ULTEM™ 2410R resin

Polyether Imide

SABIC Innovative Plastics

Message:

40% Glass fiber filled, enhanced flow Polyetherimide (Tg 217C) with internal mold release. Resin is RoHS compliant. UL94 V0 and 5VA listing.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Additive	demoulding		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.61	g/cm³	ASTM D792, ISO 1183
Melt Volume-Flow Rate (MVR) (360°C/5.0 kg)	7.00	cm³/10min	ISO 1133
Molding Shrinkage - Flow [1]	0.10 - 0.30	%	Internal method
Water Absorption			
24 hr	0.12	%	ASTM D570
Saturated, 23°C	0.80	%	ISO 62
Equilibrium, 23°C, 50% RH	0.40	%	ISO 62
Hardness	**Nominal Value**	**Unit**	**Test Method**
Ball Indentation Hardness (H 358/30)	170	MPa	ISO 2039-1
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	11500	MPa	ISO 527-2/1
Tensile Stress (Break)	180	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus [2]	10000	MPa	ISO 178
Flexural Stress	240	MPa	ISO 178
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	20.0	mg	Internal method
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Unnotched Impact Strength [3]			ISO 179/1eU
-30°C	40	kJ/m²	ISO 179/1eU
23°C	40	kJ/m²	ISO 179/1eU
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Unnotched Izod Impact			
23°C	430	J/m	ASTM D4812
-30°C [4]	35	kJ/m²	ISO 180/1U
23°C [5]	35	kJ/m²	ISO 180/1U
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature [6]			

0.45 MPa, unannealed, 100 mm span	215	°C	ISO 75-2/Be
1.8 MPa, unannealed, 100 mm span	210	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	234	°C	ASTM D1525 [7]
--	230	°C	ISO 306/A50
--	217	°C	ISO 306/B50
--	225	°C	ISO 306/B120
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 150°C	1.5E-5	cm/cm/°C	ISO 11359-2
Horizontal: 23 to 150°C	4.5E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.33	W/m/K	ISO 8302
RTI Elec	105	°C	UL 746
RTI Imp	105	°C	UL 746
RTI	105	°C	UL 746
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Dielectric Strength			IEC 60243-1
0.800mm, in oil	35	kV/mm	IEC 60243-1
1.60mm, in oil	26	kV/mm	IEC 60243-1
3.20mm, in oil	16	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
50 Hz	3.50		IEC 60250
60 Hz	3.50		IEC 60250
1 MHz	3.10		IEC 60250
Dissipation Factor			IEC 60250
50 Hz	2.5E-3		IEC 60250
60 Hz	2.5E-3		IEC 60250
1 kHz	2.0E-3		IEC 60250
1 MHz	1.9E-3		IEC 60250
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.250 mm	V-0		UL 94
1.50 mm	5VA		UL 94
Glow Wire Flammability Index (3.20 mm)	960	°C	IEC 60695-2-12
Oxygen Index	48	%	ISO 4589-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	150	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	80.0 - 100	°C	

Rear Temperature	350 - 390	°C
Middle Temperature	370 - 410	°C
Front Temperature	380 - 420	°C
Nozzle Temperature	370 - 410	°C
Processing (Melt) Temp	370 - 410	°C
Mold Temperature	140 - 180	°C

NOTE	
1.	Tensile Bar
2.	2.0 mm/min
3.	80*10*4 sp=62mm
4.	80*10*4
5.	80*10*4
6.	120*10*4 mm
7.	标准 B (120°C/h), 载荷2 (50N)

Recommended distributors for this material

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