

ULTEM™ MD141 resin

Polyether Imide
SABIC Innovative Plastics Europe

Message:
Transparent, standard flow Polyetherimide (Tg 217C). ECO Conforming. UL94 V0 and 5VA listing. US FDA and EU Food Contact compliant.

General Information			
Features	ECO Compliant		
	Food Contact Acceptable		
Agency Ratings	EU Eco		
	EU Food Contact, Unspecified Rating		
	FDA Food Contact, Unspecified Rating		
RoHS Compliance	RoHS Compliant		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (360°C/5.0 kg)	13.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 to 0.70	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	1.3	%	
Equilibrium, 23°C, 50% RH	0.70	%	
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	140	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	105	MPa	
Break	85.0	MPa	
Tensile Strain			ISO 527-2/50
Yield	6.0	%	
Break	60	%	
Flexural Modulus ²	3300	MPa	ISO 178
Flexural Stress	160	MPa	ISO 178
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	10.0	mg	Internal Method
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			

-30°C ³	4.0	kJ/m ²	ISO 179/1eA
23°C ⁴	4.0	kJ/m ²	ISO 179/1eA
23°C	10	kJ/m ²	ISO 179/2C
Notched Izod Impact Strength ⁵			ISO 180/1A
-30°C	6.0	kJ/m ²	
23°C	6.0	kJ/m ²	
Unnotched Izod Impact Strength ⁶			ISO 180/1U
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed, 100 mm Span	200	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 100 mm Span	190	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	215	°C	ISO 306/A50
--	211	°C	ISO 306/B50
--	212	°C	ISO 306/B120
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
CLTE			ISO 11359-2
Flow : 23 to 150°C	5.0E-5	cm/cm/°C	
Transverse : 23 to 150°C	5.0E-5	cm/cm/°C	
Thermal Conductivity	0.24	W/m/K	ISO 8302
RTI Elec	170	°C	UL 746
RTI Imp	170	°C	UL 746
RTI Str	170	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Electric Strength			IEC 60243-1
0.800 mm, in Oil	33	kV/mm	
1.60 mm, in Oil	25	kV/mm	
3.20 mm, in Oil	16	kV/mm	
Relative Permittivity			IEC 60250
50 Hz	2.90		
60 Hz	2.90		
1 MHz	2.90		
Dissipation Factor			IEC 60250
50 Hz	5.0E-4		
60 Hz	5.0E-4		
1 MHz	6.0E-3		
2.45 GHz	2.5E-3		
Comparative Tracking Index			IEC 60112

--	150	V	
Solution B	100	V	
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index (3.20 mm)	960	°C	IEC 60695-2-12
Oxygen Index	47	%	ISO 4589-2
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	80.0 to 120	°C	
Rear Temperature	340 to 395	°C	
Middle Temperature	350 to 405	°C	
Front Temperature	360 to 415	°C	
Nozzle Temperature	350 to 405	°C	
Processing (Melt) Temp	370 to 410	°C	
Mold Temperature	140 to 180	°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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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



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