

NORYL™ PCN2910 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics Asia Pacific

Message:

35% Glass/Mica filled. High modulus and tight tolerance molding for the chassis market.

General Information			
UL YellowCard	E45587-237063	E207780-228572	
Filler / Reinforcement	Glass\Mica,35% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/2.16 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.25 to 0.30	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	11400	MPa	ASTM D638
--	10600	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	123	MPa	ASTM D638
Yield	106	MPa	ISO 527-2/5
Break ³	115	MPa	Internal Method
Tensile Elongation			
Yield ⁴	5.0	%	Internal Method
Break ⁵	1.5	%	ASTM D638
Break	1.3	%	ISO 527-2/5
Flexural Modulus			
100 mm Span ⁶	8940	MPa	ASTM D790
-- ⁷	9130	MPa	ISO 178
Flexural Stress			
--	160	MPa	ISO 178
Yield, 100 mm Span ⁸	159	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.4	kJ/m²	ISO 179/2C
Charpy Unnotched Impact Strength ⁹ (23°C)	20	kJ/m²	ISO 179/1eU
Notched Izod Impact			
23°C	68	J/m	ASTM D256
23°C ¹⁰	5.0	kJ/m²	ISO 180/1A
Unnotched Izod Impact			

23°C	330	J/m	ASTM D4812
23°C ¹¹	14	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	7.10	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	125	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	129	°C	ISO 75-2/Af
Vicat Softening Temperature	140	°C	ASTM D1525 ¹³
CLTE - Flow (-30 to 30°C)	2.1E-6 to 3.3E-6	cm/cm/°C	ASTM E831
RTI Elec	65.0	°C	UL 746
RTI Imp	65.0	°C	UL 746
RTI Str	65.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-1		
3.00 mm	V-0		
2.30 mm	5VB		
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	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 10 mm/min		
4.	Type I, 10 mm/min		
5.	Type I, 5.0 mm/min		
6.	2.6 mm/min		
7.	2.0 mm/min		
8.	2.6 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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