

ULTEM™ 1110 resin

Polyether Imide

SABIC Innovative Plastics

Message:

Enhanced flow Polyetherimide (Tg 217C). ECO Conforming.

General Information			
UL YellowCard	E121562-101048292		
Features	ECO Compliant		
	Good Flow		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm³	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 to 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)	1600	J/m	ASTM D256
Gardner 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
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.750 mm	V-0		
3.00 mm	5VA		
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. | 2.6 mm/min |
| 5. | 2.6 mm/min |

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