

**ULTEM® 2212**Americas: **COMMERCIAL**

20% Milled glass filled, enhanced flow Polyetherimide (Tg 217C). ECO Conforming, UL94 V0 and 5VA listing.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Str, brk, Type I, 5 mm/min	92	MPa	ASTM D 638
Tensile Elong, brk, Type I, 5 mm/min	6	%	ASTM D 638
Tensile Modulus, 5 mm/min	4270	MPa	ASTM D 638
Flex Stress, brk, 2.6 mm/min, 100 mm span	172	MPa	ASTM D 790
Flex Mod, 2.6 mm/min, 100 mm span	5100	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	384	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	206	°C	ASTM D 648
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	1.43	-	ASTM D 792
Melt Flow Rate, 337°C/6.6 kgf	13.2	g/10 min	ASTM D 1238
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	4	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.4	mm	UL 94



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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