

NORYL™ PX0844 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

NORYL PX0844 is an unfilled standard material with a Vicat B/120 of 125°C according ISO306. NORYL PX0844 offers high heat resistance and constant processability. Typical

General Information			
Features	Workability, good		
	Heat resistance, high		
Uses	Car interior parts		
RoHS Compliance	RoHS compliance		
Appearance	Available colors		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.06	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/3.8 kg)	9.00	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow ¹	0.50 - 0.70	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.14	%	ISO 62
Equilibrium, 23°C, 50% RH	0.030	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/50
Yield	45.0	MPa	ISO 527-2/50
Fracture	35.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.0	%	ISO 527-2/50
Fracture	40	%	ISO 527-2/50
Flexural Modulus ²	2200	MPa	ISO 178
Flexural Stress	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ³			ISO 180/1A
-40°C	5.0	kJ/m ²	ISO 180/1A
-30°C	7.0	kJ/m ²	ISO 180/1A
23°C	10	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, unannealed, 100 mm span	115	°C	ISO 75-2/Be

1.8 MPa, unannealed, 100 mm span	105	°C	ISO 75-2/Ae
Vicat Softening Temperature			
--	130	°C	ISO 306/A50
--	123	°C	ISO 306/B50
--	125	°C	ISO 306/B120
Ball Pressure Test (75°C)	Pass		IEC 60695-10-2
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 80°C	8.0E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 80°C	9.0E-5	cm/cm/°C	ISO 11359-2
Thermal Conductivity	0.23	W/m/K	ISO 8302
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	2.0 - 3.0	hr	
Hopper Temperature	60.0 - 80.0	°C	
Rear Temperature	240 - 260	°C	
Middle Temperature	260 - 280	°C	
Front Temperature	280 - 300	°C	
Nozzle Temperature	260 - 280	°C	
Processing (Melt) Temp	280 - 300	°C	
Mold Temperature	80.0 - 120	°C	
NOTE			
1.	Tensile Bar		
2.	2.0 mm/min		
3.	80*10*4		
4.	120*10*4 mm		

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