

NORYL™ RESIN NHP5054

REGION ASIA

TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	120	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	150	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	6000	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	100	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	120	°C	ASTM D 648
Relative Temp Index, Elec	125	°C	UL 746B
Relative Temp Index, Mech w/impact	115	°C	UL 746B
Relative Temp Index, Mech w/o impact	125	°C	UL 746B
PHYSICAL			
Specific Gravity	1.3	-	ASTM D 792
Melt Flow Rate, 250°C/ 10.0 kgf	24	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating	0.75	mm	UL 94
INJECTION MOLDING			
Drying Temperature	105 – 110	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 310	°C	
Nozzle Temperature	280 – 310	°C	
Front - Zone 3 Temperature	270 – 310	°C	
Middle - Zone 2 Temperature	260 – 305	°C	
Rear - Zone 1 Temperature	250 – 300	°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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