



NORYL™ Resin EZ250
Americas: COMMERCIAL

Automotive wheel covers. Offers superior processability/flow and better chemical resistance when exposed to many automotive fluids over PX0844.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	450	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	40	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	690	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	20300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	29	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	403	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -40°C	345	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	126	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	112	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.07	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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