

NORYLTM PPOTM POWDER 6850C

REGION EUROPE

DESCRIPTION

NORYL 6850C is a PPO+PS extrusion grade, it is optimized for blending with polystyrene resins. It is suitable for (microwavable) food packaging and is compliant with US and European food contact regulations.

TYPICAL PROPERTY VALUES

Revision 20180905

MECHANICAL Tensile Stress, yield, 50 mm/min 70 MPa ISO 527 Tensile Stress, break, 50 mm/min 70 MPa ISO 527 Tensile Strain, yield, 50 mm/min 5 % ISO 527 Tensile Strain, break, 50 mm/min 5 % ISO 527 Tensile Modulus, 1 mm/min 2540 MPa ISO 527 Flexural Stress, yield, 2 mm/min 107 MPa ISO 178 Flexural Modulus, 2 mm/min 2580 MPa ISO 178 IMPACT Izod Impact, notched 80*10*4+23°C 4 kl/m² ISO 180/1A Izod Impact, notched 80*10*4+23°C 4 kl/m² ISO 180/1A Izod Impact, notched 80*10*4-30°C 2 kl/m² ISO 180/1A Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm 4 kl/m² ISO 179/1eA Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm 7.E-05 1/°C ISO 1359-2 THERMAL CTE, -40°C to 40°C, flow 7.E-05 1/°C ISO 11359-2 CTE, -40°C to 40°C, flow 7.E-05 1/°C ISO 11359-2 Vicat Softening T	
Tensile Stress, break, 50 mm/min 70 MPa ISO 527 Tensile Strain, yield, 50 mm/min 5 % ISO 527 Tensile Strain, break, 50 mm/min 5 % ISO 527 Tensile Modulus, 1 mm/min 2540 MPa ISO 178 Flexural Stress, yield, 2 mm/min 107 MPa ISO 178 IMPACT IMPACT Impact, notched 80*10*4+23°C 4 Impact, notched 80*10*4+23°C 2 Impact, notched 80*10*4 sp=62mm ISO 180/1A Lzod Impact, notched 80*10*4-30°C 2 Impact, notched 80*10*4 sp=62mm 4 Impact, notched 80*10*4 sp=62mm 3 Impact, notched 80*10*4 sp=62mm 3 Impact, notched 80*10*4 sp=62mm 3 Impact, notched 80*10*4 sp=62mm 4 Impact, notched 80*10*4 sp=62mm 1 5 15	
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Tensile Strain, break, 50 mm/min 5 % ISO 527 Tensile Modulus, 1 mm/min 2540 MPa ISO 527 Flexural Stress, yield, 2 mm/min 107 MPa ISO 178 IMPACT Izod Impact, notched 80*10*4 +23°C 4 kJ/m² ISO 180/1A Izod Impact, notched 80*10*4 -30°C 2 kJ/m² ISO 180/1A Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm 4 kJ/m² ISO 179/1eA Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm 3 kJ/m² ISO 179/1eA THERMAL CTE, -40°C to 40°C, flow 7.E·05 1/°C ISO 11359-2 CTE, -40°C to 40°C, xflow 7.E·05 1/°C ISO 11359-2 Vicat Softening Temp, Rate A/120 151 °C ISO 306 Vicat Softening Temp, Rate B/120 143 °C ISO 306 Vicat Softening Temp, Rate B/120 145 °C ISO 306 HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm 125 °C ISO 75/Af PHYSICAL Density 1.06 9/cm³ IS	
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Flexural Stress, yield, 2 mm/min 107 MPa ISO 178 Flexural Modulus, 2 mm/min 2580 MPa ISO 178 IMPACT Izod Impact, notched 80*10*4 +23°C 4 kJ/m² ISO 180/1A Izod Impact, notched 80*10*4-30°C 2 kJ/m² ISO 180/1A Izod Impact, notched 80*10*4 sp=62mm 4 kJ/m² ISO 179/1eA Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm 3 kJ/m² ISO 179/1eA THERMAL THERMAL THERMAL THERMAC THERM	
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Density 1.06 g/cm³ ISO 1183	
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Water Absorption, (23°C/sat) 0.25 % ISO 62	
Moisture Absorption (23°C / 50% RH) 0.06 % ISO 62	
Melt Volume Rate, MVR at 280°C/5.0 kg 40 cm³/10 min ISO 1133	
Melt Viscosity, 280°C, 1500 sec-1 133 Pa-s ISO 11443	
INJECTION MOLDING	
Drying Temperature 80 – 100 °C	
Drying Time 2 – 4 hrs	
Melt Temperature 280 – 300 °C	
Nozzle Temperature 260 – 280 °C	
Front - Zone 3 Temperature 280 – 300 °C	
Middle - Zone 2 Temperature 260 – 280 °C	
Rear - Zone 1 Temperature 240 – 260 °C	
Hopper Temperature 60 – 80 °C	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Temperature	60 – 100	°C	

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