

ULTEM™ AR9110 resin

Polyether Imide
SABIC Innovative Plastics

Message:

10% Glass fiber filled, enhanced flow Polyetherimide (Tg 217C). Meets FAR 25.853 and OSU 65/65 with low toxicity, smoke, and flame evolution. ECO Conforming.

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	ECO Compliant		
	Flame Retardant		
	Low Smoke Emission		
	Low Toxicity		
Agency Ratings	FAR 25.853		
	OSU 65/65		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	13	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	4480	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	106	MPa	
Break	102	MPa	
Tensile Elongation ³ (Break)	8.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	4830	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	189	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	59	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	400	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	208	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
FAA Flammability ⁶	NATURAL		FAR 25.853
NBS Smoke Density			ASTM E662
Flaming, Dmax	5.00		
Flaming, Ds, 1.5 min	0.00		
Flaming, Ds, 4 min	5.00		

OSU Peak Heat Release Rate ⁷	36.0	kW/m ²	FAR 25.853
OSU Total Heat Release ⁸	6.00	kW · min/m ²	FAR 25.853
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	343 to 366	°C	
Middle Temperature	354 to 377	°C	
Front Temperature	366 to 388	°C	
Nozzle Temperature	360 to 382	°C	
Processing (Melt) Temp	366 to 388	°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

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|----|--------------------|
| 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. | Method A/B |
| 7. | 5 minute test |
| 8. | 2 minute test |

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