

Ultem* Resin HU2210

Americas: COMMERCIAL

20% Glass fiber filled, enhanced flow Polyetherimide (Tg 217C). ECO Conforming. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	139	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	140	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Modulus, 5 mm/min	6890	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	227	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	6890	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	140	MPa	ISO 527
Tensile Stress, break, 5 mm/min	140	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5	%	ISO 527
Tensile Strain, break, 5 mm/min	5	%	ISO 527
Tensile Modulus, 1 mm/min	6800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	210	MPa	ISO 178
Flexural Modulus, 2 mm/min	6500	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	475	J/m	ASTM D 4812
Izod Impact, notched, 23°C	64	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	13	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	226	°C	ASTM D 1525
HDT, 1.82 MPa, 6.4 mm, unannealed	211	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	212	°C	ISO 306
Vicat Softening Temp, Rate B/120	218	°C	ISO 306
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.42	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.3 - 0.5	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	8.4	g/10 min	ASTM D 1238
Density	1.42	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	1	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.55	%	ISO 62

Source GMD, last updated:2010/01/04

Processing

Parameter	Value	Unit
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

Source GMD, last updated:2010/01/04

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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