

NORYL™ RESIN HN73 1SE

REGION EUROPE

DESCRIPTION

PPE+PS blend. For medical devices and pharmaceutical applications. NORYL HN73 1SE is an unfilled material, with a Vicat B/120 of 135C according ISO 306. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant (restrictions apply).

TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	30	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	15	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	15	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	135	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	115	°C	ISO 75/Ae
PHYSICAL			
Density	1.06	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.23	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	8	cm ³ /10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	100 – 120	°C	
Drying Time	2 – 3	hrs	
Melt Temperature	280 – 300	°C	
Nozzle Temperature	260 – 280	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	260 – 280	°C	
Rear - Zone 1 Temperature	240 – 260	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 120	°C	



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