



NORYL™ Resin PKN4752F

Americas: COMMERCIAL

PPE+PS blend. High Heat. Translucent with yellow tint in natural color. FDA compliant. Extrusion and Injection Molding. Typical applications include High Performance Food Packaging, Electronics and Healthcare Packaging.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	870	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	750	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	15	%	ASTM D 638
Tensile Modulus, 50 mm/min	30600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1470	kgf/cm ²	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1390	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	32100	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	30000	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	66	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	173	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	160	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	151	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	151	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.58E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.08	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.9	%	SABIC Method



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- Use lower process temperatures when material is let-down.

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Sheet Extrusion		
Drying Temperature	70 - 80	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0	%
Melt Temperature	265 - 275	°C
Barrel - Zone 1 Temperature	205 - 225	°C
Barrel - Zone 2 Temperature	215 - 240	°C
Barrel - Zone 3 Temperature	240 - 265	°C
Barrel - Zone 4 Temperature	240 - 265	°C
Adapter Temperature	240 - 265	°C
Die Temperature	240 - 265	°C
Roll Stack Temp - Top	105 - 120	°C
Roll Stack Temp - Middle	105 - 120	°C
Roll Stack Temp - Bottom	105 - 120	°C