

**NORYL® PX1404**
Americas: COMMERCIAL

PPE+PS blend. High Heat. FDA compliant with restrictions. Injection Molding and Extrusion.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	76	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	20	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	104	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2410	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	534	J/m	ASTM D 256
Izod Impact, notched, -40°C	171	J/m	ASTM D 256
Gardner, 23°C	34	J	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	149	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	295 - 315	°C
Front - Zone 3 Temperature	280 - 315	°C
Middle - Zone 2 Temperature	270 - 310	°C
Rear - Zone 1 Temperature	260 - 305	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%