

NORYL™ ZM3640 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics Asia Pacific

Message:

PPE+PS, Mineral, Low Warpage, Non-Halogen Flame Retardant,

General Information			
UL YellowCard	E207780-100140832		
Filler / Reinforcement	Mineral		
Features	Flame Retardant		
	Halogen Free		
	Low Warpage		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/2.16 kg)	24	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	60.0	MPa	ASTM D638
Tensile Elongation ² (Break)	4.0	%	ASTM D638
Flexural Modulus (6.40 mm)	4620	MPa	ASTM D790
Flexural Strength (Yield, 6.40 mm)	102	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	35	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	103	°C	ASTM D648
CLTE			ASTM E831
Flow : -40 to 40°C	4.2E-5	cm/cm/°C	
Transverse : -40 to 40°C	4.8E-5	cm/cm/°C	
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-1		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	87.8 to 93.3	°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	221 to 271	°C	
Middle Temperature	232 to 277	°C	

Front Temperature	243 to 282	°C
Nozzle Temperature	254 to 282	°C
Processing (Melt) Temp	254 to 282	°C
Mold Temperature	65.6 to 87.8	°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. Type I, 5.0 mm/min
2. Type I, 5.0 mm/min

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