

ULTEM™ RESIN AUR200G6

REGION EUROPE

DESCRIPTION

The data listed in this data sheet are the lower specification limits, apart from the MFR, CTE, HDT at 1.8 MPa, Density, Tensile strain, Water Absorption, Thermal Conductivity and Shrinkage which are typical data.

The MVR of this material at 337 degrees C/6.7 kgf will have a specification between 3 and 7.5 (MFR: 4.2-10.5)

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	120	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	8000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	180	MPa	ISO 178
Flexural Modulus, 2 mm/min	6500	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
THERMAL			
Thermal Conductivity	0.3	W/m-°C	ISO 8302
CTE, 23°C to 150°C, flow	2.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	6.E-05	1/°C	ISO 11359-2
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	205	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	200	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.2 – 0.4	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	7.5	g/10 min	ASTM D 1238
Density	1.53	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.9	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.5	%	ISO 62
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	370 – 410	°C	
Nozzle Temperature	360 – 410	°C	
Front - Zone 3 Temperature	370 – 420	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	360 – 410	°C	
Rear - Zone 1 Temperature	350 – 400	°C	
Hopper Temperature	80 – 120	°C	
Mold Temperature	140 – 180	°C	

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