

Noryl* Resin PN235

Americas: COMMERCIAL

Plating grade, primarily automotive applications.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	37	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	72	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	55	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	1820	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	347	J/m	ASTM D 256
Izod Impact, notched, -40°C	133	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	112	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	104	°C	ASTM D 648
CTE, 0°C to 100°C, flow	7.56E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.05	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	2	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	0	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

Source GMD, last updated:01/05/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	265 - 295	°C
Nozzle Temperature	265 - 295	°C
Front - Zone 3 Temperature	255 - 295	°C
Middle - Zone 2 Temperature	245 - 290	°C

Rear - Zone 1 Temperature	230 - 280	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm

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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