



ULTEM™ Resin 2212R

Europe-Africa-Middle East: COMMERCIAL

20% Milled glass filled, enhanced flow Polyetherimide (Tg 217C) with internal mold release. Resin is RoHS compliant. UL94 V0 and 5VA listing.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break, 5 mm/min	75	MPa	ISO 527
Tensile Strain, break, 5 mm/min	8	%	ISO 527
Tensile Modulus, 1 mm/min	4500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	135	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m ²	ISO 180/1U
THERMAL			
Thermal Conductivity	0.28	W/m-°C	ISO 8302
Vicat Softening Temp, Rate B/120	211	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	202	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	189	°C	ISO 75/Ae
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			
Mold Shrinkage on Tensile Bar, flow (2) (5)	0.3 - 0.5	%	SABIC Method
Density	1.43	g/cm ³	ISO 1183
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.41	mm	UL 94





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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	150	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	360 - 400	°C
Nozzle Temperature	360 - 400	°C
Front - Zone 3 Temperature	370 - 410	°C
Middle - Zone 2 Temperature	360 - 400	°C
Rear - Zone 1 Temperature	340 - 380	°C
Hopper Temperature	80 - 100	°C
Mold Temperature	140 - 180	°C

