



ULTEM™ Resin 1285
Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1120	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	840	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	34400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1680	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	34400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	2	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	96	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	414	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	181	°C	ASTM D 1525
HDT, 1.82 MPa, 6.4 mm, unannealed	165	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.86E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.86E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.7	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	8.1	g/10 min	ASTM D 1238





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4 - 8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 330	°C
Nozzle Temperature	300 - 330	°C
Front - Zone 3 Temperature	295 - 325	°C
Middle - Zone 2 Temperature	290 - 320	°C
Rear - Zone 1 Temperature	280 - 315	°C
Mold Temperature	95 - 150	°C
Back Pressure	0.7 - 1.4	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

