



## Noryl\* Resin WCA105

**Americas: COMMERCIAL** 

Flexible, non-halogenated FR mPPE extrusion grade ideal for evaluation in applications such as wire insulation. Flame retardant performance capable of meeting VW1 and 105C temperature rating requirements as defined by UL 1581. 56 Shore D hardness. Excellent processing using standard extrusion equipment. UL 1581 tests conducted on 2.0 mm wire with 0.12 mm x 20 stranded copper conductor.

## **Property**

Tensile Stress, brk, Type I, 50 mm/min         23         MPa         ASTR           Flexural Modulus, 12.5 mm/min, 100 mm span         650         MPa         ASTR           Flexural Modulus, 12.5 mm/min, 100 mm span         650         MPa         ASTR           Tensile Strain, brk, Type I, 50 mm/min         23         MPa         ISC           Tensile Strain, break, 50 mm/min         90         %         ISC           Tensile Strain, break, 50 mm/min         720         MPa         ISC           Flexural Modulus, 12.5 mm/min         720         MPa         ISC           Hardness, Shore D         56         -         ISC           Tear strength         25         N/mm         ISC           Impact         Value         Unit         Sta           Brittleness Temperature         <-40         °C         ASTR           THERMAL         Value         Unit         Sta           HDT, 0.45 MPa, 6.4 mm, unannealed         85         °C         ASTR           Vical Softening Temp, Rate A/50         102         °C         ISC           PHYSICAL         Value         Unit         Sta           Specific Gravity         10.1         %         ASTM           W	TYPICAL PROPERTIES (1)			
Tensile Strain, brk, Type I, 50 mm/min         85         %         ASTI           Flexural Modulus, 12.5 mm/min, 100 mm span         650         MPa         ASTI           Tensile Stress, break, 50 mm/min         90         %         ISC           Tensile Strain, break, 50 mm/min         90         %         ISC           Flexural Modulus, 12.5 mm/min         720         MPa         ISC           Hardness, Shore D         56         -         ISC           Impact Manager         25         N/mm         ISC           IMPACT         Value         Unit         Sta           Brittleness Temperature         <-40         °C         ASTI           HDT, 0.45 MPa, 6.4 mm, unannealed         85         °C         ASTI           Vicat Softening Temp, Rate A/50         102         °C         ISC           PHYSICAL         Value         Unit         Sta           Specific Gravity         1.03         -         ASTI           Water Absorption, 23°C/48hrs         0.1         %         ASTI           Melt Flow Rate, 250°C/10.0 kgf         5.1         g/10         MSTI           ELECTRICAL         Value         Unit         Sta           Volume Resistivity <td< th=""><th>MECHANICAL</th><th>Value</th><th>Unit</th><th>Standard</th></td<>	MECHANICAL	Value	Unit	Standard
Flexural Modulus, 12.5 mm/min, 100 mm span   650 MPa   ASTM   Tensile Stress, break, 50 mm/min   23 MPa   IST   Tensile Strain, break, 50 mm/min   90 %   IST   ST   ST   ST   ST   ST   ST   S	Tensile Stress, brk, Type I, 50 mm/min	23	MPa	ASTM D 638
Tensile Stress, break, 50 mm/min         23         MPa         ISC           Tensile Strain, break, 50 mm/min         90         %         ISC           Flexural Modulus, 12.5 mm/min         720         MPa         ISC           Hardness, Shore D         56         - ISC           Tear strength         25         N/mm         ISC           IMPACT         Value         Unit         Sta           Brittleness Temperature         <-40	Tensile Strain, brk, Type I, 50 mm/min	85	%	ASTM D 638
Tensile Strain, break, 50 mm/min   90	Flexural Modulus, 12.5 mm/min, 100 mm span	650	MPa	ASTM D 790
Flexural Modulus, 12.5 mm/min	Tensile Stress, break, 50 mm/min	23	MPa	ISO 527
Hardness, Shore D	Tensile Strain, break, 50 mm/min	90	%	ISO 527
Tear strength         25         N/mm         ISC           IMPACT         Value         Unit         Sta           Brittleness Temperature         < -40         °C         ASTI           THERMAL         Value         Unit         Sta           HDT, 0.45 MPa, 6.4 mm, unannealed         85         °C         ASTI           Vicat Softening Temp, Rate A/50         102         °C         ISC           PHYSICAL         Value         Unit         Sta           Specific Gravity         1.03         -         ASTI           Water Absorption, 23°C/48hrs         0.1         %         ASTI           Melt Flow Rate, 250°C/10.0 kgf         5.1         g/10         min         ASTI           Melt Flow Rate, 250°C/10.0 kgf         5.1         g/10         min         ASTI           Melt Flow Rate, 250°C/10.0 kgf         5.1         g/10         Min         ASTI           ELECTRICAL         Value         Unit         Sta           Volume Resistivity         3.9E+16         Ohm- min         ASTI           Dielectric strength in oil, 2.0mm         2.6         kV/rmm         IEC           Relative Permittivity, 50/60 Hz         2.6         -         IEC <t< td=""><td>Flexural Modulus, 12.5 mm/min</td><td>720</td><td>MPa</td><td>ISO 178</td></t<>	Flexural Modulus, 12.5 mm/min	720	MPa	ISO 178
IMPACT         Value         Unit         State           Brittleness Temperature         <-40	Hardness, Shore D	56	-	ISO 868
Brittleness Temperature	Tear strength	25	N/mm	ISO 6383
THERMAL         Value         Unit         State (C)         ASTM (C)         AS	IMPACT	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	Brittleness Temperature	<-40	°C	ASTM D 746
Vicat Softening Temp, Rate A/50         102         °C         ISC           PHYSICAL         Value         Unit         Sta           Specific Gravity         1.03         -         ASTI           Water Absorption, 23°C/48hrs         0.1         %         ASTI           Melt Flow Rate, 250°C/10.0 kgf         5.1         g/10 min         ASTI           ELECTRICAL         Value         Unit         Sta           Volume Resistivity         3.9E+16         Ohm-cm         IEC           Dielectric strength in oil, 2.0mm         26         kV/mm         IEC           Relative Permittivity, 50/60 Hz         2.6         -         IEC           Relative Permittivity, 1 MHz         2.5         -         IEC           Dissipation Factor, 50/60 Hz         0.024         -         IEC           Dissipation Factor, 50/60 Hz         0.024         -         IEC           Comparative Tracking Index         600         V         IEC           Comparative Tracking Index         600         V         IEC           FLAME CHARACTERISTICS         Value         Unit         Sta           Smoke Density on 0.5mm plaque, Non-flame, Ds, max         75         -         ASTI           G	THERMAL	Value	Unit	Standard
PHYSICAL	HDT, 0.45 MPa, 6.4 mm, unannealed	85	°C	ASTM D 648
Specific Gravity	Vicat Softening Temp, Rate A/50	102	°C	ISO 306
Water Absorption, 23°C/48hrs         0.1         %         ASTM           Melt Flow Rate, 250°C/10.0 kgf         5.1         g/10 min         ASTM           ELECTRICAL         Value         Unit         Sta           Volume Resistivity         3.9E+16         Ohm-cm         IEC           Dielectric strength in oil, 2.0mm         26         kV/mm         IEC           Relative Permittivity, 50/60 Hz         2.6         -         IEC           Relative Permittivity, 1 MHz         2.5         -         IEC           Dissipation Factor, 50/60 Hz         0.024         -         IEC           Dissipation Factor, 1 MHz         0.0038         -         IEC           Comparative Tracking Index         600         V         IEC           FLAME CHARACTERISTICS         Value         Unit         Sta           Smoke Density on 0.5mm plaque, Non-flame, Ds, max         75         -         ASTM           Glow Wire Flammability Index 960°C, passes at         3         mm         IEC         6           Glow Wire Ignitability Temperature, 3.0 mm         750         °C         IEC         6           Oxygen Index (LOI)         25         %         ISC           WIRE AND CABLE - UL 1581 tested on 2.0mm wire wi	PHYSICAL	Value	Unit	Standard
Melt Flow Rate, 250°C/10.0 kgf         5.1         g/10 min         ASTM           ELECTRICAL         Value         Unit         Sta           Volume Resistivity         3.9E+16         Ohm-cm         IEC           Dielectric strength in oil, 2.0mm         26         kV/mm         IEC           Relative Permittivity, 50/60 Hz         2.6         -         IEC           Relative Permittivity, 1 MHz         2.5         -         IEC           Dissipation Factor, 50/60 Hz         0.024         -         IEC           Dissipation Factor, 1 MHz         0.0038         -         IEC           Comparative Tracking Index         600         V         IEC           FLAME CHARACTERISTICS         Value         Unit         Sta           Smoke Density on 0.5mm plaque, Non-flame, Ds, max         75         -         ASTM           Smoke Density on 0.5mm plaque, Flame, Ds, max         150         -         ASTM           Glow Wire Flammability Index 960°C, passes at         3         mm         IEC         6           Oxygen Index (LOI)         25         %         ISC           WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded         Value         Unit         Sta	Specific Gravity	1.03	-	ASTM D 792
ELECTRICAL  Value Unit Sta  Volume Resistivity  3.9E+16 Ohm-cm Electric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 50/60 Hz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  To ASTM  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  To Coxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta  Value Unit Sta	Water Absorption, 23°C/48hrs	0.1	%	ASTM D 570
Volume Resistivity  3.9E+16	Melt Flow Rate, 250°C/10.0 kgf	5.1	-	ASTM D 1238
Volume Resistivity  3.9E+16 cm IEC  Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 50/60 Hz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  To ASTI  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  To Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To ASTI  Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Non-flame, Ds, max  To ASTI  Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To ASTI  Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Non-flame, Ds, max  To ASTI  Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Non-flame, Ds, max  To ASTI  Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To ASTI  Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To ASTI  Comparative Tracking Index  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5mm plaque, Flame, Ds, max  To Smoke Density on 0.5m	ELECTRICAL	Value	Unit	Standard
Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  Too Coxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  2.6 - IEC -				
Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 50/60 Hz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  Relative Permittivity, 1 MHz  2.5  - IEC  0.0038 - IEC  600  V IEC  FLAME CHARACTERISTICS  Value  Unit  Sta  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  750  C IEC 6  Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value  Unit  Sta	Volume Resistivity	3.9E+16		IEC 60093
Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  Dissipation Factor, 50/60 Hz  0.0024  - IEC  0.0038  - IEC  0.0038  - IEC  0.0038  To	,		cm	IEC 60093
Dissipation Factor, 1 MHz  Comparative Tracking Index  600 V IEC  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Flame, Ds, max  500 Smoke Density on 0.5mm plaque, Non-flame, Ds, max  500 Smoke Density on 0.5m	Dielectric strength in oil, 2.0mm	26	cm kV/mm	
Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  Too C  IEC 6  Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz	26 2.6	cm kV/mm	IEC 60243-1
FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  750  C  IEC 6  Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz	26 2.6 2.5	cm kV/mm	IEC 60243-1 IEC 60250
Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  150 - ASTM  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  750 °C  IEC 6  Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz	26 2.6 2.5 0.024	cm kV/mm - -	IEC 60243-1 IEC 60250 IEC 60250
Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  750 °C  IEC 6  Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz	26 2.6 2.5 0.024 0.0038	cm kV/mm - - -	IEC 60243-1 IEC 60250 IEC 60250 IEC 60250
Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  750 °C  IEC 6  Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index	26 2.6 2.5 0.024 0.0038 600	cm kV/mm - - - V	IEC 60243-1 IEC 60250 IEC 60250 IEC 60250 IEC 60250
Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm  750 °C IEC 6  Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS	26 2.6 2.5 0.024 0.0038 600 <b>Value</b>	cm kV/mm - - - - V Unit	IEC 60243-1 IEC 60250 IEC 60250 IEC 60250 IEC 60250 IEC 60112
Oxygen Index (LOI)  WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max	26 2.6 2.5 0.024 0.0038 600 <b>Value</b> 75	cm kV/mm  V Unit -	IEC 60243-1 IEC 60250 IEC 60250 IEC 60250 IEC 60250 IEC 60112 Standard
WIRE AND CABLE - UL 1581 tested on 2.0mm wire with 0.12mmx20 stranded  Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max	26 2.6 2.5 0.024 0.0038 600 <b>Value</b> 75 150	cm kV/mm  V Unit	IEC 60243-1 IEC 60250 IEC 60250 IEC 60250 IEC 60250 IEC 60112 Standard ASTM E 662
Value Unit Sta	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at	26 2.6 2.5 0.024 0.0038 600 <b>Value</b> 75 150	cm kV/mm  V Unit - mm	IEC 60243-1 IEC 60250 IEC 60250 IEC 60250 IEC 60250 IEC 60112 Standard ASTM E 662 ASTM E 662 IEC 60695-2-
Сорре	Dielectric strength in oil, 2.0mm  Relative Permittivity, 50/60 Hz  Relative Permittivity, 1 MHz  Dissipation Factor, 50/60 Hz  Dissipation Factor, 1 MHz  Comparative Tracking Index  FLAME CHARACTERISTICS  Smoke Density on 0.5mm plaque, Non-flame, Ds, max  Smoke Density on 0.5mm plaque, Flame, Ds, max  Glow Wire Flammability Index 960°C, passes at  Glow Wire Ignitability Temperature, 3.0 mm	26 2.6 2.5 0.024 0.0038 600 <b>Value</b> 75 150 3	cm kV/mm  V Unit - mm	IEC 60243-1 IEC 60250 IEC 60250 IEC 60250 IEC 60250 IEC 60112 Standard ASTM E 662 ASTM E 662 IEC 60695-2- 12 IEC 60695-2-

Tensile strength @ break	33	MPa	UL 1581
Tensile elongation @ break	197	%	UL 1581
Tensile strength @ break after 7days @136°C	36	MPa	UL 1581
Tensile elongation @ break after 7days @136°C	156	%	UL 1581
UL temperature rating	105	°C	UL 1581
Heat Deformation at 121°C/250g	26	%	UL 1581
VW-1	Pass	-	UL 1581

Source GMD, last updated:07/11/2005

## **Processing**

Parameter		
Wire Coating Extrusion	Value	Unit
Drying Temperature	60 - 80	°C
Drying Time	4 - 6	hrs
Drying Time (Cumulative)	12	hrs
Maximum Moisture Content	0.02	%
Extruder Length/Diameter Ratio (L/D)	22:1 to 26:1	-
Screw Speed	15 - 40	rpm
Feed Zone Temperature	210 - 260	°C
Middle Zone Temperatures	230 - 285	°C
Head Zone Temperature	250 - 285	°C
Neck Temperature	250 - 285	°C
Cross-head Temperature	250 - 285	°C
Die Temperature	250 - 285	°C
Melt Temperature	250 - 285	°C
Conductor Pre-heat Temperature	80 - 150	°C
Screen Pack	150 - 100	-
Cooling Water Air Gap	100 - 200	mm
Water Bath Temperature	15 - 80	°C

Source GMD, last updated:07/11/2005

• NOTE: Recommended Drying Parameters are based on usage of Dehumidify Drying / Drying Oven.

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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