

ULTEM 1010 Resin

High-Performance Thermoplastic
for Fortus® 3D Production Systems



ULTEM 1010 resin is the newest high-performance FDM® thermoplastic, offering excellent strength and thermal stability and the ability to withstand steam autoclaving. With food-contact and bio-compatibility certifications, ULTEM 1010 resin is perfect for specialized applications including food-production tools and custom medical devices. ULTEM 1010 resin offers the highest heat resistance, chemical resistance and tensile strength of any FDM thermoplastic and is ideal for an out-of-cabin aerospace applications and under-the-hood automotive applications.

Mechanical Properties ¹	Test Method	English		Metric	
		XZ Orientation	ZX Orientation	XZ Orientation	ZX Orientation
Tensile Strength, Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	11,735 psi	4,209 psi	81 MPa	29 MPa
Tensile Modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	402,000 psi	325,000 psi	2,772 MPa	2,241 MPa
Tensile Elongation at Break (Type 1, 0.125", 0.2"/min)	ASTM D638	3.3%	1.3%	3.3%	1.3%
Tensile Elongation at Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	2.2%	1.2%	2.2%	1.2%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	20,835 psi	11,184 psi	144 MPa	77 MPa
Flexural Modulus (Method 1, 0.05"/min)	ASTM D790	409,000 psi	324,000 psi	2,820 MPa	2,234 MPa
Flexural Strain at Break (Method 1, 0.05"/min)	ASTM D790	No break	2.7%	No break	2.7%
IZOD Impact, notched (Method A, 23°C)	ASTM D256	0.8 ft-lb/in	0.4 ft-lb/in	41 J/m	24 J/m
IZOD Impact, un-notched (Method A, 23°C)	ASTM D256	6.1 ft-lb f/in	2.6 ft-lb/in	327 J/m	138 J/m

Thermal Properties ²	Test Method	English	Metric
Heat Deflection (HDT) @ 66 psi, 0.125" unannealed	ASTM D648	421°F	216°C
Heat Deflection (HDT) @ 264 psi, 0.125" unannealed	ASTM D648	415°F	213°C
Vicat Softening Temperature (Rate B/50)	ASTM D1525	416°F	214°C
Glass Transition Temperature (Tg)	DSC (SSYS)	419°F	215°C
Coefficient of Thermal Expansion	ASTM E831	26e-06 in/(in·°F)	47 µm/(m·°C)
Coefficient of Thermal Expansion (xflow)	ASTM E831	25e-06 in/(in·°F)	41 µm/(m·°C)
Melting Point	-----	Not Applicable ³	Not Applicable ³

Electrical Properties	Test Method	Value Range
Volume Resistivity	ASTM D257	1.0 x 10 ¹⁴ - 8.96x10 ¹⁵ ohm-cm
Dielectric Constant	ASTM D150-98	2.67
Dissipation Factor	ASTM D150-98	.001
Dielectric Strength	ASTM D149-09, Method A	240 V/mil

ULTEM 1010 Resin

Other ²	Test Method	Value
Specific Gravity	ASTM D792	1.27
Rockwell Hardness	ASTM D785	109
Flame Classification	UL94	V0 (1.5 mm), 5VA (3 mm)
UL File Number	-----	E345258
Food Safety Certification	NSF 51	Certified
Bio-compatibility Certification	ISO 10993/USP Class VI	Certified

System Availability	Layer Thickness Capability	Support Structure	Available Colors
Fortus 900mc™	0.010 inch (0.254 mm)	Breakaway	■ Natural

The performance characteristics of these materials may vary according to application, operating conditions, or end use. 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. End-use material performance can be impacted (+/-) by, but not limited to, part design, end-use conditions, test conditions, etc. Actual values will vary with build conditions. Tested parts were built on Fortus 400mc @ 0.010" (0.254 mm) slice. Product specifications are subject to change without notice.

The performance characteristics of these materials may vary according to application, operating conditions, or end use. Each user is responsible for determining that the Stratasys material is safe, lawful, and technically suitable for the intended application, as well as for identifying the proper disposal (or recycling) method consistent with applicable environmental laws and regulations. Stratasys makes no warranties of any kind, express or implied, including, but not limited to, the warranties of merchantability, fitness for a particular use, or warranty against patent infringement.

¹Build orientation is on side long edge.

²Literature value unless otherwise noted.

³Due to amorphous nature, material does not display a melting point.

Stratasys | www.stratasys.com | info@stratasys.com

7665 Commerce Way
Eden Prairie, MN 55344
+1 888 480-3548 (US Toll Free)
+1 952 937-3000 (Intl)
+1 952 937-0070 (Fax)

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

©2014 Stratasys Inc. All rights reserved. Stratasys, FDM, Fortus and Finishing Touch are registered trademarks of Stratasys Inc. FDM Technology, Fused Deposition Modeling, Fortus 200mc, Fortus 250mc, Fortus 360mc, Fortus 400mc, Fortus 900mc, Insight, Control Center, FDM Team, Smart Supports, SR-30, SR-100, ABSplus, ABS-ESD7, and TouchWorks are trademarks of Stratasys, Inc. ULTEM is a trademark of SABIC Innovative Plastics IP BV. All other trademarks are the property of their respective owners, and Stratasys assumes no responsibility with regard to the selection, performance, or use of these non-Stratasys products. Product specifications subject to change without notice. Printed in the USA. FortusULTEM1010MaterialSpecSheet-EN-10.14

At the core: Advanced FDM technology

Fortus systems are based on FDM (fused deposition modeling) technology. FDM is the industry's leading additive manufacturing technology, and the only one that uses production-grade thermoplastics, enabling the most durable parts

Fortus systems use a wide range of thermoplastics with advanced mechanical properties so your parts can endure high heat, caustic chemicals, sterilization and high-impact applications

No special facilities needed

You can install a Fortus 3D Production System just about anywhere. No special venting is required because Fortus systems don't produce noxious fumes, chemicals or waste.

No special skills needed

Fortus 3D Production Systems are easy to operate and maintain compared to other additive fabrication systems because there are no messy powders to handle and contain. They're so simple, an operator can be trained to operate a Fortus system in less than 30 minutes.

Get your benchmark on the future of manufacturing

Fine details. Smooth surface finishes. Accuracy. Strength. The best way to see the advantages of a Fortus 3D Production System is to have your own part built on a Fortus system. Get your free part at: stratasys.com.