



PROFESSIONAL PLASTICS, INC.

Leading Global Supplier of Engineered Plastic Shapes

USA Phone (888) 995-7767 – Asia Phone +65-6266-6193

E-Mail: sales@proplas.com Website: www.professionalplastics.com

Duratron® PEI U1000 Polyetherimide, unfilled, extruded

Duratron® U1000 polyetherimide is an amorphous, high-performance polymer with exceptional flame and heat resistance. It performs continuously to 340°F (171°C), making it ideal for high strength/high heat applications, and those requiring consistent dielectric properties over a wide frequency range. It is hydrolysis resistant, highly resistant to acidic solutions and capable of withstanding multiple autoclaving cycles.

Duratron® U1000 is FDA and USP Class VI compliant. FDA compliant colors of Ultem are also available on a custom basis. Duratron® U1000 commonly is machined into parts for reusable medical devices, analytical instrumentation, electrical/electronic insulators and a variety of structural components requiring high strength and rigidity at elevated temperatures.

Physical Properties	Metric	English	Comments
Specific Gravity	1.28 g/cc	1.28 g/cc	ASTM D792
Water Absorption	0.250 %	0.250 %	Immersion, 24hr; ASTM D570(2)
Water Absorption at Saturation	1.25 %	1.25 %	Immersion; ASTM D570(2)
Mechanical Properties	Metric	English	Comments
Hardness, Rockwell M	112	112	ASTM D785
Hardness, Rockwell R	125	125	ASTM D785
Hardness, Shore D	86	86	ASTM D2240
Tensile Strength	117 MPa	17000 psi	ASTM D638
Tensile Strength at 150°C (300°F)	86.2 MPa	12500 psi	ASTM D638
Tensile Strength at 65°C (150°F)	103 MPa	15000 psi	ASTM D638
Elongation at Break	60.0 %	60.0 %	ASTM D638
Tensile Modulus	3.45 GPa	500 ksi	ASTM D638
Flexural Modulus	3.45 GPa	500 ksi	ASTM D790
Flexural Yield Strength	138 MPa	20000 psi	ASTM D790
Compressive Strength	152 MPa	22000 psi	10% Def.; ASTM D695
Compressive Modulus	3.31 GPa	480 ksi	ASTM D695
Shear Strength	103 MPa	15000 psi	ASTM D732
Coefficient of Friction	0.420	0.420	Dry vs. Steel; QTM55007
K (wear) Factor	5840 x 10 ⁻⁸ mm ³ /N-M	2900 x 10 ⁻¹⁰ in ³ -min/ft-lb-hr	QTM 55010
Limiting Pressure Velocity	0.06568 MPa-m/sec	1875 psi-ft/min	4:1 safety factor; QTM 55007
Izod Impact, Notched	0.267 J/cm	0.500 ft-lb/in	ASTM D256 Type A
Electrical Properties	Metric	English	Comments
Surface Resistivity per Square	>= 1.00e+13 ohm	>= 1.00e+13 ohm	EOS/ESD S11.11
Dielectric Constant	3.15	3.15	ASTM D150
	@Frequency 1e+6 Hz	@Frequency 1e+6 Hz	
Dielectric Strength	32.7 kV/mm	830 kV/in	Short Term; ASTM D149
Dissipation Factor	0.00130	0.00130	ASTM D150
	@Frequency 1e+6 Hz	@Frequency 1e+6 Hz	

Thermal Properties	Metric	English	Comments
CTE, linear	55.8 $\mu\text{m}/\text{m}\cdot\text{C}$ @Temperature - 40.0 - 149 $^{\circ}\text{C}$	31.0 $\mu\text{in}/\text{in}\cdot\text{F}$ @Temperature -40.0 - 300 $^{\circ}\text{F}$	ASTM E831
Thermal Conductivity	0.177 $\text{W}/\text{m}\cdot\text{K}$	1.23 $\text{BTU}\cdot\text{in}/\text{hr}\cdot\text{ft}^2\cdot\text{F}$	ASTM F433
Maximum Service Temperature, Air	171 $^{\circ}\text{C}$	340 $^{\circ}\text{F}$	Long Term
Deflection Temperature at 1.8 MPa (264 psi)	204 $^{\circ}\text{C}$	400 $^{\circ}\text{F}$	ASTM D648
Glass Transition Temp, Tg	210 $^{\circ}\text{C}$	410 $^{\circ}\text{F}$	ASTM D3418
Flammability, UL94	V-0	V-0	1/8 inch (Estimated Rating)
Compliance Properties	Metric	English	Comments
3A-Dairy	No	No	
Canada AG	Yes	Yes	Black Only
FDA	Yes	Yes	
NSF	Yes	Yes	STD 51, Natural Only
USDA	Yes	Yes	
USP Class VI	Yes	Yes	
Chemical Resistance Properties	Metric	English	Comments
Acids, Strong (pH 1-3)	Unacceptable	Unacceptable	
Acids, Weak	Acceptable	Acceptable	
Alcohols	Acceptable	Acceptable	
Alkalies, Strong (pH 11-14)	Unacceptable	Unacceptable	
Alkalies, Weak	Acceptable	Acceptable	
Chlorinated Solvents	Unacceptable	Unacceptable	
Conductive / Static Dissipative	No	No	
Continuous Sunlight	Acceptable	Acceptable	
Hot Water / Steam	Acceptable	Acceptable	
Hydrocarbons - Aliphatic	Limited	Limited	
Hydrocarbons - Aromatic	Unacceptable	Unacceptable	
Inorganic Salt Solutions	Acceptable	Acceptable	
Ketones, Esters	Unacceptable	Unacceptable	
Miscellaneous Properties	Metric	English	Comments
Data Sheet Region	Americas	Americas	
Targeted Usage	Structural Uses	Structural Uses	
Descriptive Properties			
Color	Natural and black		
Machinability	3		1-10, 1=Easier to Machine



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