

NORYL™ PN275F resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

PPE+PS with low mineral loading. High heat, platable applications. NSF approved for water contact applications.

General Information			
Features	High Heat Resistance		
	Platable		
Agency Ratings	NSF Unspecified Rating		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	5.3	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.60 to 0.90	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2140	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	55.2	MPa	
Break	48.3	MPa	
Tensile Elongation ³			ASTM D638
Yield	6.6	%	
Break	34	%	
Flexural Modulus ⁴ (50.0 mm Span)	2340	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	210	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	44.1	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	137	°C	
1.8 MPa, Unannealed, 3.20 mm	121	°C	
Vicat Softening Temperature	152	°C	ASTM D1525 ⁶
CLTE			ASTM E831
Flow : -40 to 40°C	6.3E-5	cm/cm/°C	
Transverse : -40 to 40°C	5.6E-5	cm/cm/°C	
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. 50 mm/min
2. Type I, 50 mm/min
3. Type I, 50 mm/min
4. 1.3 mm/min
5. 1.3 mm/min
6. Rate B (120°C/h), Loading 2 (50 N)

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