NORYL™ RESIN PX0844

REGION ASIA

DESCRIPTION

NORYL™ PX0844 resin is a non-reinforced blend of polyphenylene ether (PPE) + high impact polystyrene (HIPS). This grade exhibits very low moisture absorption, hydrolytic stability, dimensional stabilty, good foam adhesion, and property retention over a wide temperature range. NORYL PX0844 resin is inherently UL94 HB and is an excellent candidate for automotive interior applications such as instrument panels, audio components, speaker housings, and interior trim. *see NORYL PX0888 resin for higher heat resistance.

TYPICAL PROPERTY VALUES

Revision 20190110

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	49	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	30	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	75	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2240	MPa	ASTM D 790
Hardness, Rockwell R	114	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	234	J/m	ASTM D 256
Izod Impact, notched, -40°C	133	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	112	°C	ASTM D 648
CTE, 0°C to 100°C, flow	7.38E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
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	

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