



NORYL™ Resin APS130
Asia Pacific: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1150	kgf/cm ²	SABIC - Japan Method
Tensile Strain, break	8 - 8	%	SABIC - Japan Method
Flexural Stress	1590	kgf/cm ²	ASTM D 790
Flexural Modulus	85900	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	267	°C	ASTM D 648
CTE, -30°C to 30°C	2.5E-05 - 5.5E-05	1/°C	TMA
PHYSICAL			
Specific Gravity	1.44	-	ASTM D 792
Water Absorption, 24 hours	0.02	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.25 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/5.0 kgf	29.1	g/10 min	ASTM D 1238
ELECTRICAL			
Surface Resistivity	1.E+16	Ohm	ASTM D 257
Dielectric Strength, in oil, 1.6 mm	22.1	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.3	-	ASTM D 150

(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.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4 - 8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 330	°C
Nozzle Temperature	300 - 330	°C
Front - Zone 3 Temperature	295 - 325	°C
Middle - Zone 2 Temperature	290 - 320	°C
Rear - Zone 1 Temperature	280 - 315	°C
Mold Temperature	95 - 150	°C
Back Pressure	0.7 - 1.4	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

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