

ULTEM™ 1110F resin

Polyether Imide

SABIC Innovative Plastics

Message:

Enhanced flow Polyetherimide (Tg 217°C). ECO Conforming, UL94 V0 and 5VA listing. US FDA and EU Food Contact compliant, NSF 51 listing. Effective June 2007, this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HU1110.

General Information			
Features	Comply with ECO		
	Good liquidity		
	Compliance of Food Exposure		
Agency Ratings	EU Eco		
	FDA Food Exposure, Not Rated		
	NSF 51		
	European food contact, not rated		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3720	MPa	ASTM D638
Tensile Strength ² (Yield)	110	MPa	ASTM D638
Tensile Elongation ³ (Break)	70	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	3720	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	165	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Reverse Notch Izod Impact (3.20 mm)	1900	J/m	ASTM D256
Dart Drop Impact (23°C)	23.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	199	°C	ASTM D648
RTI Elec	170	°C	UL 746
RTI Imp	170	°C	UL 746
RTI	170	°C	UL 746
Electrical	Nominal Value	Test Method	
Arc Resistance ⁶	PLC 5	ASTM D495	
Comparative Tracking Index (CTI)	PLC 4	UL 746	

High Amp Arc Ignition (HAI)	PLC 3	UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 2	UL 746
Hot-wire Ignition (HWI)	PLC 1	UL 746
Flammability	Nominal Value	Test Method
Flame Rating		UL 94
0.750 mm	V-0	UL 94
3.00 mm	5VA	UL 94
Injection	Nominal Value	Unit
Drying Temperature	149	°C
Drying Time	4.0 - 6.0	hr
Drying Time, Maximum	24	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 - 60	%
Rear Temperature	332 - 399	°C
Middle Temperature	338 - 399	°C
Front Temperature	343 - 399	°C
Nozzle Temperature	343 - 399	°C
Processing (Melt) Temp	349 - 399	°C
Mold Temperature	135 - 163	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm
NOTE		
1.	5.0 mm/min	
2.	Type 1, 5.0 mm/min	
3.	Type 1, 5.0 mm/min	
4.	2.6 mm/min	
5.	2.6 mm/min	
6.	Tungsten electrode	

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