

# NORYL™ RESIN NH4030R

REGION ASIA

## TYPICAL PROPERTY VALUES

Revision 20181012

| PROPERTIES                              | TYPICAL VALUES | UNITS    | TEST METHODS         |
|---|----------------|----------|----------------------|
| <b>MECHANICAL</b>                       |                |          |                      |
| Tensile Stress, yield                   | 60             | MPa      | SABIC - Japan Method |
| Tensile Strain, break                   | 27             | %        | SABIC - Japan Method |
| Flexural Stress                         | 87             | MPa      | ASTM D 790           |
| Flexural Modulus                        | 2350           | MPa      | ASTM D 790           |
| <b>IMPACT</b>                           |                |          |                      |
| Izod Impact, notched, 23°C              | 240            | J/m      | ASTM D 256           |
| <b>THERMAL</b>                          |                |          |                      |
| HDT, 1.82 MPa, 6.4 mm, unannealed       | 100            | °C       | ASTM D 648           |
| <b>PHYSICAL</b>                         |                |          |                      |
| Specific Gravity                        | 1.1            | -        | ASTM D 792           |
| Water Absorption, 24 hours              | 0.07           | %        | ASTM D 570           |
| Mold Shrinkage, flow, 3.2 mm            | 0.5 – 0.7      | %        | SABIC method         |
| Melt Flow Rate, 250°C/ 10.0 kgf         | 14             | g/10 min | ASTM D 1238          |
| <b>ELECTRICAL</b>                       |                |          |                      |
| Arc Resistance, Tungsten {PLC}          | 6              | PLC Code | ASTM D 495           |
| <b>FLAME CHARACTERISTICS</b>            |                |          |                      |
| UL Compliant, 94V-1 Flame Class Rating  | 0.75           | mm       | UL 94 by SABIC-IP    |
| UL Recognized, 94V-0 Flame Class Rating | 1.2            | mm       | UL 94                |
| UL Recognized, 94-5VB Rating            | 2.5            | mm       | UL 94                |
| <b>INJECTION MOLDING</b>                |                |          |                      |
| Drying Temperature                      | 100 – 105      | °C       |                      |
| Drying Time                             | 3 – 4          | hrs      |                      |
| Drying Time (Cumulative)                | 8              | hrs      |                      |
| Maximum Moisture Content                | 0.02           | %        |                      |
| Melt Temperature                        | 270 – 300      | °C       |                      |
| Nozzle Temperature                      | 270 – 300      | °C       |                      |
| Front - Zone 3 Temperature              | 260 – 300      | °C       |                      |
| Middle - Zone 2 Temperature             | 250 – 295      | °C       |                      |
| Rear - Zone 1 Temperature               | 240 – 290      | °C       |                      |
| Mold Temperature                        | 65 – 95        | °C       |                      |
| Back Pressure                           | 0.3 – 0.7      | MPa      |                      |
| Screw Speed                             | 20 – 100       | rpm      |                      |
| Shot to Cylinder Size                   | 30 – 70        | %        |                      |
| Vent Depth                              | 0.038 – 0.051  | mm       |                      |



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