

NORYL™ PKN4752F resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

PPE+PS blend. High Heat. Translucent with yellow tint in natural color. FDA compliant. Extrusion and Injection Molding. Typical applications include High Performance Food Packaging, Electronics and Healthcare Packaging.

General Information			
Features	Heat resistance, high		
Uses	Electrical/Electronic Applications		
	Food packaging		
	Medical packaging		
Agency Ratings	FDA not rated		
Appearance	Translucent		
Processing Method	Sheet extrusion molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.60 - 0.90	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3010	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	86.2	MPa	ASTM D638
Fracture	73.8	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	6.0	%	ASTM D638
Fracture	15	%	ASTM D638
Flexural Modulus			ASTM D790
50.0mm span ⁴	3150	MPa	ASTM D790
100mm span ⁵	2950	MPa	ASTM D790
Flexural Strength			ASTM D790
Yield, 50.0mm span ⁶	145	MPa	ASTM D790
Yield, 100mm span ⁷	137	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	32	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	6.55	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	161	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	151	°C	ASTM D648

1.8 MPa, unannealed, 6.40mm	152	°C	ASTM D648
Vicat Softening Temperature	174	°C	ASTM D1525 ⁸
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	6.3E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	5.6E-5	cm/cm/°C	ASTM E831

Extrusion	Nominal Value	Unit
Drying Temperature	71.1 - 82.2	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	2.0E-4	%
Cylinder Zone 1 Temp.	204 - 227	°C
Cylinder Zone 2 Temp.	216 - 238	°C
Cylinder Zone 3 Temp.	238 - 266	°C
Cylinder Zone 4 Temp.	238 - 266	°C
Adapter Temperature	238 - 266	°C
Melt Temperature	266 - 277	°C
Die Temperature	238 - 266	°C

Extrusion instructions

Drying Time (Cumulative): 8 hrsRoll Stack Temp - Bottom: 104 - 121 °CRoll Stack Temp - Middle: 104 - 121 °CRoll Stack Temp - Top: 104 - 121 °C

NOTE

- 50 mm/min
- Type 1, 50mm/min
- Type 1, 50mm/min
- 1.3 mm/min
- 2.6 mm/min
- 1.3 mm/min
- 2.6 mm/min
- 标准 B (120°C/h), 载荷2 (50N)

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