

## Noryl\* Resin BN5308

Americas: COMMERCIAL

Blowmolding. 179F (82C) HDT. V-1 capability. High melt strength.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	50	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	34	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	71	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2190	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	400	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	81	°C	ASTM D 648
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	Value	Unit	Standard
Specific Gravity	1.09	-	ASTM D 792
FLAME CHARACTERISTICS	Value	Unit	Standard
UL Recognized, 94V-1 Flame Class Rating (3)	1.47	mm	UL 94

Source GMD, last updated:01/05/2000

### Processing

- Dry for recommended time and temperature as overdrying can cause loss of physical properties and/or create appearance defects.

Parameter	Value	Unit
Extrusion Blow Molding		
Drying Temperature	95	°C
Drying Time	2 - 4	hrs
Melt Temperature (Parison)	210 - 215	°C
Barrel - Zone 1 Temperature	205 - 215	°C
Barrel - Zone 2 Temperature	205 - 215	°C
Barrel - Zone 3 Temperature	205 - 215	°C
Barrel - Zone 4 Temperature	210 - 215	°C
Adapter - Zone 5 Temperature	210 - 215	°C
Head - Zone 6 - Top Temperature	210 - 215	°C
Head - Zone 7 - Bottom Temperature	215 - 220	°C
Mold Temperature	50 - 70	°C
Die Temperature	215 - 220	°C

Source GMD, last updated:01/05/2000

- As screw speed is increased, shear heating increases; reducing barrel temperatures helps keep melt temperature under control.
- Processing temperature must be measured with a hand-held probe as opposed to an internal-head probe.
- A reverse barrel profile may increase output while maintaining the melt temperature.

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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