



NORYL™ Resin EN265
Americas: COMMERCIAL

Extrusion grade. 254F (123C) DTUL. UL94 V-1 rated.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	640	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	25	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1010	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	26000	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	119	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	19	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	13	cm-kgf/cm	ASTM D 256
Gardner, -30°C	152	cm-kgf	ASTM D 3029
Gardner, -40°C	41	cm-kgf	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	123	°C	ASTM D 648
CTE, -40°C to 95°C, flow	5.94E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	110	°C	UL 746B
Relative Temp Index, Mech w/impact	105	°C	UL 746B
Relative Temp Index, Mech w/o impact	110	°C	UL 746B
PHYSICAL			
Specific Gravity	1.08	-	ASTM D 792
Water Absorption, 24 hours	0.07	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
ELECTRICAL			
Dielectric Strength, in oil, 3.2 mm	19.6	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.69	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0007	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495



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ELECTRICAL			
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	1.49	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	5.99	mm	UL 94
Oxygen Index (LOI)	29.2	%	ASTM D 2863
Radiant Panel Listing	RP100	-	UL Tested
UV-light, water exposure/immersion	F1	-	UL 746C



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Extrusion		
Drying Temperature	105 - 115	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	225 - 255	°C
Barrel - Zone 1 Temperature	205	°C
Barrel - Zone 2 Temperature	205	°C
Barrel - Zone 3 Temperature	225	°C
Barrel - Zone 4 Temperature	225	°C
Adapter Temperature	250	°C
Die Temperature	250	°C