

## Ultem\* Resin 9076

Americas: COMMERCIAL

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

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
	Value	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	96	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	92	%	ASTM D 638
Tensile Modulus, 5 mm/min	3300	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	144	MPa	ASTM D 790
Flexural Stress, brk, 2.6 mm/min, 100 mm span	141	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3240	MPa	ASTM D 790
<b>IMPACT</b>			
	Value	Unit	Standard
Izod Impact, notched, 23°C	74	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2136	J/m	ASTM D 256
Gardner, 23°C	35	J	ASTM D 3029
<b>THERMAL</b>			
	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	188	°C	ASTM D 648
<b>PHYSICAL</b>			
	Value	Unit	Standard
Specific Gravity	1.3	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	1.4	g/10 min	ASTM D 1238
Halogen Content	0	%	SABIC Method
<b>FLAME CHARACTERISTICS</b>			
	Value	Unit	Standard
FAA Flammability, FAR 25.853 A/B	SECT A-1	-	FAR 25.853
OSU total heat release (2 minute test)	10	kW-min/m <sup>2</sup>	FAR 25.853
Vertical Burn a (60s) passes at	1	sec	FAR 25.853
Vertical Burn b (12s) passes at	0	sec	FAR 25.853

Source GMD, last updated:01/13/2000

### Processing

Parameter	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

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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