

NORYL™ EXNL0357 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

PPE+PS, Flame Retardant, UL Grade, Non-Halogen Flame Retardant, Flame retardant,

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Halogen Free		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	9.6	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	9.85	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.25	%	
Equilibrium, 23°C, 50% RH	0.050	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2170	MPa	ASTM D638
--	2910	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	63.3	MPa	ASTM D638
Yield	64.9	MPa	ISO 527-2/50
Break ³	51.3	MPa	ASTM D638
Break	53.3	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	5.2	%	ASTM D638
Yield	4.9	%	ISO 527-2/50
Break ⁵	29	%	ASTM D638
Break	21	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	2630	MPa	ASTM D790
-- ⁷	2630	MPa	ISO 178
Flexural Stress			
--	107	MPa	ISO 178

Yield, 50.0 mm Span ⁸	104	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	16	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	93	J/m	ASTM D256
23°C	170	J/m	ASTM D256
-30°C ¹⁰	7.8	kJ/m ²	ISO 180/1A
23°C ¹¹	16	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	34.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	115	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	116	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	136	°C	ASTM D1525, ISO 306/B50 ¹³
--	138	°C	ISO 306/B120
CLTE			
Flow : -40 to 40°C	7.4E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	7.1E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	7.1E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	7.4E-5	cm/cm/°C	ISO 11359-2
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	249 to 299	°C	
Middle Temperature	260 to 304	°C	
Front Temperature	271 to 310	°C	
Nozzle Temperature	282 to 310	°C	
Processing (Melt) Temp	282 to 310	°C	
Mold Temperature	76.7 to 104	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	20 to 100	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 50 mm/min		
3.	Type I, 50 mm/min		
4.	Type I, 50 mm/min		
5.	Type I, 50 mm/min		

6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4 sp=62mm
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	Rate B (120°C/h), Loading 2 (50 N)

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