ULTEM™ RESIN SF2350

REGION AMERICAS

DESCRIPTION

30% Glass fiber filled, super high flow for thin wall application.

TYPICAL PROPERTY VALUES

Revision 20260326

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	172	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	2.6	%	ASTM D638
Tensile Modulus, 5 mm/min	11600	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	222	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	9320	MPa	ASTM D790
Tensile Stress, break, 5 mm/min	171	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.5	%	ISO 527
Flexural Modulus, 2 mm/min	9400	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	95	J/m	ASTM D256
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	204	°C	ASTM D648
CTE, -40°C to 150°C, flow	1.5E-05	1/°C	ASTM E831
CTE, -40°C to 150°C, xflow	5.5E-05	1/°C	ASTM E831
CTE, 23°C to 150°C, flow	1.4E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	5.6E-05	1/°C	ISO 11359-2
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	209	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.52	-	ASTM D792
Melt Flow Rate, 337°C/6.6 kgf	14.7	g/10 min	ASTM D1238
Density	1.52	g/cm³	ISO 1183
Melt Volume Rate			
345°C/10.0 kg	30	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS (1)			
UL Yellow Card Link (1)	E207780-100116344	-	-
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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