

**ULTEM® 2100N***Americas: COMMERCIAL*

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

TYPICAL PROPERTIES ¹	TYPICAL 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	116	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	6	%	ASTM D 638
Tensile Modulus, 5 mm/min	4690	MPa	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	200	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	481	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	209	°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	%	GE 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	27.6	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



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PROCESSING PARAMETERS	TYPICAL 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