

ULTEM™ 9075 resin

Polyether Imide
SABIC Innovative Plastics

Message:
High flow Polyetherimide blend. Meets FAR 25.853 and OSU 65/65 with low toxicity, smoke, and flame evolution. ECO Conforming.

General Information			
Features	Low smoke		
	Low toxicity		
	Comply with ECO		
	High liquidity		
Agency Ratings	EU Eco		
	FAR 25.853		
	OSU 65/65		
Processing Method	Profile extrusion molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (295°C/6.6 kg)	2.4	g/10 min	ASTM D1238
Molding Shrinkage			Internal method
Flow: 3.20mm	0.50 - 0.70	%	Internal method
Transverse flow: 3.20mm	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3310	MPa	ASTM D638
Tensile Strength ² (Yield)	96.5	MPa	ASTM D638
Tensile Elongation ³ (Break)	85	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	3240	MPa	ASTM D790
Flexural Strength ⁵			ASTM D790
Yield, 100mm span	145	MPa	ASTM D790
Fracture, 100mm span	141	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	69	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	2100	J/m	ASTM D256
Dart Drop Impact (23°C)	35.3	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	189	°C	ASTM D648

Flammability	Nominal Value	Unit	Test Method
FAA Flammability ⁶	SECT A-1		FAR 25.853
Halogen Content	0		Internal method
OSU total heat release ⁷	10.0	kW · min/m ²	FAR 25.853
Vertical Burn Test			FAR 25.853
Test a (60 s), passes at	1.0	sec	FAR 25.853
Test b (12 s), passes at	0.0	sec	FAR 25.853
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	10	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	338 - 360	°C	
Middle Temperature	343 - 366	°C	
Front Temperature	349 - 371	°C	
Nozzle Temperature	349 - 371	°C	
Processing (Melt) Temp	349 - 371	°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	
Extrusion	Nominal Value	Unit	
Drying Temperature	130 - 140	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	80.0 - 100	°C	
Cylinder Zone 1 Temp.	280 - 300	°C	
Cylinder Zone 2 Temp.	295 - 320	°C	
Cylinder Zone 3 Temp.	305 - 330	°C	
Cylinder Zone 4 Temp.	310 - 335	°C	
Adapter Temperature	285 - 335	°C	
Melt Temperature	295 - 330	°C	
Die Temperature	275 - 330	°C	
Calibration Temp, First	140 - 170	°C	
Calibration Temp, Second	90.0 - 130	°C	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	2.6 mm/min		
5.	2.6 mm/min		

6.	Method A/B
7.	2 minute test

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