

NORYL™ PX0844 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

Automotive interiors. High heat/moisture resistant. consistent processability.

General Information			
Features	Moisture resistance		
	Workability, good		
	Heat resistance, high		
Uses	Car interior parts		
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
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	49.6	MPa	ASTM D638
Tensile Elongation ² (Break)	42	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	2240	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 100 mm Span)	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	130	J/m	ASTM D256
23°C	230	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	121	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	113	°C	ASTM D648
CLTE - Flow (0 to 100°C)	7.4E-5	cm/cm/°C	ASTM E831
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	243 - 293	°C	

Middle Temperature	254 - 299	°C
Front Temperature	266 - 304	°C
Nozzle Temperature	277 - 304	°C
Processing (Melt) Temp	277 - 304	°C
Mold Temperature	71.1 - 98.9	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	20 - 100	rpm
Vent Depth	0.038 - 0.051	mm

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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