

NORYL™ NH4030R resin

Polyphenylene Ether + PS

SABIC Innovative Plastics Asia Pacific

Message:

Non halogenated flame retardant and Mold release ability improved NORYL product

General Information			
Additive	Flame Retardant		
	Mold Release		
Features	Flame Retardant		
	Good Mold Release		
	Halogen Free		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	14	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption (24 hr)	0.070	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	60.0	MPa	Internal Method
Tensile Elongation (Break)	27	%	Internal Method
Flexural Modulus	2350	MPa	ASTM D790
Flexural Strength	87.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	240	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	100	°C	ASTM D648
Electrical	Nominal Value		Test Method
Arc Resistance ¹	PLC 6		ASTM D495
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.750 mm, Testing by SABIC	V-1		
1.20 mm	V-0		
2.50 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	98.9 to 104	°C	
Drying Time	3.0 to 4.0	hr	

Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	30 to 70	%
Rear Temperature	238 to 288	°C
Middle Temperature	249 to 293	°C
Front Temperature	260 to 299	°C
Nozzle Temperature	271 to 299	°C
Processing (Melt) Temp	271 to 299	°C
Mold Temperature	65.6 to 93.3	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.038 to 0.051	mm

NOTE

1. Tungsten Electrode

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