



Noryl* Resin PX1005X

Americas: COMMERCIAL

PPE+PS blend. Unfilled. Non-brominated, non-chlorinated FR system. UL94 V0/5VA rated. UL746C F1. Excelent dielectric strength. Suitable for E/E market in indoor/outdoor applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	420	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3.1	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	17	%	ASTM D 638
Tensile Modulus, 50 mm/min	24400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	810	kgf/cm ²	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	810	kgf/cm ²	ASTM D 790
Flexural Modulus	24700	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	22400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	53	MPa	ISO 527
Tensile Stress, break, 50 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.8	%	ISO 527
Tensile Strain, break, 50 mm/min	12.5	%	ISO 527
Tensile Modulus, 1 mm/min	2460	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	76	MPa	ISO 178
Flexural Modulus, 2 mm/min	2480	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	119	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	30	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	9	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10*4 +23°C	22	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	23	kJ/m ²	ISO 179/1eA



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THERMAL			
Vicat Softening Temp, Rate B/50	107	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	84	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	72	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	88	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	78	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.03E-04	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	94	°C	ISO 306
Vicat Softening Temp, Rate B/120	97	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	88	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	75	°C	ISO 75/Ae
Relative Temp Index, Elec	95	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	95	°C	UL 746B
PHYSICAL			
Specific Gravity	1.12	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2) (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	37	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 280°C/5.0 kg	37	cm³/10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	3.3E+16	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+16	Ohm	ASTM D 257
Dielectric Strength, in oil, 3.2 mm	17.7	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.67	-	ASTM D 150



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
ELECTRICAL			
Relative Permittivity, 1 MHz	2.53	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.012	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0026	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	2	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.01	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	1.47	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.99	mm	UL 94
UV-light, water exposure/immersion	F1	-	UL 746C



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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