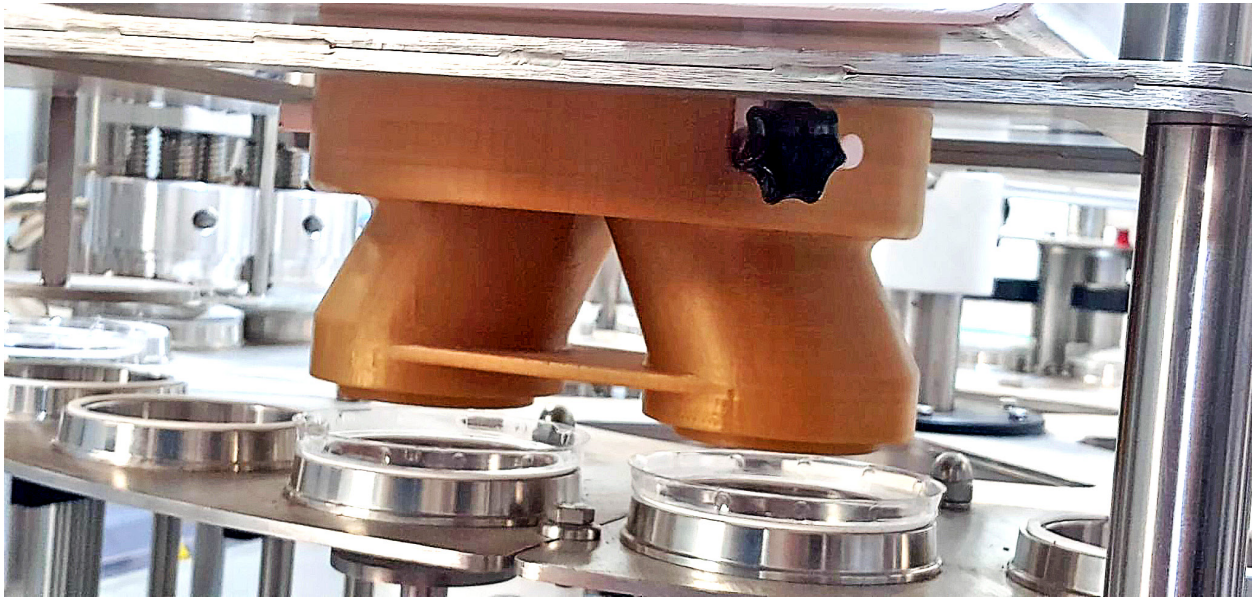


ULTEM 1010 Resin



FDM Thermoplastic Filament

The information presented are typical values intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes.



Overview

ULTEM™ 1010 resin is a high-performance FDM® polyetherimide (PEI) thermoplastic. It exhibits high tensile strength in addition to broad chemical resistance and excellent thermal stability. Its high heat resistance makes it autoclave-capable for applications involving sterilization and composite lay-up tooling.

This material is available in both general-purpose and certified grades (CG). ULTEM 1010 resin is used with breakaway support material and is available in natural color.

Contents:

Ordering Information	3
Physical Properties	4
Mechanical Properties	5
Outgassing	7
Appendix	8

Ordering Information

Table 1. Printer and Support Material Compatibility

Printer	Model Tip (Slice)	Support Material	Support Tip
Fortus 400mc™	T14 (10 slice)	1010 support (breakaway)	T16 (10, 13 slice)
	T20 (13 slice)		
Fortus 450mc™	T14 (10 slice)	1010 support (breakaway)	T16 (10, 13 slice)
	T20 (13 slice)		
Fortus 900mc™/F900™	T14 (10 slice)	1010 support (breakaway)	T16 (10, 13 slice)
	T20 (13 slice)		
	T40A (20 slice)		T20 (20 slice)

Build Sheet

High Temperature

- 0.02 x 26 x 38 in.
- 0.02 x 16 x 18.5 in.

Table 2. ULTEM™ 1010 Resin Ordering Information

Part Number	Description
Filament Canisters^{1 2}	
355-02330	ULTEM™ 1010 resin, 92.3 cu in - Plus
355-02320	ULTEM™ 1010 resin CG, 92.3 cu in - Plus
312-22100	ULTEM™ 1010 resin, 92.3 cu in - Classic
312-22000	ULTEM™ 1010 resin CG, 92.3 cu in - Classic
355-03240	ULTEM Support, 92.3 cu in. - Plus
310-31000	ULTEM Support, 92.3 cu in. - Classic
Printer Consumables	
511-12000	T14 tip
511-10701	T20 tip
511-10750	T40A tip
511-10401	T16 tip
325-00275-S	High Temperature build sheet, 0.2 x 26 x 38 in. (0.76 x 660 x 965 mm)
325-00475-S	High Temperature build sheet, 0.2 x 16 x 18.5 in. (0.76 x 406 x 470 mm)

¹ Classic canisters are compatible with Fortus 900mc printers prior to s/n L502.

² Plus canisters are compatible with all Fortus 450mc, all Stratasys F900, and Fortus 900mc printers s/n L502 and up.

Physical Properties

Values are measured as printed. XY, XZ, and ZX orientations were tested. For full details refer to the [Stratasys Materials Test Report](#) (immediate download upon clicking the link). DSC and TMA curves can be found in the Appendix.

Table 3. ULTEM™ 1010 Resin Physical Properties

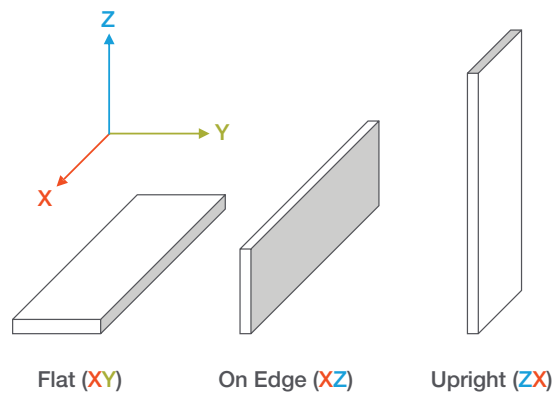
Property	Test Method	Typical Values	
		XY	XZ/ZX
HDT @ 66 psi	ASTM D648		215 °C (415 °F)
	Method B		
HDT @ 264 psi	ASTM D648		210 °C (410 °F)
	Method B		
Tg	ASTM D7426		210 °C (410 °F)
	Inflection Point		
Mean CTE	ASTM E831	35 µm/[m*°C]	-
	(-50 °C to 60 °C)	(19.5 µin./[in.*°F])	
	ASTM E831	30 µm/[m*°C]	-
	(60 °C to 205 °C)	(16.7 µin./[in.*°F])	
	ASTM E831	-	30 µm/[m*°C]
	(-50 °C to 110 °C)		(16.7 µin./[in.*°F])
Volume Resistivity	ASTM E831	-	15 µm/[m*°C]
	(110 °C to 165 °C)		(8.3 µin./[in.*°F])
	ASTM E831	-	5 µm/[m*°C]
	(165 °C to 200 °C)		(2.7µin./[in.*°F])
Dielectric Constant	ASTM D257		>7.0*10 ¹⁴ Ω*cm
	ASTM D150		2.85
Dissipation Factor	1 kHz test condition		-0.002
	ASTM D150		
Specific Gravity	1 kHz test condition		3.1
	ASTM D150		
Dissipation Factor	2 MHz test condition		0
	ASTM D150		
Specific Gravity	ASTM D257		1.29
	@23 °C		

Mechanical Properties

ULTEM 1010 resin samples were printed with a 0.010 in. (0.254 mm) layer height on the F900. For the full test procedure please see the [Stratasys Materials Test Procedure](#) (immediate download upon clicking the link).

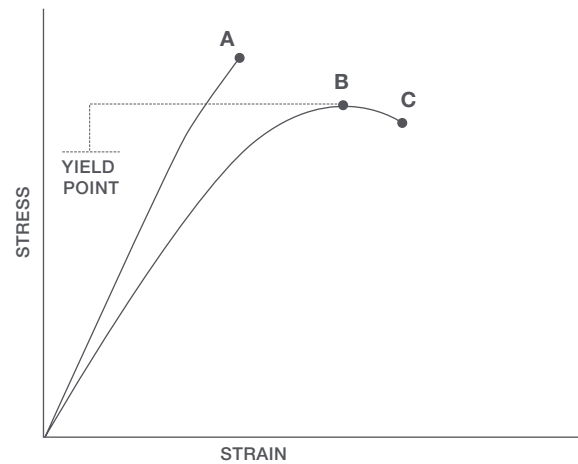
Print Orientation

Parts created using FDM are anisotropic as a result of the printing process. Below is a reference of the different orientations used to characterize the material.



Tensile Curves

Due to the anisotropic nature of FDM, tensile curves look different depending on orientation. Below is a guide of the two types of curves seen when printing tensile samples and what reported values mean.



- A** = Tensile at break, elongation at break (no yield point)
- B** = Tensile at yield, elongation at yield
- C** = Tensile at break, elongation at break

Table 4. ULTEM™ 1010 Resin Mechanical Properties (Fortus 900mc - T14 Tip)

		XZ Orientation ¹	ZX Orientation ¹
Tensile Properties: ASTM D638			
Yield Strength	MPa	No yield	No yield
	psi		
Elongation @ Yield	%	No yield	No yield
Strength @ Break	MPa	80 (5)	30 (10)
	psi	11,490 (710)	4,080 (1280)
Elongation @ Break	%	4.0 (0.4)	1.1 (0.4)
Modulus (Elastic)	GPa	3.0 (0.1)	3.0 (0.4)
	ksi	440 (25)	435 (65)
Flexural Properties: ASTM D790, Procedure A			
Strength @ Break	MPa	No break	80 (13)
	psi	No break	11,830 (1940)
Strength @ 5% Strain	MPa	130 (4)	-
	psi	18,475 (570)	-
Strain @ Break	%	No break	3.2 (0.5)
Modulus	MPa	2.91 (0.05)	2.6 (0.1)
	ksi	420 (7)	380 (20)
Compression Properties: ASTM D695			
Yield Strength	MPa	245 (50)	440 (30)
	psi	35,585 (7245)	63,520 (4460)
Modulus	GPa	2.9 (0.1)	3.2 (0.5)
	ksi	425 (20)	470 (80)
Impact Properties: ASTM D256, ASTM D4812			
Notched	J/m	25 (3)	20 (5)
	ft*lb/in.	0.50 (0.06)	0.41 (0.09)
Unnotched	J/m	260 (60)	70 (30)
	ft*lb/in.	4.9 (1.1)	1.3 (0.5)

¹ Values in parentheses are standard deviations.

Outgassing

ULTEM™ 1010 resin, natural, was printed with a T14 tip on a Stratasys Fortus 450mc and tested per ASTM E595-15. Full report available upon request.

Table 5. ULTEM™ 1010 Resin Outgassing Test Results

Sample	TML (%)	CVCM (%)	WVR (%)
ULTEM™ 1010 Resin, Natural, T14 tip, Flat (XY)	0.55	0.02	0.39
ULTEM™ 1010 Resin, Natural, T14 tip, Upright (ZX)	0.58	0.03	0.33
Testing Observations⁽¹⁾			
Visible Condensate	No	Opaque	N/A
Percent Covered	0%	Interference Fringes	N/A
Thin	N/A	Colored Fringes	N/A
Heavy	N/A	Sample appearance after test	No change
Transparent	N/A		

(1) Observations apply to all tested samples

Appendix

Figure 1. 2nd heating scan DSC data for the ULTEM™ 1010 resin Flat (XY) sample.

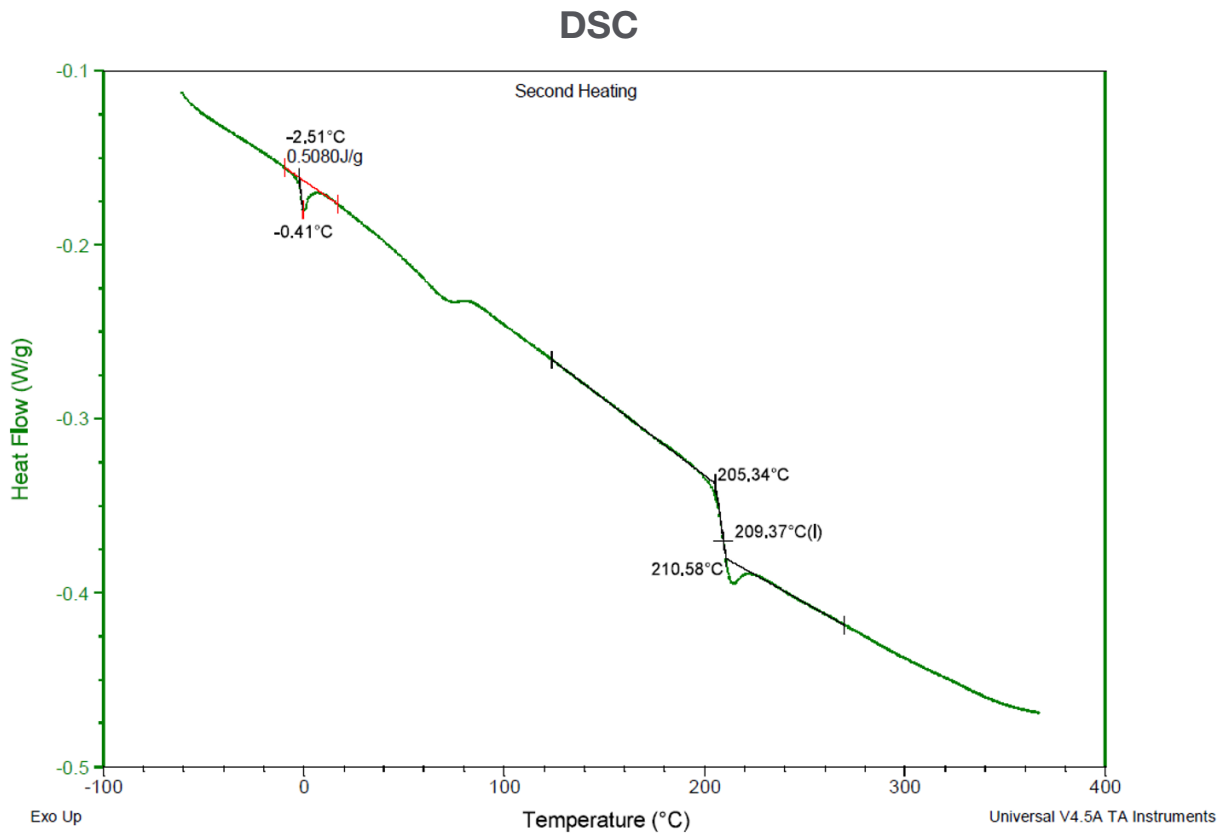


Figure 2. – Dimension change data as a function of temperature for the ULTEM™ 1010 resin Flat (XY) sample.

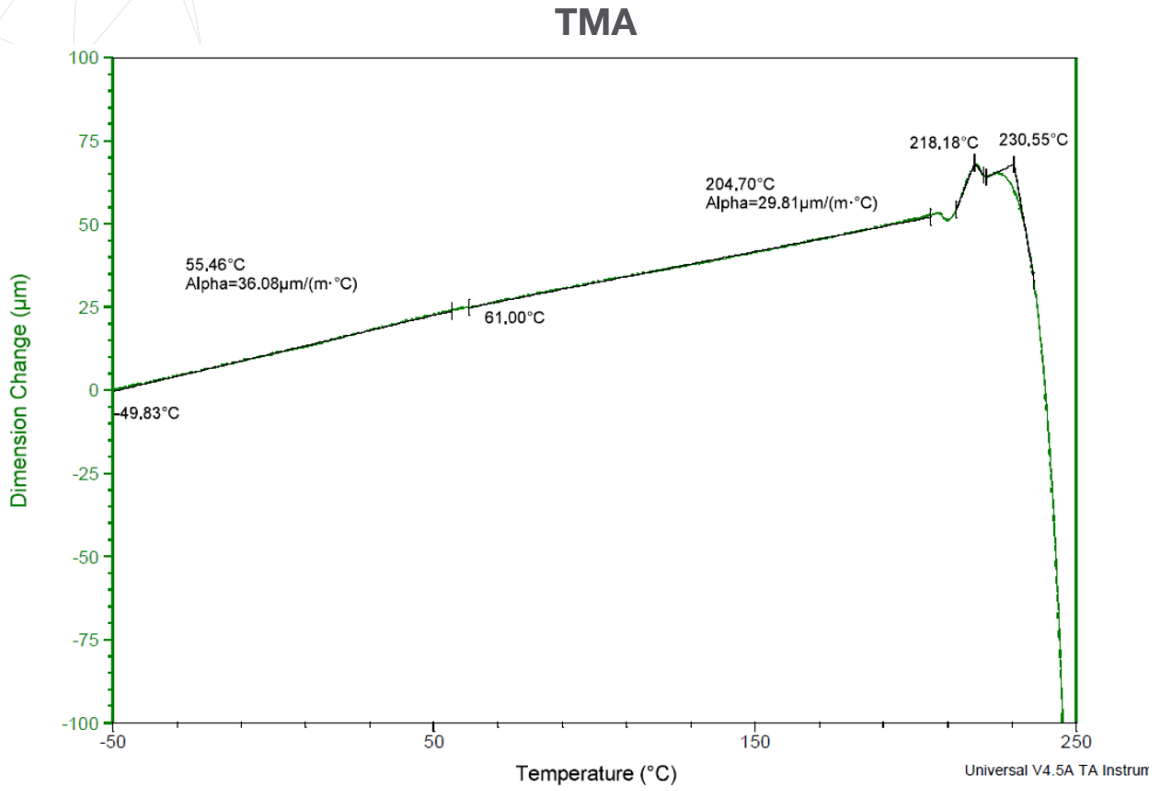


Figure 3. Dimension change data as a function of temperature for the ULTEM™ 1010 resin On Edge (XZ) sample.

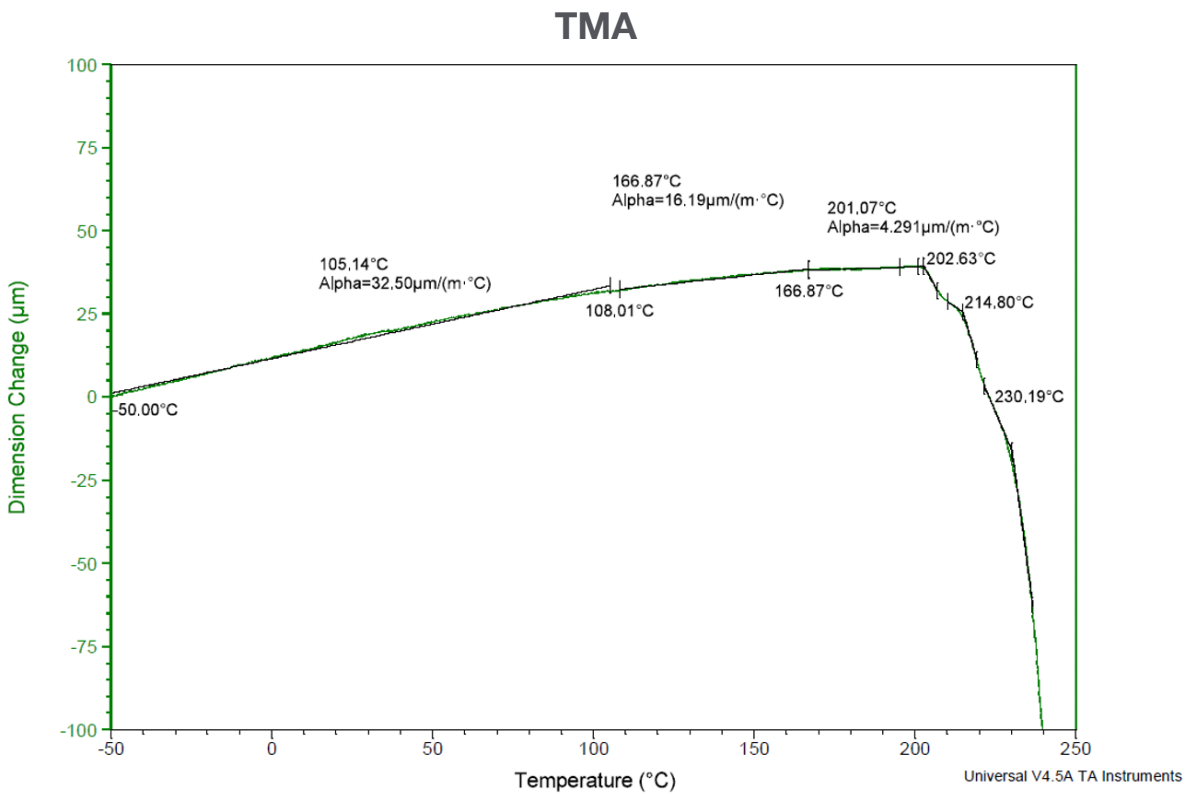
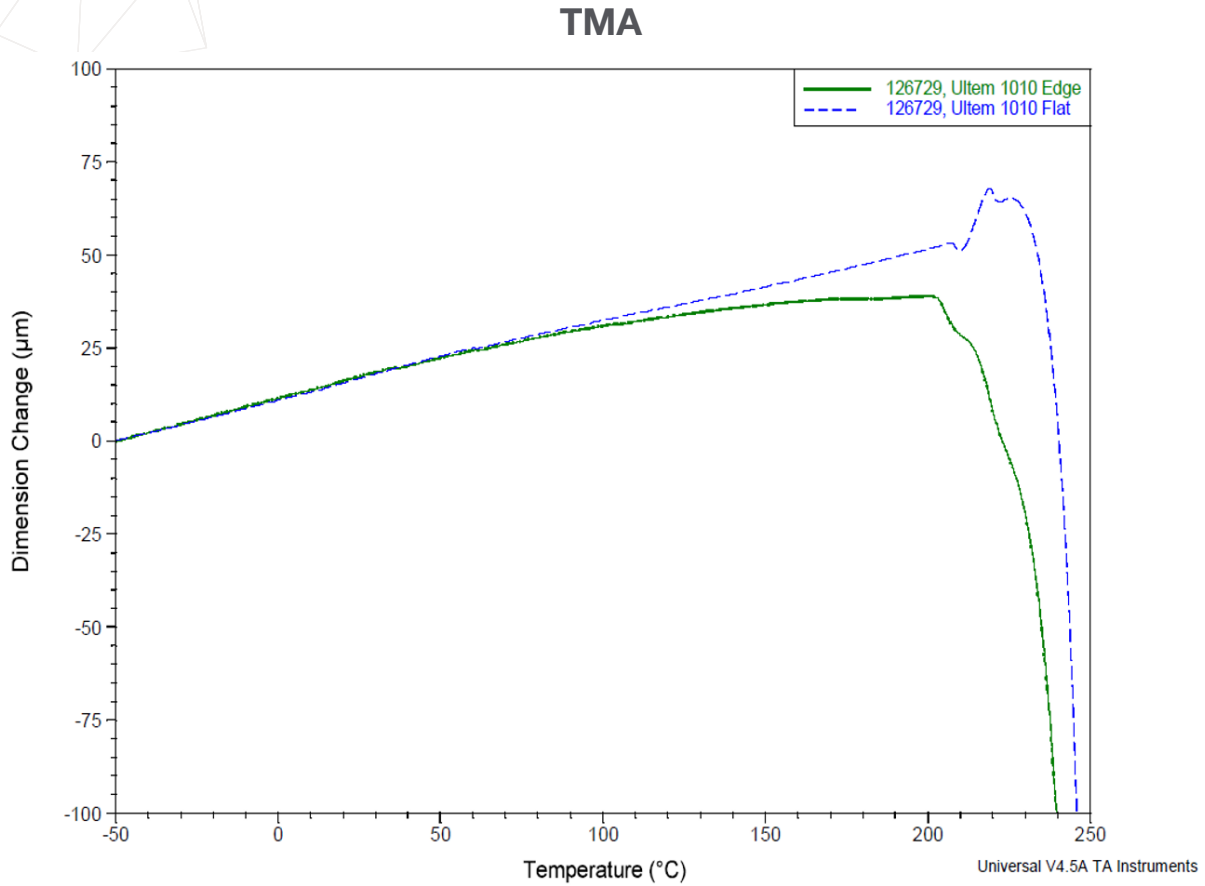


Figure 4. – Overlay of the dimension change data for the Flat (XY) and On Edge (XZ) ULTEM™ 1010 resin samples.



Stratasys Headquarters

7665 Commerce Way,
Eden Prairie, MN 55344
+1 800 801 6491 (US Toll Free)
+1 952 937-3000 (Intl)
+1 952 937-0070 (Fax)

stratasys.com
ISO 9001:2015 Certified

1 Holtzman St., Science Park,
PO Box 2496
Rehovot 76124, Israel
+972 74 745 4000
+972 74 745 5000 (Fax)

