

ULTEM™ RESIN 2400

REGION AMERICAS

DESCRIPTION

40% Glass fiber filled, standard flow Polyetherimide (Tg 217C). ECO Conforming, UL94 V0 and 5VA listing. WRAS certification in recognized colors.

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	179	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	11720	MPa	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	241	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	11720	MPa	ASTM D 790
Hardness, Rockwell M	114	-	ASTM D 785
IMPACT			
Izod Impact, unnotched, 23°C	427	J/m	ASTM D 4812
Izod Impact, notched, 23°C	112	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	480	J/m	ASTM D 256
THERMAL			
Vicat Softening Temp, Rate B/50	234	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	212	°C	ASTM D 648
CTE, -20°C to 150°C, flow	1.44E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	170	°C	UL 746B
Relative Temp Index, Mech w/impact	170	°C	UL 746B
Relative Temp Index, Mech w/o impact	170	°C	UL 746B
PHYSICAL			
Specific Gravity	1.61	-	ASTM D 792
Water Absorption, 24 hours	0.13	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.9	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.1 – 0.3	%	SABIC method
Melt Flow Rate, 337°C/6.6 kgf	4.2	g/10 min	ASTM D 1238
ELECTRICAL			
Volume Resistivity	1.5E+16	Ohm-cm	ASTM D 257

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Dielectric Strength, in oil, 1.6 mm	24	kV/mm	ASTM D 149
Relative Permittivity, 1 kHz	3.7	-	ASTM D 150
Dissipation Factor, 1 kHz	0.002	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	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}	5	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.25	mm	UL 94
Oxygen Index (LOI)	54	%	ASTM D 2863
NBS Smoke Density, Flaming, Ds 4 min	1	-	ASTM E 662
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	

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