



ULTEM™ Resin 1000

Asia Pacific: COMMERCIAL

Transparent, standard flow Polyetherimide (Tg 217C). UL94 V0, V2 and 5VA listing. Effective June, 2007 this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HU1000. For US FDA and EU Food Contact compliance, please select 1000F resin.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Extrusion Blow Molding		
Drying Temperature	140 - 150	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.01 - 0.02	%
Melt Temperature (Parison)	320 - 355	°C
Barrel - Zone 1 Temperature	325 - 350	°C
Barrel - Zone 2 Temperature	330 - 355	°C
Barrel - Zone 3 Temperature	330 - 355	°C
Barrel - Zone 4 Temperature	330 - 355	°C
Adapter - Zone 5 Temperature	330 - 355	°C
Head - Zone 6 - Top Temperature	330 - 355	°C
Head - Zone 7 - Bottom Temperature	330 - 355	°C
Screw Speed	10 - 70	rpm
Mold Temperature	65 - 175	°C
Die Temperature	325 - 355	°C

- DO NOT purge with low melting styrene or acrylic resins.
- Up to 30% Regrind has been successfully reprocessed.

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

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