

Noryl* Resin PKN4736

Americas: LIMITED USE

PPE+PS blend. Opaque. FDA compliant in limited colors. Good ESCR. Extrusion and Injection Molding. Typical applications include High Performance Food Packaging. PKN4775 is similar product with improved processability.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	64	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	55	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	9.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	28	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	99	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2280	MPa	ASTM D 790
Hardness, Rockwell R	118	-	ASTM D 785
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	96	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	155	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	143	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	129	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.06	-	ASTM D 792

Source GMD, last updated:01/05/2000

Processing

Parameter	Value	Unit
Extrusion		
Drying Temperature	70 - 80	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	270 - 305	°C
Barrel - Zone 1 Temperature	260 - 280	°C
Barrel - Zone 2 Temperature	270 - 295	°C
Barrel - Zone 3 Temperature	270 - 305	°C
Barrel - Zone 4 Temperature	270 - 305	°C
Adapter Temperature	270 - 305	°C
Die Temperature	270 - 305	°C

Source GMD, last updated:01/05/2000

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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