NORYL™ RESIN PX0888

REGION ASIA

DESCRIPTION

NORYL™ PX0888 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 PX0888 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.

TYPICAL PROPERTY VALUES

Revision 20191022

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	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	93	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2350	MPa	ASTM D 790
Hardness, Rockwell R	118	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	197	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	129	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	127	°C	ASTM D 648
CTE, 0°C to 100°C, flow	7.38E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.04	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Volume Rate, MVR at 300°C/2.16 kg	6	cm³/10 min	ISO 1133
INJECTION MOLDING			
Drying Temperature	105 – 110	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 310	°C	
Nozzle Temperature	280 – 310	°C	
Front - Zone 3 Temperature	270 – 310	°C	
Middle - Zone 2 Temperature	260 – 305	°C	
Rear - Zone 1 Temperature	250 – 300	°C	
Mold Temperature	75 – 105	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	

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