NORYL™ RESIN HM4025H

REGION ASIA

DESCRIPTION

NORYL™ HM4025H resin is a 40% glass and mineral filled blend of polyphenylene ether (PPE) + high impact polystyrene (HIPS). This high flow, injection moldable grade contains non-brominated, non-chlorinated flame retardant and carries a UL94 flame ratings of 5VB and V1. NORYL HM4025H resin exhibits good dimensional stability, Low warpage, and low moisture absorption. It is an excellent candidate for printer chassis and other consumer electronic components.

TYPICAL PROPERTY VALUES

Revision 20200130

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	116	MPa	SABIC - Japan Method
Tensile Strain, break	4 – 6	%	SABIC - Japan Method
Flexural Stress	154	MPa	ASTM D 790
Flexural Modulus	10290	MPa	ASTM D 790
Hardness, Rockwell M	90	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	68	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	125	°C	ASTM D 648
CTE, -30°C to 30°C	0.000021 – 0.000033	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	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
FLAME CHARACTERISTICS			
UL Yellow Card Link	E207780-228551	-	-
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	

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Shot to Cylinder Size	30 – 70	%	

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