

## Ultem\* Resin 2410R

Americas: COMMERCIAL

40% Glass fiber filled, enhanced flow Polyetherimide (Tg 217C) with internal mold release. ECO Conforming, UL94 V0 and 5VA listing.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
	Value	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	179	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	11720	MPa	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	241	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	11720	MPa	ASTM D 790
Hardness, Rockwell M	114	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	427	J/m	ASTM D 4812
Izod Impact, notched, 23°C	112	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	480	J/m	ASTM D 256
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	234	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	212	°C	ASTM D 648
CTE, -20°C to 150°C, flow	1.44E-05	1/°C	ASTM E 831
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
<b>PHYSICAL</b>			
Specific Gravity	1.61	-	ASTM D 792
Water Absorption, 24 hours	0.13	%	ASTM D 570
Water Absorption, equilibrium, 23C	0.9	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.1 - 0.3	%	SABIC Method
Melt Flow Rate, 337°C/6.6 kgf	5.5	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Volume Resistivity	1.5E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in oil, 1.6 mm	24	kV/mm	ASTM D 149
Relative Permittivity, 1 kHz	3.7	-	ASTM D 150
Dissipation Factor, 1 kHz	0.002	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	5	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	5	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-0 Flame Class Rating (3)	0.25	mm	UL 94
UL Recognized, 94-5VA Rating (3)	1.47	mm	UL 94
Oxygen Index (LOI)	54	%	ASTM D 2863

Source GMD, last updated:01/13/2000

Parameter	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

Source GMD, last updated:01/13/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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