

ULTEM™ 1000E resin

Polyether Imide

SABIC Innovative Plastics

Message:

Transparent, standard flow Polyetherimide (Tg 217C) with internal mold release. ECO Conforming. US FDA and EU Food Contact compliant, NSF 51 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 HU1000E.

General Information			
Additive	demoulding		
Features	Comply with ECO		
	Compliance of Food Exposure		
Agency Ratings	EU Eco		
	FDA Food Exposure, Not Rated		
	NSF 51		
	European food contact, not rated		
Appearance	Clear/transparent		
Processing Method	Extrusion blow molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Water Absorption			ASTM D570
24 hr	0.25	%	ASTM D570
Equilibrium, 23°C	1.3	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3590	MPa	ASTM D638
Tensile Strength ² (Yield)	110	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	7.0	%	ASTM D638
Fracture	60	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	3520	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	165	MPa	ASTM D790
Poisson's Ratio	0.36		ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Unnotched Izod Impact (23°C)	1300	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, unannealed, 6.40mm	210	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	201	°C	ASTM D648
Vicat Softening Temperature	219	°C	ASTM D1525 ⁶
Linear thermal expansion coefficient			ASTM E831
Flow: -20 to 150°C	5.6E-5	cm/cm/°C	ASTM E831
Lateral: -20 to 150°C	5.4E-5	cm/cm/°C	ASTM E831
Thermal Conductivity	0.22	W/m/K	ASTM C177

Extrusion	Nominal Value	Unit
Drying Temperature	138 - 149	°C
Drying Time	4.0 - 6.0	hr
Suggested Max Moisture	0.010 - 0.020	%
Cylinder Zone 1 Temp.	324 - 349	°C
Cylinder Zone 2 Temp.	329 - 357	°C
Cylinder Zone 3 Temp.	329 - 357	°C
Cylinder Zone 4 Temp.	329 - 357	°C
Cylinder Zone 5 Temp.	329 - 357	°C
Adapter Temperature	329 - 357	°C
Die Temperature	327 - 357	°C

Extrusion instructions

Drying Time (Cumulative): 24 hrs
Head - Zone 6 - Top Temperature: 329 - 357 °C
Head - Zone 7 - Bottom Temperature: 329 - 357 °C
Melt Temperature (Parison): 321 - 357 °C
Mold Temperature: 66 - 177 °C
Screw Speed: 10 - 70 rpm

NOTE

- 5.0 mm/min
- Type 1, 5.0 mm/min
- Type 1, 5.0 mm/min
- 2.6 mm/min
- 2.6 mm/min
- 标准 B (120°C/h), 载荷2 (50N)

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