

NORYL™ PX9406P resin

Polyphenylene Ether + PS

SABIC Innovative Plastics Asia Pacific

Message:

Nonbrominated, nonchlorinated, flame retarded. Improved productivity and reliability. 125dc HDT. UL94 V-0 rated. Electrical applications.

General Information			
UL YellowCard	E45587-237097	E207780-228585	E45587-237098
	E207780-631706	E45587-631707	
Features	Bromine Free		
	Chlorine Free		
	Flame Retardant		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.09	g/cm ³	ASTM D792
--	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	3.9	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR)			ISO 1133
280°C/10.0 kg	27.0	cm ³ /10min	
280°C/5.0 kg	10.0	cm ³ /10min	
300°C/5.0 kg	23.0	cm ³ /10min	
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption (24 hr)	0.070	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield	63.0	MPa	Internal Method
Yield	73.0	MPa	ISO 527-2/50
Tensile Elongation			
Break	85	%	Internal Method
Break	4.5	%	ISO 527-2/50
Flexural Modulus			
--	2350	MPa	ASTM D790
-- ¹	2600	MPa	ISO 178
Flexural Strength			
--	99.0	MPa	ASTM D790
--	108	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ² (23°C)	14	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ³ (-30°C)	9.0	kJ/m ²	ISO 179/1eU
Notched Izod Impact			
23°C	170	J/m	ASTM D256
-40°C ⁴	8.0	kJ/m ²	ISO 180/1A
-30°C ⁵	8.0	kJ/m ²	ISO 180/1A
-20°C ⁶	9.0	kJ/m ²	ISO 180/1A
-10°C ⁷	10	kJ/m ²	ISO 180/1A
0°C ⁸	11	kJ/m ²	ISO 180/1A
23°C ⁹	13	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	136	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	131	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 6.40 mm	125	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	117	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	151	°C	ISO 306/A120
--	142	°C	ISO 306/B120
Ball Pressure Test ¹² (125°C)	Pass		IEC 60695-10-2
CLTE			
Flow : -30 to 30°C	7.0E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	6.6E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	7.6E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Dielectric Constant			ASTM D150
50 Hz	2.80		
60 Hz	2.80		
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.400 mm	V-2		
0.750 mm	V-0		
2.50 mm	5VA		
Fill Analysis	Nominal Value	Unit	Test Method
Melt Viscosity (280°C, 1500 sec ⁻¹)	278	Pa · s	ISO 11443
Injection	Nominal Value	Unit	
Drying Temperature	104 to 110	°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	243 to 293	°C
Middle Temperature	254 to 299	°C
Front Temperature	266 to 304	°C
Nozzle Temperature	277 to 304	°C
Processing (Melt) Temp	277 to 304	°C
Mold Temperature	71.1 to 98.9	°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.	2.0 mm/min
2.	80*10*4 sp=62mm
3.	80*10*4 sp=62mm
4.	80*10*4
5.	80*10*4
6.	80*10*4
7.	80*10*4
8.	80*10*4
9.	80*10*4
10.	80*10*4 mm
11.	80*10*4 mm
12.	Approximate maximum

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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