+135-3858-6433 (GuangDong)
+188-1699-6168 (ShangHai)
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NORYL™ Resin PX1390

Americas: COMMERCIAL

Automotive applications, primarily. Excellent electrical properties, easy processability, high heat, 295F (146C) DTUL.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	630	kgf/cm²	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	1010	kgf/cm²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	23200	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	29	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	16	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	154	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	146	°C	ASTM D 648
CTE, 0°C to 100°C, flow	7.2E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.06	-	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
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	0.71	mm	UL 94

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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	295 - 315	°C
Nozzle Temperature	295 - 315	°C
Front - Zone 3 Temperature	280 - 315	°C
Middle - Zone 2 Temperature	270 - 310	°C
Rear - Zone 1 Temperature	260 - 305	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%