

NORYL™ RESIN PKN4752

REGION ASIA

DESCRIPTION

PPE+PS blend. High Heat. Translucent with yellow tint in natural color. Extrusion and Injection Molding. Typical applications include High Performance Food Packaging, Electronics and Healthcare Packaging.

TYPICAL PROPERTY VALUES

Revision 20180906

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	86	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	73	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	15	%	ASTM D 638
Tensile Modulus, 50 mm/min	3000	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	144	MPa	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	136	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3150	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2940	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	32	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	6	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	173	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	160	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	151	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	151	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.58E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.08	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 – 0.9	%	SABIC method
SHEET EXTRUSION			
Drying Temperature	70 – 80	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0	%	
Melt Temperature	265 – 275	°C	
Barrel - Zone 1 Temperature	205 – 225	°C	
Barrel - Zone 2 Temperature	215 – 240	°C	
Barrel - Zone 3 Temperature	240 – 265	°C	
Barrel - Zone 4 Temperature	240 – 265	°C	
Adapter Temperature	240 – 265	°C	
Die Temperature	240 – 265	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Roll Stack Temp - Top	105 – 120	°C	
Roll Stack Temp - Middle	105 – 120	°C	
Roll Stack Temp - Bottom	105 – 120	°C	

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