



ULTEM™ Resin 9075
Americas: COMMERCIAL

High flow Polyetherimide blend. Meets FAR 25.853 and OSU 65/65 with low toxicity, smoke, and flame evolution. ECO Conforming.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	980	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	85	%	ASTM D 638
Tensile Modulus, 5 mm/min	33700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1470	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 2.6 mm/min, 100 mm span	1440	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	33000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	212	cm-kgf/cm	ASTM D 256
Gardner, 23°C	359	cm-kgf	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	188	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	2.4	g/10 min	ASTM D 1238
Halogen Content	0	%	SABIC Method
FLAME CHARACTERISTICS			
FAA Flammability, FAR 25.853 A/B	SECT A-1	-	FAR 25.853
OSU total heat release (2 minute test)	10	kW-min/m ²	FAR 25.853
Vertical Burn a (60s) passes at	1	sec	FAR 25.853
Vertical Burn b (12s) passes at	0	sec	FAR 25.853





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	135	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	10	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	350 - 370	°C
Nozzle Temperature	350 - 370	°C
Front - Zone 3 Temperature	350 - 370	°C
Middle - Zone 2 Temperature	345 - 365	°C
Rear - Zone 1 Temperature	340 - 360	°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
Profile Extrusion		
Drying Temperature	130 - 140	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 330	°C
Barrel - Zone 1 Temperature	280 - 300	°C
Barrel - Zone 2 Temperature	295 - 320	°C
Barrel - Zone 3 Temperature	305 - 330	°C
Barrel - Zone 4 Temperature	310 - 335	°C
Hopper Temperature	80 - 100	°C
Adapter Temperature	285 - 335	°C
Die Temperature	275 - 330	°C
Calibrator Temperature	140 - 170	°C

