

**NORYL® N225X**
Americas: COMMERCIAL

PPE+PS blend. Unfilled. Halogen-Free FR performance. UL94 V0/5VA. UL746C F1. Dielectric Strength. Suitable for E/E market indoor/outdoor applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	67	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	50	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	17	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	99	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2490	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	187	J/m	ASTM D 256
Izod Impact, notched, -30°C	96	J/m	ASTM D 256
Izod Impact, Reverse Notched, 3.2 mm	886	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	39	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	12	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	129	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	109	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	99	°C	ASTM D 648
Relative Temp Index, Elec	95	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	95	°C	UL 746B
PHYSICAL			
Specific Gravity	1.11	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	GE Method
ELECTRICAL			
Volume Resistivity	2.8E+16	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+14	Ohm	ASTM D 257
Dielectric Strength, in oil, 3.2 mm	16.3	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.69	-	ASTM D 150
Relative Permittivity, 1 MHz	2.55	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.01	-	ASTM D 150



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
Dissipation Factor, 1 MHz	0.007	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.4	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94-5VA Rating (3)	3	mm	UL 94
Radiant Panel Listing	YES	-	UL Tested
UV-light, water exposure/immersion	F1	-	UL 746C



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	95 - 100	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	240 - 280	°C
Rear - Zone 1 Temperature	225 - 275	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm