



## ULTEM™ Resin 1285

### Americas: COMMERCIAL

Transparent Polyetherimide blend. ECO Conforming. US FDA and EU Food Contact Compliant in recognized colors.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	1120	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	840	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	34400	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1680	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	34400	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	2	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	96	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	414	cm-kgf	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	181	°C	ASTM D 1525
HDT, 1.82 MPa, 6.4 mm, unannealed	165	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.86E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.86E-05	1/°C	ASTM E 831
<b>PHYSICAL</b>			
Specific Gravity	1.29	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.7	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	8.1	g/10 min	ASTM D 1238

(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.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	120 - 150	°C
Drying Time	4 - 8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 330	°C
Nozzle Temperature	300 - 330	°C
Front - Zone 3 Temperature	295 - 325	°C
Middle - Zone 2 Temperature	290 - 320	°C
Rear - Zone 1 Temperature	280 - 315	°C
Mold Temperature	95 - 150	°C
Back Pressure	0.7 - 1.4	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

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