NORYL™ Resin PX4605
Americas: COMMERCIAL

PPE+PS blend. 20% Glass reinforced. High heat. Dimensional stability. Suitable for automotive and E/E applications.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1140	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1120	kgf/cm²	ASTM D 638
Tensile Strain, yield	2.4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Modulus, 5 mm/min	77000	kgf/cm²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1730	kgf/cm²	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1510	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	56200	kgf/cm²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	53400	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	11	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	203	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	160	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	154	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	154	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.4	%	SABIC Method
Density	1.24	g/cm³	ISO 1183

NORYL™ Resin PX4605

Americas: COMMERCIAL

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	110 - 120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 325	°C
Nozzle Temperature	300 - 325	°C
Front - Zone 3 Temperature	290 - 325	°C
Middle - Zone 2 Temperature	275 - 320	°C
Rear - Zone 1 Temperature	265 - 315	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%