

ULTEM™ XH6050 resin

Polyether Imide

SABIC Innovative Plastics Asia Pacific

Message:

Transparent, Thermoplastic Polyimide (TPI) resin. Glass transition Temp. (Tg) of 247°C. This resin has thinwall FR capability and has a UL94 V0 listing. Resin is RoHS compliant and halogen free according VDE/DIN 472 part 815.

General Information			
Features	Flame Retardant		
	Halogen Free		
Agency Ratings	DIN VDE 0472 Part 815		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (367°C/6.6 kg)	13	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (360°C/5.0 kg)	8.50	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow ¹	0.50 to 0.70	%	
Flow : 3.20 mm	0.50 to 0.70	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
Water Absorption			ISO 62
Saturation, 23°C	1.8	%	
Equilibrium, 23°C, 50% RH	0.60	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	141	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	3520	MPa	ASTM D638
--	3120	MPa	ISO 527-2/1
Tensile Strength			
Yield ³	96.5	MPa	ASTM D638
Yield	95.0	MPa	ISO 527-2/5
Break ⁴	96.5	MPa	ASTM D638
Break	78.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁵	6.0	%	ASTM D638
Yield	8.5	%	ISO 527-2/5
Break ⁶	25	%	ASTM D638

Break	17	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁷	3170	MPa	ASTM D790
-- ⁸	3080	MPa	ISO 178
Flexural Stress			
--	123	MPa	ISO 178
Yield, 100 mm Span ⁹	155	MPa	ASTM D790
Break, 50.0 mm Span ¹⁰	159	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength ¹¹			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact			
-30°C	74	J/m	ASTM D256
23°C	69	J/m	ASTM D256
-30°C ¹²	5.4	kJ/m ²	ISO 180/1A
23°C ¹³	4.6	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	No Break		ASTM D4812, ISO 180/1U
-30°C ¹⁴	No Break		ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	33.9	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	237	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	230	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁵	228	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	242	°C	ASTM D1525, ISO 306/B50 12 ¹⁶
--	238	°C	ISO 306/B120
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
CLTE			
Flow : -40 to 150°C	5.0E-5	cm/cm/°C	ASTM E831
Flow : 23 to 150°C	5.0E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 150°C	5.0E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 150°C	5.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.22	W/m/K	ASTM E1530
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (3.20 mm, in Oil)	17	kV/mm	ASTM D149
Dissipation Factor			IEC 60250
50 Hz	0.025		
60 Hz	0.025		

100 Hz	8.0E-3		
1 kHz	1.0E-3		
1 MHz	7.0E-3		
Comparative Tracking Index	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index (3.20 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (3.00 mm)	850	°C	IEC 60695-2-13
Oxygen Index	45	%	ISO 4589-2
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 μm)	58.0	%	ASTM D1003
Haze (2540 μm)	2.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	360 to 382	°C	
Middle Temperature	371 to 393	°C	
Front Temperature	382 to 404	°C	
Nozzle Temperature	377 to 399	°C	
Processing (Melt) Temp	382 to 404	°C	
Mold Temperature	135 to 163	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
NOTE			
1.	Tensile Bar		
2.	5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	Type I, 5.0 mm/min		
7.	1.3 mm/min		
8.	2.0 mm/min		
9.	2.6 mm/min		
10.	1.3 mm/min		
11.	80*10*4 sp=62mm		
12.	80*10*4		
13.	80*10*4		
14.	80*10*4		
15.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co., Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

