

# ULTEM 9085

FAR 25,853 certified material for aeronautical purpose

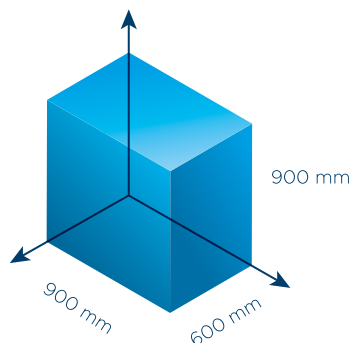
MECHANICALS FEATURES	STANDARD TEST	METRIC	ENGLISH
Traction resistance (Type 1, 0.125", 0.2"/min)	ASTM D638	71.6 MPa	10,400 psi
Traction modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	2.200 MPa	322 ksi
Traction elongation (Type 1, 0.125", 0.2"/min)	ASTM D638	6%	6%
Bend resistance (Method 1, 0.05"/min)	ASTM D790	115.1 MPa	16,700 psi
Bend modulus (Method 1, 0.05"/min)	ASTM D790	2,500 MPa	362.6 ksi
Impact resistance carved IZOD (Method A, 23°C)	ASTM D256	106 J/m	2.0 ft-lb f/in
Impact resistance not carved IZOD (Method A, 23°C)	ASTM D256	613.8 J/m	11.5 ft-lb f/in
Compression resistance	ASTM D695	104 MPa	15.2 ksi
Compression modulus	ASTM D732	1930 MPa	280 ksi
Cut resistance	ASTM D732	57 MPa	8.3 ksi

OTHER FEATURES	STANDARD TEST	VALUE
Specific weight	ASTM D792	1.34
Hardness	ASTM D785	-
Fire reaction classification	UL94	V-0
Dielectric rigidity	ASTM D149-09, Method A	290 - 110 V/mil
Dielectric constant (at 60 Hz)	ASTM D150-98	3.2 - 3.0

THERMAL FEATURES	STANDARD TEST	METRIC	ENGLISH
Under load deflection temperature (HDT)@264 psi, 0.125"	ASTM D648	153 °C	307 °F

FLAME CHARACTERISTICS	STANDARD TEST	VALUE
Oxygen limit index	ASTM D2863	0.49
Vertical burning time	FAR 25.853	2 seconds
Inflammability FAA	FAR 25.853 (Method A/B)	< 5
Heat release peak OSU (5 minutes test)	FAR 25.853	36 kW/m <sup>2</sup>
Heat release peak OSU ( 2 minutes test)	FAR 25.853	16 kW min/ m <sup>2</sup>

## MAX PRINT SIZE:



SLICING				SUPPORT	
0,12	0,17	0,25	0,33	Soluble	Removable
		✓	✓		✓

Manufacturing tolerances : +/- 0,2 mm up to 50 mm

### KEY:

N.A. not applicable.

### NOTES:

Available colours: black, light brown.

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The data presented are only for informative purpose, they aren't official.

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