

ULTEM™ 1285 resin

Polyether Imide
SABIC Innovative Plastics

Message:
Transparent Polyetherimide blend. ECO Conforming. US FDA and EU Food Contact Compliant in recognized colors.

General Information			
Features	ECO Compliant		
	Food Contact Acceptable		
Agency Ratings	EU Eco		
	EU Food Contact, Unspecified Rating		
	FDA Food Contact, Unspecified Rating		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831)		
	Flexural DMA (ASTM D4065)		
	Tensile Stress vs. Strain (ASTM D638)		
	Thermal Conductivity vs. Temperature (ASTM E1530)		
	Viscosity vs. Shear Rate (ASTM D3835)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (295°C/6.6 kg)	8.1	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.60 to 0.70	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3380	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	110	MPa	
Break	82.7	MPa	
Tensile Elongation ³ (Break)	60	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	3380	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)	27	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	950	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	40.7	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	165	°C	ASTM D648
Vicat Softening Temperature	181	°C	ASTM D1525 ⁶
CLTE			ASTM E831
Flow : -40 to 40°C	4.9E-5	cm/cm/°C	
Transverse : -40 to 40°C	4.9E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121 to 149	°C	
Drying Time	4.0 to 8.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	282 to 316	°C	
Middle Temperature	288 to 321	°C	
Front Temperature	293 to 327	°C	
Nozzle Temperature	299 to 332	°C	
Processing (Melt) Temp	299 to 332	°C	
Mold Temperature	93.3 to 149	°C	
Back Pressure	0.689 to 1.38	MPa	
Screw Speed	50 to 100	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.	Rate B (120°C/h), Loading 2 (50 N)		

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