

ULTEM™ RESIN 2110EPR

REGION AMERICAS

DESCRIPTION

10% Glass fiber filled, high flow Polyetherimide (Tg 217C) with internal mold release and enhanced electroplatability. ECO Conforming, UL94 V0 and 5VA listing.

| INDUSTRY | SUB INDUSTRY |
|----------------------------|---|
| Automotive | Heavy Truck, Automotive Under the Hood, Aerospace, Motorcycle, Recreational/Specialty Vehicles |
| Building and Construction | Building Component, Water Management |
| Consumer | Consumer Goods, Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance, Furniture |
| Electrical and Electronics | Energy Management, Drone Solutions, Mobile Phone - Computer - Tablets, Circuit Boards/Additives, Lighting, Printer Copier, Speaker - Earphone, Wireless Communication |
| Hygiene and Healthcare | Personal and Professional Hygiene, Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing |
| Industrial | Electrical, Material Handling, Textile, Eyewear |
| Mass Transportation | Rail |
| Packaging | Industrial Packaging |

TYPICAL PROPERTY VALUES

Revision 20231109

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---|----------------|-------|--------------|
| MECHANICAL | | | |
| Tensile Stress, yld, Type I, 5 mm/min | 119 | MPa | ASTM D638 |
| Tensile Stress, brk, Type I, 5 mm/min | 119 | MPa | ASTM D638 |
| Tensile Strain, yld, Type I, 5 mm/min | 3 | % | ASTM D638 |
| Tensile Strain, brk, Type I, 5 mm/min | 3 | % | ASTM D638 |
| Tensile Modulus, 5 mm/min | 5240 | MPa | ASTM D638 |
| Flexural Stress, yld, 1.3 mm/min, 50 mm span | 199 | MPa | ASTM D790 |
| Flexural Stress, brk, 2.6 mm/min, 100 mm span | 193 | MPa | ASTM D790 |
| Flexural Modulus, 1.3 mm/min, 50 mm span | 4800 | MPa | ASTM D790 |
| Flexural Modulus, 2.6 mm/min, 100 mm span | 5170 | MPa | ASTM D790 |
| IMPACT | | | |
| Izod Impact, unnotched, 23°C | 534 | J/m | ASTM D4812 |
| Izod Impact, notched, 23°C | 69 | J/m | ASTM D256 |
| Instrumented Dart Impact Total Energy, 23°C | 10 | J | ASTM D3763 |
| THERMAL | | | |
| Vicat Softening Temp, Rate B/50 | 210 | °C | ASTM D1525 |
| HDT, 0.45 MPa, 3.2 mm, unannealed | 210 | °C | ASTM D648 |
| HDT, 1.82 MPa, 3.2mm, unannealed | 205 | °C | ASTM D648 |
| HDT, 0.45 MPa, 6.4 mm, unannealed | 212 | °C | ASTM D648 |
| HDT, 1.82 MPa, 6.4 mm, unannealed | 207 | °C | ASTM D648 |
| CTE, -40°C to 40°C, flow | 3.6E-05 | 1/°C | ASTM E831 |
| CTE, -40°C to 40°C, xflow | 8.1E-05 | 1/°C | ASTM E831 |
| Relative Temp Index, Elec ⁽¹⁾ | 155 | °C | UL 746B |

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---|--------------------------------|----------|--------------|
| Relative Temp Index, Mech w/impact ⁽¹⁾ | 155 | °C | UL 746B |
| Relative Temp Index, Mech w/o impact ⁽¹⁾ | 155 | °C | UL 746B |
| PHYSICAL | | | |
| Specific Gravity | 1.35 | - | ASTM D792 |
| Mold Shrinkage, flow, 3.2 mm | 0.7 – 0.9 | % | SABIC method |
| Mold Shrinkage, xflow, 3.2 mm | 0.6 – 0.8 | % | SABIC method |
| Melt Flow Rate, 337°C/6.6 kgf | 19 | g/10 min | ASTM D1238 |
| ELECTRICAL | | | |
| Comparative Tracking Index (UL) {PLC} | 4 | PLC Code | UL 746A |
| Hot-Wire Ignition (HWI), PLC 1 | ≥3 | mm | UL 746A |
| Hot-Wire Ignition (HWI), PLC 2 | ≥0.75 | mm | UL 746A |
| Hot-Wire Ignition (HWI), PLC 4 | ≥0.4 | mm | UL 746A |
| High Amp Arc Ignition (HAI), PLC 3 | ≥0.4 | mm | UL 746A |
| High Voltage Arc Track Rate {PLC} | 3 | PLC Code | UL 746A |
| Arc Resistance, Tungsten {PLC} | 6 | PLC Code | ASTM D495 |
| FLAME CHARACTERISTICS ⁽¹⁾ | | | |
| UL Yellow Card Link | E121562-221094 | - | - |
| UL Recognized, 94V-0 Flame Class Rating | ≥0.4 | 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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