

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	demoulding		
Features	Comply with ECO		
	Ethylene oxide disinfection		
	Biocompatibility		
	Compliance of Food Exposure		
	Disinfect with steam		
Uses	Drug		
	Medical/nursing supplies		
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 - 0.70	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	1.3	%	ISO 62
Equilibrium, 23°C, 50% RH	0.70	%	ISO 62
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
Fracture ³	85.0	MPa	ASTM D638

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Tensile Elongation			
Yield ⁴	7.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/5
Fracture ⁵	60	%	ASTM D638
Fracture	60	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	3440	MPa	ASTM D790
-- ⁷	3300	MPa	ISO 178
Flexural Stress			
--	160	MPa	ISO 178
Yield, 50.0mm 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	ISO 179/1eA
23°C	4.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ¹⁰			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
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, 3.20mm	207	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	199	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	201	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ¹⁵	190	°C	ISO 75-2/Ae
1.8 MPa, unannealed, 64.0mm 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
Linear thermal expansion coefficient			

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
Lateral: -40 to 150°C	5.5E-5	cm/cm/°C	ASTM E831
Horizontal: 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 - 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	332 - 399	°C	
Middle Temperature	338 - 399	°C	
Front Temperature	343 - 399	°C	
Nozzle Temperature	343 - 399	°C	
Processing (Melt) Temp	349 - 399	°C	
Mold Temperature	135 - 163	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	Type 1, 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.	标准 B (120°C/h), 载荷2 (50N)		

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