

NORYL™ PX0888 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

Unfilled, non-FR. Higher heat resistance than N110 (BOZ) and px0844 (USA). For automotive interiors. 250F (121C) DTUL.

General Information			
Uses	Car interior parts		
Processing Method	Injection molding		
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831)		
	Elastic Modulus vs Temperature (ASTM D4065)		
	Specific Heat vs. Temperature (ASTM D3417)		
	Tensile Creep (ASTM D2990)		
	Tensile Fatigue		
	Tensile Stress vs. Strain (ASTM D638)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Volume-Flow Rate (MVR) (300°C/2.16 kg)	6.00	cm ³ /10min	ISO 1133
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)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	58.6	MPa	ASTM D638
Tensile Elongation ² (Break)	30	%	ASTM D638
Flexural Modulus ³ (100 mm Span)	2360	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 100 mm Span)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	130	J/m	ASTM D256
23°C	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	129	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	128	°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	249 - 299	°C
Middle Temperature	260 - 304	°C
Front Temperature	271 - 310	°C
Nozzle Temperature	282 - 310	°C
Processing (Melt) Temp	282 - 310	°C
Mold Temperature	77 - 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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