

ULTEM™ 6202 resin

Polyether Imide

SABIC Innovative Plastics

Message:

12% Silica filled, standard flow Polyetherimide Copolymer (Tg 235C). ECO Conforming, UL94 VO Listing.

General Information			
Filler / Reinforcement	Silica,12% Filler by Weight		
Features	Copolymer		
	ECO Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (367°C/6.6 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption (24 hr)	0.22	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	96.5	MPa	
Break	92.4	MPa	
Tensile Elongation ² (Break)	10	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	4410	MPa	ASTM D790
Flexural Strength ⁴			ASTM D790
Yield, 100 mm Span	145	MPa	
Break, 100 mm Span	145	MPa	
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	11.0	mg	ASTM D1044
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	43	J/m	ASTM D256
Unnotched Izod Impact (23°C)	370	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	214	°C	ASTM D648
Vicat Softening Temperature	237	°C	ASTM D1525 ⁵
CLTE			ASTM E831
Flow : -20 to 150°C	4.5E-5	cm/cm/°C	
Transverse : -20 to 150°C	4.9E-5	cm/cm/°C	
RTI Elec	105	°C	UL 746

RTI Imp	105	°C	UL 746
RTI Str	105	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+17	ohms·cm	ASTM D257
Dielectric Strength (1.60 mm, in Oil)	21	kV/mm	ASTM D149
Dielectric Constant (1 kHz)	3.10		ASTM D150
Dissipation Factor (1 kHz)	1.0E-3		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.47 mm)	V-0		UL 94
Oxygen Index	48	%	ASTM D2863
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	360 to 382	°C	
Middle Temperature	371 to 393	°C	
Front Temperature	382 to 404	°C	
Nozzle Temperature	377 to 399	°C	
Processing (Melt) Temp	382 to 404	°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.	Type I, 5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	2.6 mm/min		
4.	2.6 mm/min		
5.	Rate B (120°C/h), Loading 2 (50 N)		

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