

Noryl* Resin HN731A

Americas: COMMERCIAL

PPE+PS blend. For medical devices and pharmaceutical applications. Healthcare management of change, biocompatible (ISO 10993 or USP Class VI), food contact compliant (restrictions apply). Combines good hydrolytic stability and dimensional stability.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	49	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7.2	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	28.1	%	ASTM D 638
Tensile Modulus, 50 mm/min	2860	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	89	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2640	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2420	MPa	ASTM D 790
Hardness, Rockwell R	119	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	30	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	213	J/m	ASTM D 256
Izod Impact, notched, -40°C	133	J/m	ASTM D 256
Gardner, -30°C	25	J	ASTM D 3029
Gardner, -40°C	5	J	ASTM D 3029
Instrumented Impact Total Energy, 23°C	48	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	15	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	15	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	148	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	131	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	117	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.18E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.54E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	135	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306

HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	115	°C	ISO 75/Af
Relative Temp Index, Elec	105	°C	UL 746B
Relative Temp Index, Mech w/impact	90	°C	UL 746B
Relative Temp Index, Mech w/o impact	105	°C	UL 746B
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	9.2	g/10 min	ASTM D 1238
Density	1.06	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.23	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL	Value	Unit	Standard
Dielectric Strength, in oil, 3.2 mm	21.6	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.65	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0004	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94
CSA (See File for complete listing)	LS88480	File No.	CSA LISTED
Oxygen Index (LOI)	22	%	ASTM D 2863

Source GMD, last updated:05/29/2007

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 310	°C
Nozzle Temperature	280 - 310	°C
Front - Zone 3 Temperature	270 - 310	°C
Middle - Zone 2 Temperature	260 - 305	°C
Rear - Zone 1 Temperature	250 - 300	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%

Source GMD, last updated:05/29/2007

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.

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