ULTEM™ RESIN 2310R

REGION ASIA

DESCRIPTION

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

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Interiors, Automotive Under the Hood
Consumer	Personal Accessory, Home Appliance, Personal Recreation, Commercial Appliance, Recreational Vehicle
Electrical and Electronics	Electrical Devices and Displays, Electrical Components and Infrastructure
Hydrocarbon and Energy	Energy Storage
Industrial	Defense, Semiconductors, Servomotor, Electronic Material Handling, Composite, Electronic Material
Mass Transportation	Aircraft Interiors

TYPICAL PROPERTY VALUES

Revision 20190717

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	168	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	158	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 5 mm/min	9230	MPa	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	220	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	9230	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	85	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	480	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	211	°C	ASTM D 648
CTE, -20°C to 150°C, flow	1.62E-05	1/°C	ASTM E 831
CTE, -20°C to 150°C, xflow	4.14E-05	1/°C	ASTM E 831
Relative Temp Index, Elec [(1)]	180	°C	UL 746B
Relative Temp Index, Mech w/impact [(1)]	170	°C	UL 746B
Relative Temp Index, Mech w/o impact [(1)]	180	°C	UL 746B
PHYSICAL			
Specific Gravity	1.51	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	7.6	g/10 min	ASTM D 1238
ELECTRICAL			
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
Hot-Wire Ignition (HWI), PLC 1	≥1.5	mm	UL 746A
High Amp Arc Ignition (HAI), PLC 4	≥1.5	mm	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E45587-236984	-	-
UL Recognized, 94V-0 Flame Class Rating	≥0.38	mm	UL 94
Glow Wire Flammability Index, 2.0 mm	960	°C	IEC 60695-2-12
Glow Wire Ignitability Temperature, 2.0 mm	900	°C	IEC 60695-2-13
UV-light, water exposure/immersion	F1	-	UL 746C
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	24	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	350 – 400	°C	
Nozzle Temperature	345 – 400	°C	
Front - Zone 3 Temperature	345 – 400	°C	
Middle - Zone 2 Temperature	340 – 400	°C	
Rear - Zone 1 Temperature	330 – 400	°C	
Mold Temperature	135 – 165	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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