

ULTEM™ RESIN SF2350

REGION EUROPE

DESCRIPTION

30% Glass fiber filled, super high flow for thin wall application.

TYPICAL PROPERTY VALUES

Revision 20231212

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	172	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	2.6	%	ASTM D638
Tensile Modulus, 5 mm/min	11600	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	222	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	9320	MPa	ASTM D790
Tensile Stress, break, 5 mm/min	171	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.5	%	ISO 527
Flexural Modulus, 2 mm/min	9400	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	95	J/m	ASTM D256
Izod Impact, notched 80°10°4 +23°C	10	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	204	°C	ASTM D648
CTE, -40°C to 150°C, flow	1.5E-05	1/°C	ASTM E831
CTE, -40°C to 150°C, xflow	5.5E-05	1/°C	ASTM E831
CTE, 23°C to 150°C, flow	1.4E-05	1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	5.6E-05	1/°C	ISO 11359-2
HDT/Ae, 1.8 MPa Edgew 120°10°4 sp=100mm	209	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.52	-	ASTM D792
Melt Flow Rate, 337°C/6.6 kgf	14.7	g/10 min	ASTM D1238
Density	1.52	g/cm³	ISO 1183
Melt Volume Rate, MVR at 345°C/10.0 kg	30	cm³/10 min	ISO 1133
FLAME CHARACTERISTICS ⁽¹⁾			
UL Yellow Card Link	E207780-100116344	-	-
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	

© 2023 Copyright by SABIC. All rights reserved

CHEMISTRY THAT MATTERS™

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

DISCLAIMER

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NON-INFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.