



**ULTEM™ Resin ATX200R**  
**Americas: COMMERCIAL**

High flow Polyetherimide blend with internal mold release. ECO Conforming, UL94 V0 Listing.

| TYPICAL PROPERTIES <sup>1</sup>               | TYPICAL VALUE | Unit                | Standard     |
|-----------------------------------------------|---------------|---------------------|--------------|
| <b>MECHANICAL</b>                             |               |                     |              |
| Tensile Stress, yld, Type I, 5 mm/min         | 980           | kgf/cm <sup>2</sup> | ASTM D 638   |
| Tensile Strain, brk, Type I, 5 mm/min         | 70            | %                   | ASTM D 638   |
| Flexural Stress, yld, 2.6 mm/min, 100 mm span | 1470          | kgf/cm <sup>2</sup> | ASTM D 790   |
| Flexural Modulus, 2.6 mm/min, 100 mm span     | 32300         | kgf/cm <sup>2</sup> | ASTM D 790   |
| <b>IMPACT</b>                                 |               |                     |              |
| Izod Impact, notched, 23°C                    | 5             | cm-kgf/cm           | ASTM D 256   |
| Izod Impact, Reverse Notched, 3.2 mm          | 217           | cm-kgf/cm           | ASTM D 256   |
| <b>THERMAL</b>                                |               |                     |              |
| HDT, 1.82 MPa, 6.4 mm, unannealed             | 190           | °C                  | ASTM D 648   |
| <b>PHYSICAL</b>                               |               |                     |              |
| Specific Gravity                              | 1.26          | -                   | ASTM D 792   |
| Mold Shrinkage, flow, 3.2 mm (5)              | 0.5 - 0.7     | %                   | SABIC Method |
| Melt Flow Rate, 337°C/6.6 kgf                 | 26.5          | g/10 min            | ASTM D 1238  |





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| PROCESSING PARAMETERS       | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| 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   |

