



NORYL™ Resin ZM3242

Asia Pacific: COMMERCIAL

Modified PPO* 30% mineral filled products, Non Halogenated Flame Retardant V-1 products. Supper low warpage series, HDT 110degC

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	6	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1060	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	58800	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	2	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	110	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.1E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.35	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.4	%	SABIC Method
Melt Flow Rate, 300°C/2.16 kgf	27	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Compliant, 94V-1 Flame Class Rating (3)(4)	1.5	mm	UL 94 by SABIC-IP



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Melt Temperature	280 - 300	°C
Nozzle Temperature	280 - 300	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	260 - 280	°C
Mold Temperature	70 - 90	°C