

ULTEM™ DU242 resin

Polyether Imide
SABIC Innovative Plastics

Message:
Enhanced low temperature impact, high flow Polyetherimide blend. ECO Conforming.

General Information			
Features	ECO Compliant		
	High Flow		
	Low Temperature Impact Resistance		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	30	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2590	MPa	ASTM D638
Tensile Strength ² (Yield)	74.5	MPa	ASTM D638
Tensile Elongation ³ (Break)	67	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	2520	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 100 mm Span)	112	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	180	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	2000	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	160	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	135	°C	
Drying Time	4.0 to 6.0	hr	
Drying Time, Maximum	12	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	310 to 332	°C	
Middle Temperature	321 to 343	°C	
Front Temperature	332 to 354	°C	
Nozzle Temperature	327 to 349	°C	
Processing (Melt) Temp	332 to 354	°C	
Mold Temperature	93.3 to 135	°C	

Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	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 |

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