

ULTEM™ RESIN 2300F

REGION EUROPE

DESCRIPTION

30% Glass fiber filled, standard flow Polyetherimide (Tg 217°C). ECO Conforming. US FDA Food Contact compliant in recognized colors.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	20	mg/1000cy	SABIC method
Tensile Stress, break, 5 mm/min	165	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	9500	MPa	ISO 527
Flexural Stress, break, 2 mm/min	225	MPa	ISO 178
Flexural Modulus, 2 mm/min	8500	MPa	ISO 178
Hardness, H358/30	165	MPa	ISO 2039-1
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	40	kJ/m ²	ISO 180/1U
Charpy Impact, notched, 23°C	10	kJ/m ²	ISO 179/2C
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	40	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	40	kJ/m ²	ISO 179/1eU
THERMAL			
Thermal Conductivity	0.29	W/m·°C	ISO 8302
CTE, 23°C to 150°C, flow	2.E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	6.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	225	°C	ISO 306
Vicat Softening Temp, Rate B/50	213	°C	ISO 306
Vicat Softening Temp, Rate B/120	220	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	215	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	210	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.2 – 0.4	%	SABIC method
Density	1.51	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.9	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.5	%	ISO 62
Melt Volume Rate, MVR at 360°C/5.0 kg	6	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 0.8 mm	35	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	26	kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	15	kV/mm	IEC 60243-1

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Relative Permittivity, 1 MHz	3.4	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.0016	-	IEC 60250
Dissipation Factor, 1 MHz	0.0023	-	IEC 60250
Dissipation Factor, 2450 MHz	0.0053	-	IEC 60250
Comparative Tracking Index	150	V	IEC 60112
Comparative Tracking Index, M	100	V	IEC 60112
Relative Permittivity, 50/60 Hz	3.3	-	IEC 60250
FLAME CHARACTERISTICS			
Glow Wire Flammability Index 960°C, passes at	3.2	mm	IEC 60695-2-12
Oxygen Index (LOI)	48	%	ISO 4589
INJECTION MOLDING			
Drying Temperature	150	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	370 – 410	°C	
Nozzle Temperature	360 – 410	°C	
Front - Zone 3 Temperature	370 – 420	°C	
Middle - Zone 2 Temperature	360 – 410	°C	
Rear - Zone 1 Temperature	350 – 400	°C	
Hopper Temperature	80 – 120	°C	
Mold Temperature	140 – 180	°C	

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