

NORYL™ PX1543F resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

NORYL™ PX1543F resin is a Polyphenylene Ether + PS (PPE+PS) product. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Water Absorption (24 hr)	0.066	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	51.7	MPa	ASTM D638
Tensile Elongation ² (Break)	25	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2410	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	75.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	190	J/m	
23°C	320	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	110	°C	ASTM D648
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI Str	50.0	°C	UL 746
Electrical	Nominal Value		Test Method
Arc Resistance ⁵	PLC 7		ASTM D495
Comparative Tracking Index (CTI)	PLC 3		UL 746
High Amp Arc Ignition (HAI)	PLC 3		UL 746
High Voltage Arc Tracking Rate (HVTR)	PLC 3		UL 746
Hot-wire Ignition (HWI)	PLC 3		UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.47 mm)	HB		UL 94
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. | Type I, 50 mm/min |
| 2. | Type I, 50 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | Tungsten Electrode |

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