



NORYL™ Resin PN275F
Americas: COMMERCIAL

PPE+PS with low mineral loading. High heat, platable applications. NSF approved for water contact applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	34	%	ASTM D 638
Tensile Modulus, 50 mm/min	21700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	910	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23900	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	21	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	449	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	151	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	136	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	120	°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	1.11	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.9	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	5.3	g/10 min	ASTM D 1238



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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	280 - 310	°C
Nozzle Temperature	280 - 310	°C
Front - Zone 3 Temperature	270 - 310	°C
Middle - Zone 2 Temperature	260 - 305	°C
Rear - Zone 1 Temperature	250 - 300	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%