NORYL*® *BN5308

Americas: COMMERCIAL *Modified PPO® Alloy*

Blowmolding. 179F (82C) HDT. V-1 capability. High melt strength.

TYPICAL PROPERTIES [1]	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Str, yld, Type I, 50 mm/min	50	MPa	ASTM D 638
Tensile Elong, brk, Type I, 50 mm/min	34	%	ASTM D 638
Flex Stress, yld, 2.6 mm/min, 100 mm span	72	MPa	ASTM D 790
Flex Mod, 2.6 mm/min, 100 mm span	2200	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	401	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	82	°C	ASTM D 648
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.09	-	ASTM D 792
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	1.5	mm	UL 94

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Dry for recommended time and temperature as overdrying can cause loss of physical properties and/or create appearance defects.

PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Extrusion Blow Molding		
Drying Temperature	95	°C
Drying Time	2 - 4	hrs
Melt Temperature (Parison)	210 - 215	°C
Barrel - Zone 1 Temperature	205 - 215	°C
Barrel - Zone 2 Temperature	205 - 215	°C
Barrel - Zone 3 Temperature	205 - 215	°C
Barrel - Zone 4 Temperature	210 - 215	°C
Adapter - Zone 5 Temperature	210 - 215	°C
Head - Zone 6 - Top Temperature	210 - 215	°C
Head - Zone 7 - Bottom Temperature	215 - 220	°C
Mold Temperature	50 - 70	°C
Die Temperature	215 - 220	°C

- As screw speed is increased, shear heating increases; reducing barrel temperatures helps keep melt temperature under control.
- Processing temperature must be measured with a hand-held probe as opposed to an internal-head probe.
- A reverse barrel profile may increase output while maintaining the melt temperature.