

ULTEM™ HU2210 resin

Polyether Imide
SABIC Innovative Plastics

Message:

20% Glass fiber filled, enhanced flow Polyetherimide (Tg 217C). ECO Conforming. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant.

General Information			
UL YellowCard	E121562-221093		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Biocompatible		
	ECO Compliant		
	Food Contact Acceptable		
	Good Flow		
Uses	Medical/Healthcare Applications		
	Pharmaceuticals		
Agency Ratings	EU Eco		
	ISO 10993		
	USP Class VI		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	8.4	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.30 to 0.50	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	1.0	%	
Equilibrium, 23°C, 50% RH	0.55	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6900	MPa	ASTM D638
--	6800	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	139	MPa	ASTM D638
Yield	140	MPa	ISO 527-2/5
Break ³	140	MPa	ASTM D638
Break	140	MPa	ISO 527-2/5
Tensile Elongation			

Yield ⁴	4.0	%	ASTM D638
Yield	5.0	%	ISO 527-2/5
Break ⁵	4.0	%	ASTM D638
Break	5.0	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	6890	MPa	ASTM D790
-- ⁷	6500	MPa	ISO 178
Flexural Stress			
--	210	MPa	ISO 178
Yield, 50.0 mm Span ⁸	227	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	8.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C	64	J/m	ASTM D256
-30°C ¹⁰	5.0	kJ/m ²	ISO 180/1A
23°C ¹¹	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact (23°C)	480	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	13.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	211	°C	ASTM D648
Vicat Softening Temperature			
--	226	°C	ASTM D1525 ¹²
--	212	°C	ISO 306/B50
--	218	°C	ISO 306/B120
CLTE			ASTM E831
Flow : -40 to 40°C	2.5E-5	cm/cm/°C	
Transverse : -40 to 40°C	5.0E-5	cm/cm/°C	
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.	Type I, 5.0 mm/min	
5.	Type I, 5.0 mm/min	
6.	1.3 mm/min	
7.	2.0 mm/min	
8.	1.3 mm/min	
9.	80*10*4 sp=62mm	
10.	80*10*4	
11.	80*10*4	
12.	Rate B (120°C/h), Loading 2 (50 N)	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

