

ULTEM™ SF2255 resin

Polyether Imide

SABIC Innovative Plastics Asia Pacific

Message:

High flow Ultem for thin wall application

General Information			
Features	High Flow		
Uses	Thin-walled Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	15	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (345°C/10.0 kg)	34.0	cm ³ /10min	ISO 1133
Molding Shrinkage	Internal Method		
Flow	0.30	%	
Across Flow	0.53	%	
Water Absorption (23°C, 24 hr)	0.060	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	10100	MPa	ASTM D638
Tensile Strength ² (Break)	148	MPa	ASTM D638
Tensile Elongation ³ (Break)	1.8	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	8090	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	169	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	76	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	203	°C	ASTM D648
CLTE	ASTM E831		
Flow : -40 to 150°C	1.4E-5	cm/cm/°C	
Transverse : -40 to 150°C	5.5E-5	cm/cm/°C	
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm, Testing by SABIC)	V-0	UL 94	
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. | 1.3 mm/min |
| 5. | 1.3 mm/min |

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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



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