

**NORYL® N300X**
Americas: COMMERCIAL

PPE+PS blend. Unfilled. Non-brominated, non-chlorinated FR system. UL94 V0. High heat. Dielectric strength. Dimensional stability. Suitable for E/E applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	76	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	20	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	110	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2500	MPa	ASTM D 790
Hardness, Rockwell R	119	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	230	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	156	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	145	°C	ASTM D 648
CTE, -20°C to 150°C, flow	5.4E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	105	°C	UL 746B
Relative Temp Index, Mech w/impact	105	°C	UL 746B
Relative Temp Index, Mech w/o impact	105	°C	UL 746B
PHYSICAL			
Specific Gravity	1.12	-	ASTM D 792
Water Absorption, equilibrium, 23C	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Mold Shrinkage on Tensile Bar, xflow (2)	0.5 - 0.7	%	GE Method
ELECTRICAL			
Volume Resistivity	1.E+17	Ohm-cm	ASTM D 257
Surface Resistivity	1.E+17	Ohm	ASTM D 257
Dielectric Strength, in oil, 3.2 mm	19.4	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.68	-	ASTM D 150
Relative Permittivity, 1 MHz	2.63	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0031	-	ASTM D 150
Dissipation Factor, 1 MHz	0.009	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
High Ampere Arc Ign, surface {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.5	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	110 - 120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 325	°C
Nozzle Temperature	300 - 325	°C
Front - Zone 3 Temperature	290 - 325	°C
Middle - Zone 2 Temperature	275 - 320	°C
Rear - Zone 1 Temperature	265 - 315	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%