

NORYL™ PKN4752 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

PPE+PS. Translucent. FDA compliant. High heat. Extrusion. Microwavable. Food, electrical/electronic packaging uses.

General Information			
Features	Heat resistance, high		
Uses	Packaging		
	Electrical/Electronic Applications		
	Food packaging		
Agency Ratings	FDA not rated		
Appearance	Translucent		
Processing Method	Sheet extrusion molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.60 - 0.90	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	3010	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	86.2	MPa	ASTM D638
Fracture	73.8	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	6.0	%	ASTM D638
Fracture	15	%	ASTM D638
Flexural Modulus			ASTM D790
100mm span ⁴	2950	MPa	ASTM D790
50.0mm span ⁵	3150	MPa	ASTM D790
Flexural Strength			ASTM D790
Yield, 50.0mm span ⁶	145	MPa	ASTM D790
Yield, 100mm span ⁷	137	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	32	J/m	ASTM D256
Instrumented Dart Impact (23°C, Total Energy)	6.55	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	161	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	151	°C	ASTM D648

1.8 MPa, unannealed, 6.40mm	152	°C	ASTM D648
Vicat Softening Temperature	174	°C	ASTM D1525 ⁸
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	6.3E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	5.6E-5	cm/cm/°C	ASTM E831

Extrusion	Nominal Value	Unit
Drying Temperature	71.1 - 82.2	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	2.0E-4	%
Cylinder Zone 1 Temp.	204 - 227	°C
Cylinder Zone 2 Temp.	216 - 238	°C
Cylinder Zone 3 Temp.	238 - 266	°C
Cylinder Zone 4 Temp.	238 - 266	°C
Adapter Temperature	238 - 266	°C
Melt Temperature	266 - 277	°C
Die Temperature	238 - 266	°C

Extrusion instructions

Drying Time (Cumulative): 8 hrsRoll Stack Temp - Bottom: 104 - 121 °CRoll Stack Temp - Middle: 104 - 121 °CRoll Stack Temp - Top: 104 - 121 °C

NOTE

- 50 mm/min
- Type 1, 50mm/min
- Type 1, 50mm/min
- 2.6 mm/min
- 1.3 mm/min
- 1.3 mm/min
- 2.6 mm/min
- 标准 B (120°C/h), 载荷2 (50N)

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