ULTEM*® *ATX100

Americas: COMMERCIAL

Higher impact, high flow Polyetherimide blend. ECO Conforming, UL94 HB Listing.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	69	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	80	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	107	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2540	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	2083	J/m	ASTM D 4812
Izod Impact, notched, 23°C	427	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	157	°C	ASTM D 648
Relative Temp Index, Elec	115	°C	UL 746B
Relative Temp Index, Mech w/impact	115	°C	UL 746B
Relative Temp Index, Mech w/o impact	115	°C	UL 746B
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 295°C/6.6 kgf	6	g/10 min	ASTM D 1238
ELECTRICAL			
Hot Wire Ignition {PLC)	1	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.8	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	135	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	330 - 355	°C
Nozzle Temperature	325 - 350	°C
Front - Zone 3 Temperature	330 - 355	°C
Middle - Zone 2 Temperature	320 - 345	°C
Rear - Zone 1 Temperature	310 - 330	°C
Mold Temperature	95 - 135	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm