



## NORYL™ Resin PKN4765

### Americas: LIMITED USE

PPE+PS blend. Opaque. FDA compliant in limited colors. Extrusion and Injection Molding. Typical applications include High Performance Food Packaging.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	500	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	650	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	27	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	28	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1030	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26300	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 6.4 mm	28000	kgf/cm <sup>2</sup>	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	55	cm-kgf	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	151	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	136	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	125	°C	ASTM D 648
<b>PHYSICAL</b>			
Specific Gravity	1.1	-	ASTM D 792

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.  
 (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.  
 (4) Internal measurements according to UL standards.  
 (5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.  
 (6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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- Use lower process temperatures when material is let-down.

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Sheet Extrusion</b>		
Drying Temperature	70 - 80	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0	%
Melt Temperature	265 - 275	°C
Barrel - Zone 1 Temperature	205 - 225	°C
Barrel - Zone 2 Temperature	215 - 240	°C
Barrel - Zone 3 Temperature	240 - 265	°C
Barrel - Zone 4 Temperature	240 - 265	°C
Adapter Temperature	240 - 265	°C
Die Temperature	240 - 265	°C
Roll Stack Temp - Top	105 - 120	°C
Roll Stack Temp - Middle	105 - 120	°C
Roll Stack Temp - Bottom	105 - 120	°C

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