



NORYL™ Resin EN265
Americas: COMMERCIAL

Extrusion grade. 254F (123C) DTUL. UL94 V-1 rated.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 2.0 in/min	9100	psi	ASTM D 638
Tensile Strain, brk, Type I, 2.0 in/min	25	%	ASTM D 638
Flexural Stress, yld, 0.10 in/min, 4 in span	14300	psi	ASTM D 790
Flexural Modulus, 0.10 in/min, 4 in span	369000	psi	ASTM D 790
Hardness, Rockwell R	119	-	ASTM D 785
IMPACT			
Izod Impact, notched, 73°F	3.5	ft-lb/in	ASTM D 256
Izod Impact, notched, -40°F	2.5	ft-lb/in	ASTM D 256
Gardner Impact, -22°F	10	ft-lb	ASTM D 3029
Gardner Impact, -40°F	2	ft-lb	ASTM D 3029
THERMAL			
HDT, 264 psi, 0.250 in, unannealed	254	°F	ASTM D 648
CTE, flow, -40°F to 200°F	3.3E-05	1/°F	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
PHYSICAL			
Specific Gravity	1.08	-	ASTM D 792
Water Absorption, 24 hours @ 73°F	0.07	%	ASTM D 570
Mold Shrinkage, flow, 0.125" (5)	0.5 - 0.7	%	SABIC Method
ELECTRICAL			
Dielectric Strength, in oil, 125 mils	500	V/mil	ASTM D 149
Relative Permittivity, 50/60 Hz	2.69	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0007	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495

(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.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	0.059	in	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	0.236	in	UL 94
Oxygen Index (LOI)	29.2	%	ASTM D 2863
Radiant Panel Listing	RP100	-	UL Tested
UV-light, water exposure/immersion	F1	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Extrusion		
Drying Temperature	220 - 240	°F
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	440 - 490	°F
Barrel - Zone 1 Temperature	400	°F
Barrel - Zone 2 Temperature	400	°F
Barrel - Zone 3 Temperature	440	°F
Barrel - Zone 4 Temperature	440	°F
Adapter Temperature	480	°F
Die Temperature	480	°F

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