



NORYL™ Resin PKN4752

Europe-Africa-Middle East: COMMERCIAL

NORYL PKN4752 is a translucent, high heat PPO+PS extrusion grade for dilution with polystyrene resin. It is suitable for (microwavable) food packaging and is compliant with US and European food contact regulations.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 50 mm/min	86	MPa	ISO 527
Tensile Strain, break, 50 mm/min	6	%	ISO 527
Tensile Modulus, 1 mm/min	3100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	130	MPa	ISO 178
Flexural Modulus, 2 mm/min	2950	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	3	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	2	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	2	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate A/50	174	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	163	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	147	°C	ISO 75/Ae
PHYSICAL			
Density	1.08	g/cm ³	ISO 1183



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Profile Extrusion		
Drying Temperature	80 - 95	°C
Drying Time	2 - 4	hrs
Melt Temperature	280 - 300	°C
Barrel - Zone 1 Temperature	215 - 240	°C
Barrel - Zone 2 Temperature	225 - 250	°C
Barrel - Zone 3 Temperature	250 - 275	°C
Barrel - Zone 4 Temperature	250 - 275	°C
Hopper Temperature	50 - 70	°C
Adapter Temperature	250 - 275	°C
Die Temperature	250 - 275	°C
Calibrator Temperature	60 - 80	°C