

ULTEM™ DH1004 resin

Polyether Imide

SABIC Innovative Plastics

Message:

High Temperature, Transparent, Polyetherimide Blend with Improved Ductility and Enhanced Hydrostability.

General Information			
UL YellowCard	E121562-100737020		
Features	Ductile		
	High Heat Resistance		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	10	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (360°C/5.0 kg)	14.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2900	MPa	ASTM D638
Tensile Strength			
Yield ²	95.0	MPa	ASTM D638
Yield	97.0	MPa	ISO 527-2/50
Break ³	90.0	MPa	ASTM D638
Break	80.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	7.0	%	ASTM D638
Yield	7.0	%	ISO 527-2/50
Break ⁵	85	%	ASTM D638
Break	80	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	3000	MPa	ASTM D790
-- ⁷	2800	MPa	ISO 178
Flexural Stress			
--	136	MPa	ISO 178
Yield, 50.0 mm Span ⁸	140	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	11	kJ/m ²	ISO 179/2C
Notched Izod Impact			

23°C	70	J/m	ASTM D256
-30°C ⁹	6.0	kJ/m ²	ISO 180/1A
23°C ¹⁰	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹¹			ISO 180/1U
-30°C	No Break		
23°C	No Break		
Reverse Notch Izod Impact (3.20 mm)	3300	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-20°C, Total Energy	88.0	J	
0°C, Total Energy	99.0	J	
23°C, Total Energy	88.0	J	
Instrumented Impact, Ductility			ASTM D3763
-20°C	90	%	
0°C	100	%	
23°C	100	%	
NBS Smoke Density - Flaming, Ds, 4 min	0.700		ASTM E662
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	214	°C	ASTM D648
0.45 MPa, Unannealed, 100 mm Span ¹²	205	°C	ISO 75-2/Be
1.8 MPa, Unannealed, 6.40 mm	204	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ¹³	190	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	219	°C	ISO 306/A50
--	212	°C	ISO 306/B50, ISO 306/B120
CLTE			
Flow : -20 to 150°C	5.6E-5	cm/cm/°C	ASTM E831
Flow : 23 to 150°C	5.0E-5	cm/cm/°C	ISO 11359-2
Transverse : -20 to 150°C	5.5E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 150°C	5.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.19	W/m/K	ASTM C177
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	V-0		UL 94
Oxygen Index	46	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	6.0 to 8.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	330 to 390	°C	
Middle Temperature	335 to 390	°C	

Front Temperature	345 to 390	°C
Nozzle Temperature	345 to 390	°C
Processing (Melt) Temp	355 to 390	°C
Mold Temperature	130 to 160	°C
Back Pressure	0.300 to 0.700	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE

1.	5.0 mm/min
2.	Type I, 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.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4
10.	80*10*4
11.	80*10*4
12.	120*10*4 mm
13.	120*10*4 mm

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