



NORYL™ Resin RN0206

Asia Pacific: COMMERCIAL

RN0206 is an unfilled Post Consumer Recycle (PCR) based injection moldable modified polyphenylene ether resin comprising at least 10% PCR styrenic series resin content. Available in black only.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	740	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	14	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1010	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	25400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	18	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	118	°C	ASTM D 648
Ball Pressure Test, approximate maximum	120	°C	IEC 60695-10-2
PHYSICAL			
Specific Gravity	1.1	-	ASTM D 792
Melt Flow Rate, 250°C/10.0 kgf	5	g/10 min	ASTM D 1238
ELECTRICAL			
Dielectric Strength, in air, 3.2 mm	27	kV/mm	ASTM D 149
Hot Wire Ignition {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	0.75	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	275 - 305	°C
Nozzle Temperature	275 - 305	°C
Front - Zone 3 Temperature	265 - 305	°C
Middle - Zone 2 Temperature	255 - 300	°C
Rear - Zone 1 Temperature	245 - 295	°C
Mold Temperature	70 - 100	°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