

NORYL™ RESIN HM4025H

REGION ASIA

DESCRIPTION

40% GF/MF filled FR PPE/PS blend, high flow

TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	116	MPa	SABIC - Japan Method
Tensile Strain, break	4 – 6	%	SABIC - Japan Method
Flexural Stress	154	MPa	ASTM D 790
Flexural Modulus	10290	MPa	ASTM D 790
Hardness, Rockwell M	90	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	68	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	125	°C	ASTM D 648
CTE, -30°C to 30°C	0.000021 – 0.000033	1/°C	TMA
PHYSICAL			
Specific Gravity	1.44	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.15 – 0.25	%	SABIC method
Melt Flow Rate, 300°C/2.16 kgf	15.4	g/10 min	ASTM D 1238
ELECTRICAL			
Surface Resistivity	1.E+16	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	105 – 110	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	295 – 315	°C	
Nozzle Temperature	295 – 315	°C	
Front - Zone 3 Temperature	280 – 315	°C	
Middle - Zone 2 Temperature	270 – 310	°C	
Rear - Zone 1 Temperature	260 – 305	°C	
Mold Temperature	75 – 105	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	



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