



ULTEM™ Resin 1000F3SP

Europe-Africa-Middle East: COMMERCIAL

ULTEM™ 1000F3SP powder is a RoHS compliant polyetherimide (PEI) powder offering a glass transition temperature (Tg) of 217°C. This FDA compliant powder is available in a spherical shape with an average particle size (D50) of 15 micron and a maximum particle size (D100) of 75 micron.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Hardness, Rockwell M	109	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	10	mg/1000cy	ASTM D 1044
Tensile Stress, yield, 50 mm/min	105	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	60	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	160	MPa	ISO 178
Flexural Modulus, 2 mm/min	3300	MPa	ISO 178
Hardness, H358/30	140	MPa	ISO 2039-1
IMPACT			
Gardner, 23°C	367	cm-kgf	ASTM D 3029
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL			
Thermal Conductivity	0.24	W/m-°C	ISO 8302
CTE, 23°C to 150°C, flow	5.E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	5.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	211	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	200	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.5 - 0.7	%	SABIC Method
Density	1.27	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1.25	%	ISO 62





ULTEM™ Resin 1000F3SP

Europe-Africa-Middle East: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption (23°C / 50% RH)	0.7	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	13	cm ³ /10 min	ISO 1133
Mean Resin Particle Size	15	micrometer	SABIC Method
Bulk Density	780	kg/m ³	ISO 1183
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Dielectric Strength, in oil, 0.8 mm	33	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	25	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	16	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.9	-	IEC 60250
Dissipation Factor, 50/60 Hz	0	-	IEC 60250
Dissipation Factor, 1 MHz	0.006	-	IEC 60250
Dissipation Factor, 2450 MHz	0.002	-	IEC 60250
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
FLAME CHARACTERISTICS			
Oxygen Index (LOI)	47	%	ISO 4589





ULTEM™ Resin 1000F3SP

Europe-Africa-Middle East: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 400	°C
Nozzle Temperature	345 - 400	°C
Front - Zone 3 Temperature	345 - 400	°C
Middle - Zone 2 Temperature	340 - 400	°C
Rear - Zone 1 Temperature	330 - 400	°C
Mold Temperature	135 - 165	°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

