



## ULTEM™ Resin D9065

### Americas: COMMERCIAL

Polyetherimide blend. Meets FAR 25.853 and OSU 65/65 with low toxicity, smoke, and flame evolution. ECO Conforming.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	890	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	890	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	100	%	ASTM D 638
Tensile Modulus, 5 mm/min	31600	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1260	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	31600	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	15	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	9	cm-kgf/cm	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	206	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	691	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -30	594	cm-kgf	ASTM D 3763
<b>PHYSICAL</b>			
Specific Gravity	1.32	-	ASTM D 792
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	15.6	g/10 min	ASTM D 1238
<b>FLAME CHARACTERISTICS</b>			
OSU total heat release (2 minute test)	10	kW-min/m <sup>2</sup>	FAR 25.853
OSU peak heat release rate (5 minute test)	50	kW/m <sup>2</sup>	FAR 25.853

(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)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	340 - 360	°C
Nozzle Temperature	330 - 355	°C
Front - Zone 3 Temperature	340 - 360	°C
Middle - Zone 2 Temperature	325 - 350	°C
Rear - Zone 1 Temperature	315 - 340	°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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