

## Noryl\* Resin EN265

### Americas: COMMERCIAL

Extrusion grade. 254F (123C) DTUL. UL94 V-1 rated.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 2.0 in/min	9100	psi	ASTM D 638
Tensile Strain, brk, Type I, 2.0 in/min	25	%	ASTM D 638
Flexural Stress, yld, 0.10 in/min, 4 in span	14300	psi	ASTM D 790
Flexural Modulus, 0.10 in/min, 4 in span	369000	psi	ASTM D 790
Hardness, Rockwell R	119	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, notched, 73°F	3.5	ft-lb/in	ASTM D 256
Izod Impact, notched, -40°F	2.5	ft-lb/in	ASTM D 256
Gardner Impact, -22°F	10	ft-lb	ASTM D 3029
Gardner Impact, -40°F	2	ft-lb	ASTM D 3029
<b>THERMAL</b>			
HDT, 264 psi, 0.250 in, unannealed	254	°F	ASTM D 648
CTE, flow, -40°F to 200°F	3.3E-05	1/°F	ASTM E 831
Relative Temp Index, Elec	110	°C	UL 746B
Relative Temp Index, Mech w/impact	105	°C	UL 746B
Relative Temp Index, Mech w/o impact	110	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.08	-	ASTM D 792
Water Absorption, 24 hours @ 73°F	0.07	%	ASTM D 570
Mold Shrinkage, flow, 0.125" (5)	0.5 - 0.7	%	SABIC Method
<b>ELECTRICAL</b>			
Dielectric Strength, in oil, 125 mils	500	V/mil	ASTM D 149
Relative Permittivity, 50/60 Hz	2.69	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0007	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.  
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
4) Own measurement according to UL.  
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.

Source, GMD, Last Update:

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>ELECTRICAL</b>			
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-1 Flame Class Rating (3)	0.059	in	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.236	in	UL 94
Oxygen Index (LOI)	29.2	%	ASTM D 2863
Radiant Panel Listing	RP100	-	UL Tested
UV-light, water exposure/immersion	F1	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Extrusion</b>		
Drying Temperature	220 - 240	°F
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	440 - 490	°F
Barrel - Zone 1 Temperature	400	°F
Barrel - Zone 2 Temperature	400	°F
Barrel - Zone 3 Temperature	440	°F
Barrel - Zone 4 Temperature	440	°F
Adapter Temperature	480	°F
Die Temperature	480	°F

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