

Ultem* Resin 2410EPR

Americas: COMMERCIAL

40% Glass fiber filled, high flow Polyetherimide (Tg 217C) with internal mold release for enhanced electroplatability. ECO Conforming, UL94 V0 listing.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	165	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	165	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Modulus, 5 mm/min	11100	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	240	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	10650	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	170	MPa	ISO 527
Tensile Stress, break, 5 mm/min	170	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2	%	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	11000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	220	MPa	ISO 178
Flexural Modulus, 2 mm/min	9500	MPa	ISO 178
Hardness, H358/30	165	MPa	ISO 2039-1
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	410	J/m	ASTM D 4812
Izod Impact, notched, 23°C	82	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	18	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	30	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	10	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	30	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	35	kJ/m ²	ISO 179/1eU
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	223	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	212	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	204	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	208	°C	ASTM D 648
CTE, -40°C to 150°C, flow	1.5E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	4.5E-05	1/°C	ASTM E 831
Thermal Conductivity	0.3	W/m-°C	ISO 8302
CTE, 23°C to 150°C, flow	1.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	4.5E-05	1/°C	ISO 11359-2

Ball Pressure Test, 125°C +/- 2°C	Passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	214	°C	ISO 306
Vicat Softening Temp, Rate B/120	215	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	208	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	205	°C	ISO 75/Ae
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	206	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	197	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.56	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2)	0.2 - 0.4	%	SABIC Method
Mold Shrinkage, flow, 3.2 mm	0.2 - 0.4	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.3 - 0.5	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	8.9	g/10 min	ASTM D 1238
Density	1.56	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.8	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.4	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	11	cm ³ /10 min	ISO 1133
ELECTRICAL	Value	Unit	Standard
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	4	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-0 Flame Class Rating (3)	0.4	mm	UL 94

Source GMD, last updated:11/04/2003

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:11/04/2003

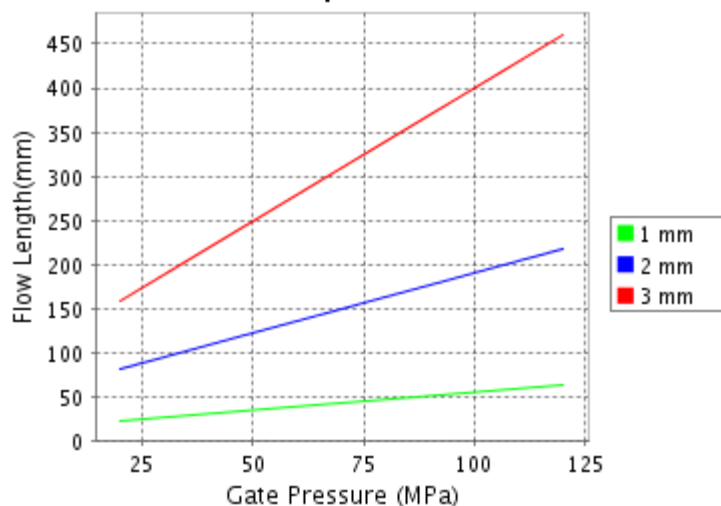
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Ultem® 2310EPR

Melt Temperature : 375°C

Mold Temperature : 150°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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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.

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