

ULTEM™ 1100F resin

Polyether Imide

SABIC Innovative Plastics

Message:

Standard flow Polyetherimide (Tg 217C). ECO Conforming. US FDA and EU Food Contact compliant. UL94 V0, V2 and 5VA listing. Effective June 2007, this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HU1100.

General Information			
UL YellowCard	E121562-101048254		
Features	ECO Compliant		
	Food Contact Acceptable		
Agency Ratings	EU Eco		
	EU Food Contact, Unspecified Rating		
	FDA Food Contact, Unspecified Rating		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	8.8	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
Notched Izod Impact (23°C)	37	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	1500	J/m	ASTM D256
Gardner Impact (23°C)	21.7	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	199	°C	ASTM D648
RTI Elec	170	°C	UL 746
RTI Imp	170	°C	UL 746
RTI Str	170	°C	UL 746
Electrical	Nominal Value	Test Method	
Arc Resistance ⁶	PLC 5	ASTM D495	
Comparative Tracking Index (CTI)	PLC 4	UL 746	

High Amp Arc Ignition (HAI)	PLC 3	UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 2	UL 746
Hot-wire Ignition (HWI)	PLC 1	UL 746
Flammability	Nominal Value	Test Method
Flame Rating		UL 94
0.400 mm	V-2	
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	
6.	Tungsten Electrode	

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