

ULTEM™ 2210R resin

Polyether Imide

SABIC Innovative Plastics

Message:

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

General Information			
UL YellowCard	E45587-236983		
Filler / Reinforcement	Glass fiber reinforced material, 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	1.42	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	9.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	6890	MPa	ASTM D638
Tensile Strength ² (Break)	140	MPa	ASTM D638
Tensile Elongation ³ (Break)	4.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	6890	MPa	ASTM D790
Flexural Strength ⁵ (Break, 100 mm Span)	228	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	75	J/m	ASTM D256
Unnotched Izod Impact (23°C)	480	J/m	ASTM D4812
Reverse Notch Izod Impact (3.20 mm)	480	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	210	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	211	°C	ASTM D648
Vicat Softening Temperature	226	°C	ASTM D1525 ⁶
RTI Elec	170	°C	UL 746
RTI Imp	170	°C	UL 746
RTI	170	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Arc Resistance ⁷	PLC 6		ASTM D495
Comparative Tracking Index (CTI)	PLC 4		UL 746
High Amp Arc Ignition (HAI)	PLC 4		UL 746

High Voltage Arc Tracking Rate (HVTR)	PLC 2		UL 746
Hot-wire Ignition (HWI)	PLC 1		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.406 mm	V-0		UL 94
1.91 mm	5VA		UL 94
Oxygen Index	50	%	ASTM D2863
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.	标准 B (120°C/h), 载荷2 (50N)		
7.	Tungsten electrode		

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