

Ultem* Resin 2100N

Americas: COMMERCIAL

10% Glass fiber filled, standard flow Polyetherimide (Tg 217C). ECO Conforming.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	114	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	115	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	6	%	ASTM D 638
Tensile Modulus, 5 mm/min	4680	MPa	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	199	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	5170	MPa	ASTM D 790
Hardness, Rockwell M	114	-	ASTM D 785
IMPACT			
Izod Impact, unnotched, 23°C	480	J/m	ASTM D 4812
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	459	J/m	ASTM D 256
THERMAL			
Vicat Softening Temp, Rate B/50	223	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	210	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	208	°C	ASTM D 648
CTE, -20°C to 150°C, flow	3.24E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.34	-	ASTM D 792
Water Absorption, 24 hours	0.21	%	ASTM D 570
Water Absorption, equilibrium, 23C	1.2	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.6	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	7	g/10 min	ASTM D 1238
ELECTRICAL			
Volume Resistivity	1.E+17	Ohm-cm	ASTM D 257
Dielectric Strength, in oil, 1.6 mm	27.5	kV/mm	ASTM D 149
Relative Permittivity, 1 kHz	3.5	-	ASTM D 150
Dissipation Factor, 1 kHz	0.0014	-	ASTM D 150
Dissipation Factor, 2450 MHz	0.0046	-	ASTM D 150

Source GMD, last updated:12/29/1999

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:12/29/1999

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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