

ULTEM™ 2100F resin

Polyether Imide
SABIC Innovative Plastics Europe

Message:
10% Glass fiber filled, standard flow Polyetherimide (Tg 217C). ECO Conforming, UL94 V0 and 5VA listing. US FDA and EU Food Contact Compliant, NSF 51 listing. WRAS certification in recognized colors.

General Information			
UL YellowCard	E121562-221093	E121562-502535	
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight		
Features	Comply with ECO		
	Compliance of Food Exposure		
Agency Ratings	EU Eco		
	FDA Food Exposure, Not Rated		
	NSF 51		
	WRAS not rated		
	European food contact, not rated		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.60	%	Internal method
Water Absorption			ASTM D570
24 hr	0.21	%	ASTM D570
Equilibrium, 23°C	1.2	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	4690	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	114	MPa	ASTM D638
Fracture	116	MPa	ASTM D638
Tensile Elongation ³ (Break)	6.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	5170	MPa	ASTM D790
Flexural Strength ⁵ (Break, 100 mm Span)	200	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Unnotched Izod Impact (23°C)	480	J/m	ASTM D4812

Reverse Notch Izod Impact (3.20 mm)	460	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	210	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	209	°C	ASTM D648
Vicat Softening Temperature	223	°C	ASTM D1525 ⁶
CLTE - Flow (-20 to 150°C)	3.2E-5	cm/cm/°C	ASTM E831
RTI Elec	170	°C	UL 746
RTI Imp	170	°C	UL 746
RTI	170	°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)	28	kV/mm	ASTM D149
Dielectric Constant (1 kHz)	3.50		ASTM D150
Dissipation Factor			ASTM D150
1 kHz	1.4E-3		ASTM D150
2.45 GHz	4.6E-3		ASTM D150
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
0.410 mm	V-0		UL 94
1.91 mm	5VA		UL 94
Oxygen Index	47	%	ASTM D2863
NBS Smoke Density - Flaming, Ds, 4 min	1.80		ASTM E662
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	4.0 - 6.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	332 - 399	°C	
Middle Temperature	338 - 399	°C	
Front Temperature	343 - 399	°C	
Nozzle Temperature	343 - 399	°C	
Processing (Melt) Temp	349 - 399	°C	
Mold Temperature	135 - 163	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	

Vent Depth	0.025 - 0.076	mm
NOTE		
1.	5.0 mm/min	
2.	Type 1, 5.0 mm/min	
3.	Type 1, 5.0 mm/min	
4.	2.6 mm/min	
5.	2.6 mm/min	
6.	标准 B (120°C/h), 载荷2 (50N)	
7.	Tungsten electrode	

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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

