

NORYL™ PX1390 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

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

General Information			
Features	Workability, good		
	Good electrical performance		
	Heat resistance, high		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	62.1	MPa	ASTM D638
Tensile Elongation ² (Break)	30	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	2280	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 100 mm Span)	100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	160	J/m	ASTM D256
23°C	290	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	154	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	146	°C	ASTM D648
CLTE - Flow (0 to 100°C)	7.2E-5	cm/cm/°C	ASTM E831
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating (0.711 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	104 - 110	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	

Suggested Max Moisture	0.020	%
Suggested Shot Size	30 - 70	%
Rear Temperature	260 - 304	°C
Middle Temperature	271 - 310	°C
Front Temperature	282 - 316	°C
Nozzle Temperature	293 - 316	°C
Processing (Melt) Temp	293 - 316	°C
Mold Temperature	76.7 - 104	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	20 - 100	rpm

NOTE

- | | |
|----|------------------|
| 1. | Type 1, 50mm/min |
| 2. | Type 1, 50mm/min |
| 3. | 2.6 mm/min |
| 4. | 2.6 mm/min |

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