



ULTEM™ Resin MD131
Asia Pacific: COMMERCIAL

Transparent, high flow Polyetherimide (Tg 217C). ECO Conforming. US FDA and EU Food Contact Compliant.

| TYPICAL PROPERTIES ¹ | TYPICAL VALUE | Unit | Standard |
|---|---------------|-----------|-------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 5 mm/min | 110 | MPa | ASTM D 638 |
| Tensile Stress, brk, Type I, 5 mm/min | 105 | MPa | ASTM D 638 |
| Tensile Strain, yld, Type I, 5 mm/min | 7 | % | ASTM D 638 |
| Tensile Strain, brk, Type I, 5 mm/min | 60 | % | ASTM D 638 |
| Tensile Modulus, 5 mm/min | 3590 | MPa | ASTM D 638 |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 167 | MPa | ASTM D 790 |
| Flexural Stress, yld, 2.6 mm/min, 100 mm span | 165 | MPa | ASTM D 790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 3550 | MPa | ASTM D 790 |
| Flexural Modulus, 2.6 mm/min, 100 mm span | 3520 | MPa | ASTM D 790 |
| 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 Stress, break, 50 mm/min | 85 | 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 | | | |
| Izod Impact, unnotched, 23°C | 1335 | J/m | ASTM D 4812 |
| Izod Impact, notched, 23°C | 32 | J/m | ASTM D 256 |

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| IMPACT | | | |
| Izod Impact, notched, -30°C | 35 | J/m | ASTM D 256 |
| Izod Impact, Reverse Notched, 3.2 mm Gardner, 23°C | 1174 | J/m | ASTM D 256 |
| Izod Impact, notched 80*10*4 +23°C | 33 | J | SABIC Method |
| Instrumented Impact Total Energy, 23°C | 33 | J | ASTM D 3763 |
| Izod Impact, unnotched 80*10*4 -30°C | NB | kJ/m ² | ISO 180/1U |
| Izod Impact, unnotched 80*10*4 +23°C | NB | kJ/m ² | ISO 180/1U |
| Izod Impact, notched 80*10*4 +23°C | 5 | kJ/m ² | ISO 180/1A |
| Izod Impact, notched 80*10*4 -30°C | 5 | kJ/m ² | ISO 180/1A |
| Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm | 3 | kJ/m ² | ISO 179/1eA |
| THERMAL | | | |
| Vicat Softening Temp, Rate B/50 | 218 | °C | ASTM D 1525 |
| HDT, 0.45 MPa, 3.2 mm, unannealed | 205 | °C | ASTM D 648 |
| HDT, 1.82 MPa, 3.2mm, unannealed | 197 | °C | ASTM D 648 |
| HDT, 0.45 MPa, 6.4 mm, unannealed | 207 | °C | ASTM D 648 |
| HDT, 1.82 MPa, 6.4 mm, unannealed | 198 | °C | ASTM D 648 |
| CTE, -40°C to 150°C, flow | 5.5E-05 | 1/°C | ASTM E 831 |
| CTE, -40°C to 150°C, xflow | 5.5E-05 | 1/°C | ASTM E 831 |
| Thermal Conductivity | 0.22 | W/m-°C | ASTM C 177 |
| Thermal Conductivity | 0.21 | 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 |
| Ball Pressure Test, 125°C +/- 2°C | Passes | - | IEC 60695-10-2 |
| Vicat Softening Temp, Rate A/50 | 215 | °C | ISO 306 |
| Vicat Softening Temp, Rate B/50 | 211 | °C | ISO 306 |

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| THERMAL | | | |
| Vicat Softening Temp, Rate B/120 | 212 | °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 |
| HDT/af, 1.8 MPa Flatw 80*10*4 sp=64mm | 190 | °C | ISO 75/af |
| PHYSICAL | | | |
| Specific Gravity | 1.27 | - | ASTM D 792 |
| Water Absorption, 24 hours | 0.25 | % | ASTM D 570 |
| Water Absorption, equilibrium, 23C | 1.25 | % | ASTM D 570 |
| Mold Shrinkage on Tensile Bar, flow (2) (5) | 0.5 - 0.7 | % | SABIC Method |
| 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, 337°C/6.6 kgf | 17.8 | g/10 min | ASTM D 1238 |
| Density | 1.27 | g/cm ³ | ISO 1183 |
| Water Absorption, (23°C/sat) | 1.25 | % | ISO 62 |
| Moisture Absorption (23°C / 50% RH) | 0.7 | % | ISO 62 |
| Melt Volume Rate, MVR at 340°C/5.0 kg | 13 | cm ³ /10 min | ISO 1133 |
| Melt Volume Rate, MVR at 360°C/5.0 kg | 25 | cm ³ /10 min | ISO 1133 |
| ELECTRICAL | | | |
| Volume Resistivity | 1.E+17 | Ohm-cm | ASTM D 257 |
| Dielectric Strength, in air, 1.6 mm | 32.6 | kV/mm | ASTM D 149 |
| Dielectric Strength, in oil, 1.6 mm | 27.9 | kV/mm | ASTM D 149 |
| Relative Permittivity, 1 kHz | 3.15 | - | ASTM D 150 |
| Dissipation Factor, 1 kHz | 0.0013 | - | ASTM D 150 |
| Dissipation Factor, 2450 MHz | 0.0025 | - | ASTM D 150 |
| Volume Resistivity | 1.E+15 | Ohm-cm | IEC 60093 |
| Surface Resistivity, ROA | >1.E+15 | Ohm | 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 |

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| ELECTRICAL | | | |
| 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 | 0.0005 | - | IEC 60250 |
| Dissipation Factor, 1 MHz | 0.006 | - | IEC 60250 |
| Dissipation Factor, 2450 MHz | 0.0025 | - | IEC 60250 |
| Comparative Tracking Index | 150 | V | IEC 60112 |
| Comparative Tracking Index, M | 100 | V | IEC 60112 |
| Relative Permittivity, 50/60 Hz | 2.9 | - | IEC 60250 |
| FLAME CHARACTERISTICS | | | |
| Oxygen Index (LOI) | 44 | % | ASTM D 2863 |
| Glow Wire Flammability Index 960°C, passes at | 3.2 | mm | IEC 60695-2-12 |
| Oxygen Index (LOI) | 47 | % | ISO 4589 |

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| 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 |

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