

ULTEM™ SF2350 resin

Polyether Imide

SABIC Innovative Plastics Asia Pacific

Message:

High flow ULTEM blends for thin wall application

General Information			
Features	High liquidity		
Uses	Thin wall parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	15	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (345°C/10.0 kg)	30.4	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	11600	MPa	ASTM D638
Tensile Strength			
Fracture ²	172	MPa	ASTM D638
Fracture	171	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ³	2.6	%	ASTM D638
Fracture	2.5	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁴	9320	MPa	ASTM D790
-- ⁵	9400	MPa	ISO 178
Flexural Strength ⁶ (Yield, 50.0 mm Span)	222	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	95	J/m	ASTM D256
23°C ⁷	10	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	204	°C	ASTM D648
1.8 MPa, unannealed, 100 mm span ⁸	209	°C	ISO 75-2/Ae
Linear thermal expansion coefficient			
Flow: -40 to 150°C	1.5E-5	cm/cm/°C	ASTM E831
Flow: 23 to 150°C	1.4E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 150°C	5.5E-5	cm/cm/°C	ASTM E831
Horizontal: 23 to 150°C	5.6E-5	cm/cm/°C	ISO 11359-2

Flammability	Nominal Value	Test Method
Flame Rating (1.50 mm, Testing by SABIC)	V-0	UL 94

Injection	Nominal Value	Unit
Drying Temperature	149	°C
Drying Time	4.0 - 6.0	hr
Drying Time, Maximum	24	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 - 60	%
Rear Temperature	332 - 399	°C
Middle Temperature	338 - 399	°C
Front Temperature	343 - 399	°C
Nozzle Temperature	343 - 399	°C
Processing (Melt) Temp	349 - 399	°C
Mold Temperature	135 - 163	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.025 - 0.076	mm

NOTE

1. 5.0 mm/min
2. Type 1, 5.0 mm/min
3. Type 1, 5.0 mm/min
4. 1.3 mm/min
5. 2.0 mm/min
6. 1.3 mm/min
7. 80*10*4
8. 120*10*4 mm

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