

# NORYL™ PKN4752 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

## Message:

NORYL PKN4752 is a translucent, high heat PPO+PS extrusion grade for dilution with polystyrene resin. It is suitable for (microwavable) food packaging and is compliant with US and European food contact regulations.

| General Information                         |                                  |                   |              |
|---------------------------------------------|----------------------------------|-------------------|--------------|
| Features                                    | Heat resistance, high            |                   |              |
|                                             | Compliance of Food Exposure      |                   |              |
| Uses                                        | Food packaging                   |                   |              |
| Agency Ratings                              | FDA Food Exposure, Not Rated     |                   |              |
|                                             | European food contact, not rated |                   |              |
| RoHS Compliance                             | RoHS compliance                  |                   |              |
| Appearance                                  | Translucent                      |                   |              |
| Processing Method                           | Profile extrusion molding        |                   |              |
| Physical                                    | Nominal Value                    | Unit              | Test Method  |
| Density                                     | 1.08                             | g/cm <sup>3</sup> | ISO 1183     |
| Mechanical                                  | Nominal Value                    | Unit              | Test Method  |
| Tensile Modulus                             | 3100                             | MPa               | ISO 527-2/1  |
| Tensile Stress (Yield)                      | 86.0                             | MPa               | ISO 527-2/50 |
| Tensile Strain (Break)                      | 6.0                              | %                 | ISO 527-2/50 |
| Flexural Modulus <sup>1</sup>               | 2950                             | MPa               | ISO 178      |
| Flexural Stress                             | 130                              | MPa               | ISO 178      |
| Impact                                      | Nominal Value                    | Unit              | Test Method  |
| Charpy Notched Impact Strength <sup>2</sup> |                                  |                   | ISO 179/1eA  |
| -30°C                                       | 2.0                              | kJ/m <sup>2</sup> | ISO 179/1eA  |
| 23°C                                        | 2.0                              | kJ/m <sup>2</sup> | ISO 179/1eA  |
| Notched Izod Impact <sup>3</sup>            |                                  |                   | ISO 180/1A   |
| -30°C                                       | 3.0                              | kJ/m <sup>2</sup> | ISO 180/1A   |
| 23°C                                        | 3.0                              | kJ/m <sup>2</sup> | ISO 180/1A   |
| Thermal                                     | Nominal Value                    | Unit              | Test Method  |
| Heat Deflection Temperature <sup>4</sup>    |                                  |                   |              |
| 0.45 MPa, unannealed, 100 mm span           | 163                              | °C                | ISO 75-2/Be  |
| 1.8 MPa, unannealed, 100 mm span            | 147                              | °C                | ISO 75-2/Ae  |
| Vicat Softening Temperature                 | 174                              | °C                | ISO 306/A50  |
| Extrusion                                   | Nominal Value                    | Unit              |              |
| Drying Temperature                          | 80.0 - 95.0                      | °C                |              |

|                         |             |    |
|-------------------------|-------------|----|
| Drying Time             | 2.0 - 4.0   | hr |
| Hopper Temperature      | 50.0 - 70.0 | °C |
| Cylinder Zone 1 Temp.   | 215 - 240   | °C |
| Cylinder Zone 2 Temp.   | 225 - 250   | °C |
| Cylinder Zone 3 Temp.   | 250 - 275   | °C |
| Cylinder Zone 4 Temp.   | 250 - 275   | °C |
| Adapter Temperature     | 250 - 275   | °C |
| Melt Temperature        | 280 - 300   | °C |
| Die Temperature         | 250 - 275   | °C |
| Calibration Temp, First | 60.0 - 80.0 | °C |

#### NOTE

- |    |                 |
|----|-----------------|
| 1. | 2.0 mm/min      |
| 2. | 80*10*4 sp=62mm |
| 3. | 80*10*4         |
| 4. | 120*10*4 mm     |

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#### 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



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