



NORYL™ Resin HM4025H
Asia Pacific: COMMERCIAL

40% GF/MF filled FR PPE/PS blend, high flow

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1180	kgf/cm ²	SABIC - Japan Method
Tensile Strain, break	4 - 6	%	SABIC - Japan Method
Flexural Stress	1570	kgf/cm ²	ASTM D 790
Flexural Modulus	104900	kgf/cm ²	ASTM D 790
Hardness, Rockwell M	90	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	125	°C	ASTM D 648
CTE, -30°C to 30°C	2.1E-05 - 3.3E-05	1/°C	TMA
PHYSICAL			
Specific Gravity	1.44	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.15 - 0.25	%	SABIC Method
Melt Flow Rate, 300°C/2.16 kgf	15.4	g/10 min	ASTM D 1238
ELECTRICAL			
Surface Resistivity	1.E+16	Ohm	ASTM D 257



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	295 - 315	°C
Front - Zone 3 Temperature	280 - 315	°C
Middle - Zone 2 Temperature	270 - 310	°C
Rear - Zone 1 Temperature	260 - 305	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%