

Ultem* Resin 1285

Americas: COMMERCIAL

Transparent Polyetherimide blend. ECO Conforming. US FDA and EU Food Contact Compliant in recognized colors.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	110	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	82	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	60	%	ASTM D 638
Tensile Modulus, 5 mm/min	3370	MPa	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	165	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3370	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	26	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	950	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	40	J	ASTM D 3763
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	181	°C	ASTM D 1525
HDT, 1.82 MPa, 6.4 mm, unannealed	165	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.86E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.86E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.29	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.7	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	8.1	g/10 min	ASTM D 1238

Source GMD, last updated:01/12/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4 - 8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 330	°C
Nozzle Temperature	300 - 330	°C
Front - Zone 3 Temperature	295 - 325	°C
Middle - Zone 2 Temperature	290 - 320	°C
Rear - Zone 1 Temperature	280 - 315	°C
Mold Temperature	95 - 150	°C
Back Pressure	0.7 - 1.4	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

Source GMD, last updated:01/12/2000

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.

Disclaimer : THE MATERIALS AND PRODUCTS OF THE BUSINESSES MAKING UP THE SABIC INNOVATIVE PLASTICS COMPANY, ITS SUBSIDIARIES AND AFFILIATES ("SABIC IP"), ARE SOLD SUBJECT TO SABIC IP' S STANDARD CONDITIONS OF SALE, WHICH ARE INCLUDED IN THE APPLICABLE DISTRIBUTOR OR OTHER SALES AGREEMENT, PRINTED ON THE BACK OF ORDER ACKNOWLEDGMENTS AND INVOICES, AND AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION, RECOMMENDATIONS, OR ADVICE CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SABIC IP MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (I) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (II) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SABIC IP MATERIALS, PRODUCTS, RECOMMENDATIONS OR ADVICE. EXCEPT AS PROVIDED IN SABIC IP' S STANDARD CONDITIONS OF SALE, SABIC IP AND ITS REPRESENTATIVES SHALL IN NO EVENT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS MATERIALS OR PRODUCTS DESCRIBED HEREIN. Each user bears full responsibility for making its own determination as to the suitability of SABIC IP' s materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating SABIC IP materials or products will be safe and suitable for use under end-use conditions. Nothing in this or any other document, nor any oral recommendation or advice, shall be deemed to alter, vary, supersede, or waive any provision of SABIC IP' s Standard Conditions of Sale or this Disclaimer, unless any such modification is specifically agreed to in a writing signed by SABIC IP. No statement contained herein concerning a possible or suggested use of any material, product or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of SABIC Innovative Plastics Company or any of its subsidiaries or affiliates covering such use or design, or as a recommendation for the use of such material, product or design in the infringement of any patent or other intellectual property right

* Ultem is a trademark of the SABIC Innovative Plastics Company

© 1997-2008 SABIC Innovative Plastics Company. All rights reserved