISO 527-2/1
Tensile Stress			
Yield	110	MPa	ISO 527-2/5
Yield	115	MPa	ISO 527-2/50
Fracture	75.0	MPa	ISO 527-2/5, ISO 527-2/50
Tensile Strain			
Yield	6.0	%	ISO 527-2/5
Yield	6.5	%	ISO 527-2/50
Fracture	36	%	ISO 527-2/5
Fracture	14	%	ISO 527-2/50
Flexural Modulus ²	3250	MPa	ISO 178
Flexural Stress	155	MPa	ISO 178

Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	36.0	mg	Internal method
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179/1eA
-30°C	3.0	kJ/m ²	ISO 179/1eA
23°C	3.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ⁴			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact ⁵			ISO 180/1A
-30°C	4.0	kJ/m ²	ISO 180/1A
23°C	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁶			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, unannealed, 100 mm span	170	°C	ISO 75-2/Be
1.8 MPa, unannealed, 100 mm span	158	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	177	°C	ISO 306/B50
--	180	°C	ISO 306/B120
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 80°C	5.3E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 80°C	5.3E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	3.4E+16	ohms	IEC 60093
Volume Resistivity	6.6E+16	ohms·cm	IEC 60093
Dielectric Strength (3.20 mm, in Oil)	16	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
50 Hz	2.98		IEC 60250
60 Hz	2.98		IEC 60250
1 MHz	2.94		IEC 60250
Dissipation Factor			IEC 60250
50 Hz	2.6E-3		IEC 60250
60 Hz	2.6E-3		IEC 60250
1 MHz	0.010		IEC 60250
Comparative Tracking Index	150	V	IEC 60112
Injection	Nominal Value	Unit	
Drying Temperature	120 - 150	°C	
Drying Time	4.0 - 8.0	hr	

Processing (Melt) Temp	300 - 330	°C
Mold Temperature	95.0 - 150	°C
NOTE		
1.	Tensile Bar	
2.	2.0 mm/min	
3.	80*10*4 sp=62mm	
4.	80*10*4 sp=62mm	
5.	80*10*4	
6.	80*10*4	
7.	120*10*4 mm	

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