



NORYL™ Resin PVX0800
Americas: COMMERCIAL

NORYL PVX0800 resin is a high flow, V0 = 1.5 mm grade, suitable for a variety of electronics applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	580	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	430	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	15	%	ASTM D 638
Tensile Modulus, 50 mm/min	27200	kgf/cm ²	ASTM D 638
Flexural Stress, yield, 6.4 mm	890	kgf/cm ²	ASTM D 790
Flexural Stress, yld, 1.3 mm/min, 50 mm span	870	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	27500	kgf/cm ²	ASTM D 790
Flexural Modulus, 6.4 mm	27500	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	53	MPa	ISO 527
Tensile Stress, break, 50 mm/min	42	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.7	%	ISO 527
Tensile Strain, break, 50 mm/min	26.6	%	ISO 527
Tensile Modulus, 1 mm/min	2580	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	83	MPa	ISO 178
Flexural Modulus, 2 mm/min	2390	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	25	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	305	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m ²	ISO 180/1A



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Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	98	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	88	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	78	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	92	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	82	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	79	°C	ISO 75/Af
Relative Temp Index, Elec	65	°C	UL 746B
Relative Temp Index, Mech w/impact	65	°C	UL 746B
Relative Temp Index, Mech w/o impact	65	°C	UL 746B
PHYSICAL			
Specific Gravity	1.11	-	ASTM D 792
Melt Flow Rate, 230°C/5 kgf	6	g/10 min	ASTM D 1238
Moisture Absorption (23°C / 50% RH)	0.07	%	ISO 62
Melt Volume Rate, MVR at 260°C/5.0 kg	22	cm ³ /10 min	ISO 1133
Melt Volume Rate, MVR at 280°C/5.0 kg	47	cm ³ /10 min	ISO 1133
Melt Viscosity, 280°C, 1500 sec-1	98	Pa-s	ISO 11443
ELECTRICAL			
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	3	PLC Code	UL 746A
Volume Resistivity	1.E+16	Ohm-cm	IEC 60093
Comparative Tracking Index	250	V	IEC 60112
FLAME CHARACTERISTICS			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	1.5	mm	UL 94 by SABIC-IP



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	75 - 80	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 275	°C
Nozzle Temperature	250 - 275	°C
Front - Zone 3 Temperature	240 - 275	°C
Middle - Zone 2 Temperature	225 - 270	°C
Rear - Zone 1 Temperature	215 - 265	°C
Mold Temperature	55 - 75	°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