

ULTEM™ 2212EPR resin

Polyether Imide

SABIC Innovative Plastics

Message:

20% Milled glass filled, high flow Polyetherimide (Tg 217C) with internal mold release and enhanced electroplatability. ECO Conforming, UL94 V0 and 5VA lising.

General Information			
UL YellowCard	E121562-221098		
Filler / Reinforcement	Milled Glass Fiber,20% Filler by Weight		
Additive	Mold Release		
Features	ECO Compliant		
	High Flow		
	Platable		
Agency Ratings	EU Eco		
Processing Method	Injection Molding		
Multi-Point Data	Flexural DMA (ASTM D4065)		
	Pressure-Volume-Temperature (PVT - Zoller Method)		
	Shear DMA (ASTM D4065)		
	Specific Heat vs. Temperature (ASTM D3417)		
	Tensile Fatigue		
	Tensile Stress vs. Strain (ASTM D638)		
	Thermal Conductivity vs. Temperature (ASTM E1530)		
	Viscosity vs. Shear Rate (ASTM D3835)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.50 to 0.70	%	
Across Flow : 3.20 mm	0.50 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	5790	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	108	MPa	
Break	108	MPa	
Tensile Elongation ³			ASTM D638
Yield	3.0	%	
Break	3.0	%	

Flexural Modulus			ASTM D790
50.0 mm Span ⁴	5520	MPa	
100 mm Span ⁵	5100	MPa	
Flexural Strength			ASTM D790
Yield, 50.0 mm Span ⁶	172	MPa	
Break, 100 mm Span ⁷	172	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	59	J/m	ASTM D256
Unnotched Izod Impact (23°C)	480	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	12.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	210	°C	
0.45 MPa, Unannealed, 6.40 mm	213	°C	
1.8 MPa, Unannealed, 3.20 mm	205	°C	
1.8 MPa, Unannealed, 6.40 mm	207	°C	
Vicat Softening Temperature	210	°C	ASTM D1525 ⁸
CLTE			ASTM E831
Flow : -40 to 40°C	3.6E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.2E-5	cm/cm/°C	
RTI Elec	105	°C	UL 746
RTI Imp	105	°C	UL 746
RTI Str	105	°C	UL 746
Electrical	Nominal Value		Test Method
Arc Resistance ⁹	PLC 5		ASTM D495
Comparative Tracking Index (CTI)	PLC 4		UL 746
High Amp Arc Ignition (HAI)	PLC 4		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 4		UL 746
Hot-wire Ignition (HWI)	PLC 1		UL 746
Flammability	Nominal Value		Test Method
Flame Rating (0.406 mm)	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.	2.6 mm/min
6.	1.3 mm/min
7.	2.6 mm/min
8.	Rate B (120°C/h), Loading 2 (50 N)
9.	Tungsten Electrode

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