

Noryl* Resin PCN2615H

Asia Pacific: LIMITED USE

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 10 mm/min	97	MPa	SABIC - Japan Method
Tensile Stress, brk, Type I, 10 mm/min	97	MPa	SABIC - Japan Method
Tensile Strain, yld, Type I, 10 mm/min	6	%	SABIC - Japan Method
Tensile Strain, brk, Type I, 10 mm/min	6	%	SABIC - Japan Method
Flexural Stress	141	MPa	ASTM D 790
Flexural Modulus	8400	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	54	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	110	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.28E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.39	-	ASTM D 792
Spiral flow (3mm)	655	cm	SABIC Method
Melt Flow Rate, 300°C/2.16 kgf	13.4	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-1 Flame Class Rating (3)	2	mm	UL 94

Source GMD, last updated:2010/01/13

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	90 - 100	°C
Drying Time	2 - 4	hrs
Melt Temperature	280 - 300	°C
Nozzle Temperature	280 - 300	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	260 - 280	°C
Mold Temperature	70 - 90	°C

Source GMD, last updated:2010/01/13

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.
- (5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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