

Ultem* Resin 8015

Americas: COMMERCIAL

High flow Polyetherimide blend. Meets FAR 25.853 and OSU 100/100 with low toxicity, smoke, and flame evolution. ECO Conforming.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	96	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	89	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	80	%	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 Modulus, 2.6 mm/min, 100 mm span	3170	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	64	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	2082	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	71	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	56	J	ASTM D 3763
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	187	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.4 - 0.5	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 295°C/6.6 kgf	2.7	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
OSU total heat release (2 minute test)	45	kW-min/m ²	FAR 25.853
OSU peak heat release rate (5 minute test)	80	kW/m ²	FAR 25.853

Source GMD, last updated:01/13/2000

Processing

Parameter	Value	Unit
Injection Molding		
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
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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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