

ULTEM™ 9085 Resin, ULTEM™ 9085 Resin CG - Plastics for Additive Manufacturing - Component

Plastics for Additive Manufacturing - Component

File Number: E345258

Blue Card® 

Printing Process Designation Number 1 ▾

COMPANY

STRATASYS INC

7665 Commerce Way
Eden Prairie, MN 55344-2001 United States

MODEL INFO

ULTEM™ 9085 Resin, ULTEM™ 9085 Resin CG

Polyetherimide (PEI), furnished as filaments

FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		ANSI/UL 94
0.508 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
ISO/IEC FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		IEC 60695-11-10
0.508 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
THERMAL PROPERTIES	VALUE	TEST METHOD
Relative Thermal Index - Electrical Strength		UL 746B
0.508 mm	105 °C	

3.0 mm	105 °C	
Relative Thermal Index - Mechanical Impact		UL 746B
0.508 mm	105 °C	
3.0 mm	105 °C	
Relative Thermal Index - Mechanical Strength		UL 746B
0.508 mm	105 °C	
3.0 mm	105 °C	

PROCESSING PARAMETER	VALUE	TEST METHOD
Process Category	Material Extrusion - Fused Deposition Modeling (FDM) - Filament	
Build Plane	Horizontal	
Layer Thickness	0.25 mm	
Post Process Method	Mechanical Breakage of Support Material	
Printer	Fortus® 400mc™, Fortus® 450mc™, Fortus® 900mc™, Stratasys® F900®	
Raster Angle	45/-45°	

Report Date: 2019-07-11
Revision Date: 2022-02-15

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Plastics for Additive Manufacturing - Component

File Number: E345258

Blue Card®

Printing Process Designation Number 2 ▾

COMPANY

STRATASYS INC

7665 Commerce Way
Eden Prairie, MN 55344-2001 United States

MODEL INFO

ULTEM™ 9085 Resin, ULTEM™ 9085 Resin CG

Polyetherimide (PEI), furnished as filaments

FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		ANSI/UL 94
0.660 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
ISO/IEC FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		IEC 60695-11-10
0.660 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
THERMAL PROPERTIES	VALUE	TEST METHOD
Relative Thermal Index - Electrical Strength		UL 746B
0.660 mm	105 °C	

3.0 mm	105 °C	
Relative Thermal Index - Mechanical Impact		UL 746B
0.660 mm	105 °C	
3.0 mm	105 °C	
Relative Thermal Index - Mechanical Strength		UL 746B
0.660 mm	105 °C	
3.0 mm	105 °C	

PROCESSING PARAMETER	VALUE	TEST METHOD
Process Category	Material Extrusion - Fused Deposition Modeling (FDM) - Filament	
Build Plane	Horizontal	
Layer Thickness	0.33 mm	
Post Process Method	Mechanical Breakage of Support Material	
Printer	Fortus® 400mc™, Fortus® 450mc™, Fortus® 900mc™, Stratasys® F900®	
Raster Angle	45/-45°	

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Revision Date: 2022-02-15

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ULTEM™ 9085 Resin, ULTEM™ 9085 Resin CG - Plastics for Additive Manufacturing - Component

Plastics for Additive Manufacturing - Component

File Number: E345258

Blue Card® 

Printing Process Designation Number 3 ▼

COMPANY

STRATASYS INC

7665 Commerce Way
Eden Prairie, MN 55344-2001 United States

MODEL INFO

ULTEM™ 9085 Resin, ULTEM™ 9085 Resin CG

Polyetherimide (PEI), furnished as filaments

FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		ANSI/UL 94
1.016 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
ISO/IEC FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		IEC 60695-11-10
1.016 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
THERMAL PROPERTIES	VALUE	TEST METHOD
Relative Thermal Index - Electrical Strength		UL 746B
1.016 mm	105 °C	

3.0 mm	105 °C	
Relative Thermal Index - Mechanical Impact		UL 746B
1.016 mm	105 °C	
3.0 mm	105 °C	
Relative Thermal Index - Mechanical Strength		UL 746B
1.016 mm	105 °C	
3.0 mm	105 °C	

PROCESSING PARAMETER	VALUE	TEST METHOD
Process Category	Material Extrusion - Fused Deposition Modeling (FDM) - Filament	
Build Plane	Vertical	
Layer Thickness	0.25 mm	
Post Process Method	Mechanical Breakage of Support Material	
Printer	Fortus® 400mc™, Fortus® 450mc™, Fortus® 900mc™, Stratasys® F900®	
Raster Angle	45/-45°	

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File Number: E345258

Blue Card®

Printing Process Designation Number 4 ▼

COMPANY

STRATASYS INC

7665 Commerce Way
Eden Prairie, MN 55344-2001 United States

MODEL INFO

ULTEM™ 9085 Resin, ULTEM™ 9085 Resin CG

Polyetherimide (PEI), furnished as filaments

FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		ANSI/UL 94
1.32 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
ISO/IEC FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		IEC 60695-11-10
1.32 mm, Color: NC	V-0	
3.0 mm, Color: NC	V-0	
THERMAL PROPERTIES	VALUE	TEST METHOD
Relative Thermal Index - Electrical Strength		UL 746B
1.32 mm	105 °C	

3.0 mm	105 °C	
Relative Thermal Index - Mechanical Impact		UL 746B
1.32 mm	105 °C	
3.0 mm	105 °C	
Relative Thermal Index - Mechanical Strength		UL 746B
1.32 mm	105 °C	
3.0 mm	105 °C	

PROCESSING PARAMETER	VALUE	TEST METHOD
Process Category	Material Extrusion - Fused Deposition Modeling (FDM) - Filament	
Build Plane	Vertical	
Layer Thickness	0.33 mm	
Post Process Method	Mechanical Breakage of Support Material	
Printer	Fortus® 400mc™, Fortus® 450mc™, Fortus® 900mc™, Stratasys® F900®	
Raster Angle	45/-45°	

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