

**ULTEM® 2110N**
Americas: COMMERCIAL

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

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Str, yld, Type I, 5 mm/min	114	MPa	ASTM D 638
Tensile Str, brk, Type I, 5 mm/min	116	MPa	ASTM D 638
Tensile Elong, brk, Type I, 5 mm/min	6	%	ASTM D 638
Tensile Modulus, 5 mm/min	4620	MPa	ASTM D 638
Flex Stress, brk, 2.6 mm/min, 100 mm span	200	MPa	ASTM D 790
Flex Mod, 2.6 mm/min, 100 mm span	5240	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	374	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	401	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	208	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.41	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	10.4	g/10 min	ASTM D 1238



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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