

ULTEM™ 2212R resin

Polyether Imide

SABIC Innovative Plastics

Message:

20% Milled glass filled, enhanced flow Polyetherimide (Tg 217C) with internal mold release. ECO Conforming, UL94 V0 and 5VA listing.

General Information			
Filler / Reinforcement	Glass fiber with embossing, 20% filler by weight		
Additive	demoulding		
Features	Comply with ECO		
Agency Ratings	EU Eco		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	14	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	4270	MPa	ASTM D638
Tensile Strength ² (Break)	92.4	MPa	ASTM D638
Tensile Elongation ³ (Break)	6.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	5100	MPa	ASTM D790
Flexural Strength ⁵ (Break, 100 mm Span)	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	48	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	380	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	206	°C	ASTM D648
RTI Elec	170	°C	UL 746
RTI Imp	170	°C	UL 746
RTI	170	°C	UL 746
Electrical	Nominal Value	Test Method	
Arc Resistance ⁶	PLC 7	ASTM D495	
Comparative Tracking Index (CTI)	PLC 4	UL 746	
High Amp Arc Ignition (HAI)	PLC 3	UL 746	
High Voltage Arc Tracking Rate (HVTR)	PLC 2	UL 746	
Hot-wire Ignition (HWI)	PLC 1	UL 746	
Flammability	Nominal Value	Test Method	
Flame Rating (0.406 mm)	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. | 2.6 mm/min |
| 5. | 2.6 mm/min |
| 6. | Tungsten electrode |

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