



ULTEM™ Resin SF2255
Asia Pacific: COMMERCIAL

High flow Ultem for thin wall application

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1500	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.8	%	ASTM D 638
Tensile Modulus, 5 mm/min	103400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1720	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	82400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	203	°C	ASTM D 648
CTE, -40°C to 150°C, flow	1.43E-05	1/°C	ASTM E 831
CTE, -40°C to 150°C, xflow	5.5E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.44	-	ASTM D 792
Mold Shrinkage, flow (5)	0.3	%	SABIC Method
Mold Shrinkage, xflow (5)	0.53	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	15.4	g/10 min	ASTM D 1238
Water Absorption, 23°C/24hrs	0.06	%	ISO 62-1
Melt Volume Rate, MVR at 345°C/10.0 kg	34	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	1.5	mm	UL 94 by SABIC-IP





ULTEM™ Resin SF2255

Asia Pacific: COMMERCIAL

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

