

ULTEM™ SF2360 resin

Polyether Imide

SABIC Innovative Plastics Asia Pacific

Message:

High flow ULTEM for thin wall application

General Information			
UL YellowCard	E207780-100116345		
Features	High Flow		
Uses	Thin-walled Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.53	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	18	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (345°C/10.0 kg)	40.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow	0.39	%	
Across Flow	0.47	%	
Water Absorption			
23°C, 24 hr	0.10	%	ISO 62
Equilibrium, 23°C, 50% RH	0.040	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	12000	MPa	ASTM D638
Tensile Strength			
Break ²	148	MPa	ASTM D638
Break	152	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.0	%	ASTM D638
Break	2.0	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	9940	MPa	ASTM D790
-- ⁵	9940	MPa	ISO 178
Flexural Strength ⁶ (Yield, 50.0 mm Span)	212	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	89	J/m	ASTM D256
23°C ⁷	9.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

1.8 MPa, Unannealed, 3.20 mm	203	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ⁸	208	°C	ISO 75-2/Ae
CLTE			
Flow : -40 to 150°C	1.5E-5	cm/cm/°C	ASTM E831
Flow : 23 to 150°C	1.3E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 150°C	5.4E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 150°C	6.2E-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 to 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	332 to 399	°C	
Middle Temperature	338 to 399	°C	
Front Temperature	343 to 399	°C	
Nozzle Temperature	343 to 399	°C	
Processing (Melt) Temp	349 to 399	°C	
Mold Temperature	135 to 163	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 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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