

# FLEX NORYL™ RESIN WCP921

REGION ASIA

## DESCRIPTION

Flexible NORYL injection molding grade. Low specific gravity with good non-halogenated flame retardant performance. Developed for evaluation in overmolding applications such as plugs, strain reliefs, and connectors. UL 94 V-0 performance with good processability.

## TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 50 mm/min	15	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	150	%	ASTM D 638
Flexural Modulus, 12.5 mm/min, 100 mm span	180	MPa	ASTM D 790
Hardness, Shore A, 30S reading	88	-	ASTM D 2240
Tensile Stress, break, 50 mm/min	15	MPa	ISO 527
Tensile Strain, break, 50 mm/min	140	%	ISO 527
Flexural Modulus, 12.5 mm/min	200	MPa	ISO 178
<b>IMPACT</b>			
Brittleness Temperature	<-40	°C	ASTM D 746
<b>PHYSICAL</b>			
Specific Gravity	1.04	-	ASTM D 792
Water Absorption, 23°C/48hrs	0.06	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.55	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.65	%	ASTM D 955
Melt Flow Rate, 210°C/5 kgf	15	g/10 min	ASTM D 1238
Melt Flow Rate, 250°C/2.16 kgf	17	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Volume Resistivity	7.1E+15	Ohm-cm	ASTM D 257
Dielectric strength in oil, 2.0mm	25	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.8	-	IEC 60250
Dissipation Factor, 1 MHz	0.029	-	IEC 60250
Comparative Tracking Index	600	V	IEC 60112
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-0 Flame Class Rating	6	mm	UL 94
Glow Wire Flammability Index 850°C, passes at	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 3.0 mm	725	°C	IEC 60695-2-13
Oxygen Index (LOI)	24	%	ISO 4589
<b>INJECTION MOLDING</b>			
Drying Temperature	60 – 80	°C	
Drying Time	4 – 6	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.01	%	
Melt Temperature	220 – 250	°C	
Nozzle Temperature	220 – 250	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	220 – 250	°C	
Middle - Zone 2 Temperature	210 – 240	°C	
Rear - Zone 1 Temperature	180 – 220	°C	
Mold Temperature	40 – 60	°C	
Back Pressure	3 – 10	MPa	
Screw Speed	30 – 80	rpm	
Shot to Cylinder Size	30 – 70	%	
Vent Depth	0.03 – 0.05	mm	

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