



NORYL™ Resin 6850C

Europe-Africa-Middle East: COMMERCIAL

NORYL 6850C is a PPO+PS extrusion grade, it is optimized for blending with polystyrene resins. It is suitable for (microwavable) food packaging and is compliant with US and European food contact regulations.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	70	MPa	ISO 527
Tensile Stress, break, 50 mm/min	70	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	5	%	ISO 527
Tensile Modulus, 1 mm/min	2540	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	107	MPa	ISO 178
Flexural Modulus, 2 mm/min	2580	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	2	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	3	kJ/m ²	ISO 179/1eA
THERMAL			
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate A/120	151	°C	ISO 306
Vicat Softening Temp, Rate B/50	143	°C	ISO 306
Vicat Softening Temp, Rate B/120	145	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Af
PHYSICAL			
Density	1.06	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.25	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	40	cm ³ /10 min	ISO 1133



NORYL™ Resin 6850C
Europe-Africa-Middle East: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL Melt Viscosity, 280°C, 1500 sec-1	133	Pa-s	ISO 11443



NORYL™ Resin 6850C

Europe-Africa-Middle East: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80 - 100	°C
Drying Time	2 - 4	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	60 - 100	°C