

ULTEM™ 2310R resin

Polyether Imide

SABIC Innovative Plastics

Message:

30% Glass fiber filled, enhanced flow Polyetherimide (Tg 217C) with internal mold release. ECO Conforming, UL94 V0 and 5VA listing.

General Information			
UL YellowCard	E121562-470961	E121562-221099	
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Mold Release		
Features	ECO Compliant		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	7.6	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	9240	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	169	MPa	
Break	159	MPa	
Tensile Elongation ³ (Break)	2.0	%	ASTM D638
Flexural Modulus ⁴ (100 mm Span)	9240	MPa	ASTM D790
Flexural Strength ⁵ (Break, 100 mm Span)	221	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	85	J/m	ASTM D256
Reverse Notch Izod Impact (3.20 mm)	480	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	211	°C	ASTM D648
CLTE			ASTM E831
Flow : -20 to 150°C	1.6E-5	cm/cm/°C	
Transverse : -20 to 150°C	4.1E-5	cm/cm/°C	
RTI Elec	180	°C	UL 746
RTI Imp	170	°C	UL 746
RTI Str	180	°C	UL 746
Electrical	Nominal Value		Test Method
Arc Resistance ⁶	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 3	UL 746
Hot-wire Ignition (HWI)	PLC 1	UL 746
Flammability	Nominal Value	Test Method
Flame Rating		UL 94
0.254 mm	V-0	
1.22 mm	5VA	
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.	Tungsten Electrode	

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