

NORYL™ HM4025H resin

Polyphenylene Ether + PS

SABIC Innovative Plastics Asia Pacific

Message:

40% GF/MF filled FR PPE/PS blend, high flow

General Information			
UL YellowCard	E45587-237039	E207780-228551	
Filler / Reinforcement	Glass\Mineral,40% Filler by Weight		
Features	High Flow		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/2.16 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.15 to 0.25	%	Internal Method
Water Absorption (24 hr)	0.060	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	117	MPa	Internal Method
Tensile Elongation (Break)	4.0 to 6.0	%	Internal Method
Flexural Modulus	10300	MPa	ASTM D790
Flexural Strength	155	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	68	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	125	°C	ASTM D648
CLTE - Flow (-30 to 30°C)	2.1E-5 to 3.3E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	104 to 110	°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	260 to 304	°C	
Middle Temperature	271 to 310	°C	
Front Temperature	282 to 316	°C	

Nozzle Temperature	293 to 316	°C
Processing (Melt) Temp	293 to 316	°C
Mold Temperature	76.7 to 104	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

