

ULTEM™ 2210 resin

Polyether Imide

SABIC Innovative Plastics

Message:

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

General Information		
UL YellowCard	E121562-502535	E121562-221093
Filler / Reinforcement	Glass Fiber,20% Filler by Weight	
Features	ECO Compliant	
Agency Ratings	EU Eco	
Processing Method	Injection Molding	
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831)	
	Tensile Stress vs. Strain (ASTM D638)	
	Thermal Conductivity vs. Temperature (ASTM E1530)	
	Viscosity vs. Shear Rate (ASTM D3835)	

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)	8.4	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)	64	J/m	ASTM D256
Unnotched Izod Impact (23°C)	480	J/m	ASTM D4812
Reverse Notch Izod Impact (3.20 mm)	450	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	210	°C	
1.8 MPa, Unannealed, 6.40 mm	211	°C	
Vicat Softening Temperature	226	°C	ASTM D1525 ⁶
RTI Elec	170	°C	UL 746
RTI Imp	170	°C	UL 746
RTI Str	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		
1.91 mm	5VA		
Oxygen Index	50	%	ASTM D2863
NBS Smoke Density - Flaming, Ds, 4 min	1.30		ASTM E662
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.	2.6 mm/min		
5.	2.6 mm/min		
6.	Rate B (120°C/h), Loading 2 (50 N)		
7.	Tungsten Electrode		

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