

Ultem* Resin 3451

Americas: COMMERCIAL

45% Glass fiber and mineral filled, standard flow Polyetherimide (Tg 217C) with enhanced dimensional stability. ECO Conforming.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	131	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.4	%	ASTM D 638
Tensile Modulus, 5 mm/min	11720	MPa	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	179	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	11720	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	229	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	212	°C	ASTM D 648
CTE, -20°C to 150°C, flow	1.08E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, xflow	2.16E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.66	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.15 - 0.25	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.3 - 0.5	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	2.7	g/10 min	ASTM D 1238

Source GMD, last updated:01/13/2000

Processing

Parameter	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

Source GMD, last updated:01/13/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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.

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