ULTEM™ RESIN SF2360

REGION ASIA

DESCRIPTION

High flow ULTEM for thin wall application

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Electrical Devices and Displays, Electrical Components and Infrastructure
Industrial	Electronic Material Handling, Electronic Material

TYPICAL PROPERTY VALUES

Revision 20190717

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	148	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 5 mm/min	11950	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	212	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	9940	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	152	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Flexural Modulus, 2 mm/min	9940	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	89	J/m	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	9	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	203	°C	ASTM D 648
CTE, -40°C to 150°C, flow	1.5E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	5.4E-05	1/°C	ASTM E 831
CTE, 23°C to 150°C, flow	1.3E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	6.2E-05	1/°C	ISO 11359-2
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	208	°C	ISO 75/Ae
Relative Temp Index, Elec [1]	105	°C	UL 746B
Relative Temp Index, Mech w/impact [1]	105	°C	UL 746B
Relative Temp Index, Mech w/o impact [1]	105	°C	UL 746B
PHYSICAL			
Specific Gravity	1.53	-	ASTM D 792
Moisture absorption (23°C/50%)	0.04	%	-
Mold Shrinkage, flow	0.39	%	SABIC method
Mold Shrinkage, xflow	0.47	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	18	g/10 min	ASTM D 1238
Density	1.53	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	0.1	%	ISO 62-1
Melt Volume Rate, MVR at 345°C/10.0 kg	40	cm³/10 min	ISO 1133

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E207780-100116345	-	-
UL Recognized, 94V-0 Flame Class Rating	1.5	mm	UL 94
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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