

ULTEM™ HU1000E resin

Polyether Imide
SABIC Innovative Plastics

Message:

Transparent, standard flow Polyetherimide (Tg 217C) with internal mold release. ECO Conforming. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant. EtO and steam sterilizable.

General Information			
Additive	Mold Release		
Features	Biocompatible		
	ECO Compliant		
	Ethylene Oxide Sterilizable		
	Food Contact Acceptable		
	Steam Sterilizable		
Uses	Medical/Healthcare Applications		
	Pharmaceuticals		
Agency Ratings	EU Eco		
	ISO 10993		
	USP Class VI		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	12	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (360°C/5.0 kg)	17.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	1.3	%	
Equilibrium, 23°C, 50% RH	0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3590	MPa	ASTM D638
--	3200	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	110	MPa	ASTM D638
Yield	105	MPa	ISO 527-2/5
Break ³	85.0	MPa	ASTM D638

Break	85.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	7.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/5
Break ⁵	60	%	ASTM D638
Break	60	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	3440	MPa	ASTM D790
-- ⁷	3300	MPa	ISO 178
Flexural Stress			
--	160	MPa	ISO 178
Yield, 50.0 mm Span ⁸	173	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	4.0	kJ/m ²	
23°C	4.0	kJ/m ²	
Charpy Unnotched Impact Strength ¹⁰			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact			
-30°C	55	J/m	ASTM D256
23°C	53	J/m	ASTM D256
-30°C ¹¹	6.0	kJ/m ²	ISO 180/1A
23°C ¹²	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1300	J/m	ASTM D4812
-30°C ¹³	No Break		ISO 180/1U
23°C ¹⁴	No Break		ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	38.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	207	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	199	°C	ASTM D648
1.8 MPa, Unannealed, 6.40 mm	201	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ¹⁵	190	°C	ISO 75-2/Ae
1.8 MPa, Unannealed, 64.0 mm Span ¹⁶	188	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	219	°C	ASTM D1525 ¹⁷
--	211	°C	ISO 306/B50
--	212	°C	ISO 306/B120
CLTE			

Flow : -40 to 150°C	5.5E-5	cm/cm/°C	ASTM E831
Flow : 23 to 150°C	5.5E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 150°C	5.5E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 150°C	5.5E-5	cm/cm/°C	ISO 11359-2
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	332 to 399	°C	
Middle Temperature	338 to 399	°C	
Front Temperature	343 to 399	°C	
Nozzle Temperature	343 to 399	°C	
Processing (Melt) Temp	349 to 399	°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.	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 sp=62mm		
10.	80*10*4 sp=62mm		
11.	80*10*4		
12.	80*10*4		
13.	80*10*4		
14.	80*10*4		
15.	120*10*4 mm		
16.	80*10*4 mm		
17.	Rate B (120°C/h), Loading 2 (50 N)		

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