



NORYL™ Resin PX5558
Americas: COMMERCIAL

30% glass reinforced, high flow PPO.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1100	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	79000	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1650	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 2.6 mm/min, 100 mm span	1330	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	85000	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	73100	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	26	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	9	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	142	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	130	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	129	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	121	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.98E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.66E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.28	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.1 - 0.2	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.2 - 0.4	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	19.6	g/10 min	ASTM D 1238



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	270 - 300	°C
Nozzle Temperature	270 - 300	°C
Front - Zone 3 Temperature	260 - 300	°C
Middle - Zone 2 Temperature	250 - 295	°C
Rear - Zone 1 Temperature	240 - 290	°C
Mold Temperature	65 - 95	°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