



## ULTEM™ Resin ATX200F

### Americas: COMMERCIAL

High flow Polyetherimide blend. ECO Conforming, UL94 V0 Listing. US FDA Food Contact compliant.

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, unnotched, 23°C	212	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	272	cm-kgf/cm	ASTM D 256
<b>THERMAL</b>			
HDT, 1.82 MPa, 6.4 mm, unannealed	190	°C	ASTM D 648
Relative Temp Index, Elec	115	°C	UL 746B
Relative Temp Index, Mech w/impact	115	°C	UL 746B
Relative Temp Index, Mech w/o impact	115	°C	UL 746B
<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	24	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Hot Wire Ignition (PLC)	0	PLC Code	UL 746A
High Ampere Arc Ign, surface (PLC)	4	PLC Code	UL 746A
Comparative Tracking Index (UL) (PLC)	4	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-2 Flame Class Rating (3)	0.76	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	1.49	mm	UL 94

(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	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

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