

ULTEM™ 2200F resin

Polyether Imide

SABIC Innovative Plastics

Message:

20% Glass fiber filled, standard flow Polyetherimide (Tg 217C). ECO Conforming. US FDA Food Contact compliant in recognized colors.

General Information			
UL YellowCard	E121562-221093		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	ECO Compliant		
	Food Contact Acceptable		
Agency Ratings	EU Eco		
	FDA Unspecified Rating		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	6.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (360°C/5.0 kg)	7.00	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.30 to 0.50	%	
Across Flow : 3.20 mm	0.30 to 0.50	%	
Water Absorption			
24 hr	0.19	%	ASTM D570
Saturation, 23°C	1.0	%	ISO 62
Equilibrium, 23°C	1.1	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.55	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6890	MPa	ASTM D638
--	6890	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	131	MPa	ASTM D638
Yield	131	MPa	ISO 527-2/5
Break ³	131	MPa	ASTM D638
Break	131	MPa	ISO 527-2/5

Tensile Elongation			
Yield ⁴	4.0	%	ASTM D638
Yield	4.0	%	ISO 527-2/5
Break ⁵	4.0	%	ASTM D638
Break	4.0	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	6850	MPa	ASTM D790
-- ⁷	6890	MPa	ISO 178
Flexural Stress			
--	228	MPa	ISO 178
Yield, 50.0 mm Span ⁸	225	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	65	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	70	J/m	ASTM D256
23°C	64	J/m	ASTM D256
-30°C ¹⁰	70	kJ/m ²	ISO 180/1A
23°C ¹¹	64	kJ/m ²	ISO 180/1A
Unnotched Izod Impact (23°C)	480	J/m	ASTM D4812
Reverse Notch Izod Impact (3.20 mm)	460	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	8.00	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	208	°C	ASTM D648
1.8 MPa, Unannealed, 100 mm Span ¹²	205	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	220	°C	ASTM D1525 ¹³
--	212	°C	ISO 306/B50
--	218	°C	ISO 306/B120
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
CLTE			
Flow : -20 to 150°C	2.5E-5	cm/cm/°C	ASTM E831
Flow : 23 to 150°C	2.5E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 150°C	5.0E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 150°C	5.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	7.0E+16	ohms · cm	ASTM D257
Dielectric Strength (1.60 mm, in Oil)	26	kV/mm	ASTM D149
Dielectric Constant (1 kHz)	3.50		ASTM D150
Dissipation Factor			ASTM D150
1 kHz	1.5E-3		

2.45 GHz	4.9E-3		
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	50	%	ASTM D2863
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.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4 sp=62mm		
10.	80*10*4		
11.	80*10*4		
12.	120*10*4 mm		
13.	Rate B (120°C/h), Loading 2 (50 N)		

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