

EXTEM™ XH2315 resin

Thermoplastic Polyimide

SABIC Innovative Plastics

Message:

Extem XH2315 Resin. Also UL rating V094 at 0.75 and V0,5VA at 1.0 and 1.5-1.65

General Information			
UL YellowCard	E121562-100988559		
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) (367°C/6.6 kg)	4.0	g/10 min	ASTM D1238
Water Absorption ¹ (23°C, 24 hr)	0.59	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	10200	MPa	ASTM D638
--	10500	MPa	ISO 527-2/1
Tensile Strength			
Yield ³	156	MPa	ASTM D638
Yield	147	MPa	ISO 527-2/5
Fracture ⁴	156	MPa	ASTM D638
Fracture	147	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁵	3.0	%	ASTM D638
Yield	2.0	%	ISO 527-2/5
Fracture ⁶	3.0	%	ASTM D638
Fracture	2.0	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁷	8960	MPa	ASTM D790
-- ⁸	9000	MPa	ISO 178
Flexural Stress			
--	200	MPa	ISO 178
Yield, 50.0mm span ⁹	206	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ¹⁰ (23°C)	24	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C	86	J/m	ASTM D256
23°C ¹¹	5.7	kJ/m ²	ISO 180/1A
Reverse Notch Izod Impact (3.20 mm)	320	J/m	ASTM D256

Instrumented Dart Impact (23°C, Total Energy)	8.20	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	257	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	254	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	255	°C	ASTM D648
Vicat Softening Temperature	267	°C	ASTM D1525 ¹²
Linear thermal expansion coefficient			ASTM E831
Flow: 23 to 150°C	1.6E-5	cm/cm/°C	ASTM E831
Horizontal: 23 to 150°C	5.3E-5	cm/cm/°C	ASTM E831
Flammability	Nominal Value		Test Method
Flame Rating (0.40 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	175	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 70	%	
Rear Temperature	360 - 380	°C	
Middle Temperature	370 - 395	°C	
Front Temperature	380 - 405	°C	
Nozzle Temperature	375 - 400	°C	
Processing (Melt) Temp	380 - 405	°C	
Mold Temperature	150 - 175	°C	
Back Pressure	0.300 - 0.700	MPa	
Screw Speed	70 - 100	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	Results measured at 48 hrs		
2.	5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	Type 1, 5.0 mm/min		
6.	Type 1, 5.0 mm/min		
7.	1.3 mm/min		
8.	2.0 mm/min		
9.	1.3 mm/min		
10.	80*10*4 sp=62mm		
11.	80*10*4		
12.	标准 B (120°C/h), 载荷2 (50N)		

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