

## Noryl\* Resin SE1GFN2

### Americas: COMMERCIAL

PPE+PS blend. 20% Glass reinforced. Non-brominated, non-chlorinated FR system. UL94 V1 and 5VA listing. RTI 110/105/110. Dielectric strength. Dimensional stability. Suitable for E/E applications.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	1080	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	5	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1540	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	58300	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Rockwell L	106	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	9	cm-kgf/cm	ASTM D 256
<b>THERMAL</b>			
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 95°C, flow	3.6E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	110	°C	UL 746B
Relative Temp Index, Mech w/impact	105	°C	UL 746B
Relative Temp Index, Mech w/o impact	110	°C	UL 746B
<b>PHYSICAL</b>			
Specific Gravity	1.23	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.5	%	SABIC Method
<b>ELECTRICAL</b>			
Dielectric Strength, in oil, 3.2 mm	23.6	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.98	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0016	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. Not to be used for part or tool design.  
3) This rating is not intended to reflect hazards presented this or any other material under actual fire conditions.  
4) Own measurement according to UL.  
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.

Source, GMD, Last Update:

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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	UNIT	STANDARD
<b>ELECTRICAL</b>			
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-1 Flame Class Rating (3)	1.47	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	5.99	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.5	mm	UL 94
Oxygen Index (LOI)	30.9	%	ASTM D 2863

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
<b>Injection Molding</b>		
Drying Temperature	110 - 120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 325	°C
Nozzle Temperature	300 - 325	°C
Front - Zone 3 Temperature	290 - 325	°C
Middle - Zone 2 Temperature	275 - 320	°C
Rear - Zone 1 Temperature	265 - 315	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%

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