

NORYL™ PX5558 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

30% glass reinforced, high flow PPO.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	High Flow		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.10 to 0.20	%	
Across Flow : 3.20 mm	0.20 to 0.40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	7760	MPa	ASTM D638
Tensile Strength ² (Break)	108	MPa	ASTM D638
Tensile Elongation ³ (Break)	1.5	%	ASTM D638
Flexural Modulus			ASTM D790
100 mm Span ⁴	7170	MPa	
50.0 mm Span ⁵	8340	MPa	
Flexural Strength			ASTM D790
Break, 50.0 mm Span ⁶	162	MPa	
Break, 100 mm Span ⁷	131	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	91	J/m	ASTM D256
Unnotched Izod Impact (23°C)	260	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	14.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	129	°C	
1.8 MPa, Unannealed, 3.20 mm	122	°C	
Vicat Softening Temperature	131	°C	ASTM D1525 ⁸
CLTE			ASTM E831
Flow : -40 to 40°C	2.0E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.7E-5	cm/cm/°C	
Injection	Nominal Value	Unit	

Drying Temperature	98.9 to 104	°C
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	30 to 70	%
Rear Temperature	238 to 288	°C
Middle Temperature	249 to 293	°C
Front Temperature	260 to 299	°C
Nozzle Temperature	271 to 299	°C
Processing (Melt) Temp	271 to 299	°C
Mold Temperature	65.6 to 93.3	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.038 to 0.051	mm

NOTE

1. 5.0 mm/min
2. Type I, 5.0 mm/min
3. Type I, 5.0 mm/min
4. 2.6 mm/min
5. 1.3 mm/min
6. 1.3 mm/min
7. 2.6 mm/min
8. Rate B (120°C/h), Loading 2 (50 N)

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