



NORYL™ Resin PX0844
Americas: COMMERCIAL

PPE+PS blend. Unfilled. UL94 HB rated. Low water absorption. Hydrolytic stability. Dimensional stability.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	500	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	440	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	27	%	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	23300	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	810	kgf/cm ²	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	770	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26000	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	22800	kgf/cm ²	ASTM D 790
Hardness, Rockwell R	114	-	ASTM D 785
Tensile Stress, yield	47	MPa	ISO 527
Tensile Stress, break	43	MPa	ISO 527
Tensile Strain, yield	2.9	%	ISO 527
Tensile Strain, break	43	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress	78	MPa	ISO 178
Flexural Modulus	2400	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	23	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	17	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	407	cm-kgf	ASTM D 3763



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IMPACT			
Izod Impact, notched 80*10*4 +23°C	17	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	10	kJ/m ²	ISO 180/1A
Charpy Impact, notched, 23°C	17	kJ/m ²	ISO 179/2C
Charpy Impact, notched, -30°C	10	kJ/m ²	ISO 179/2C
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	120	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	105	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	112	°C	ASTM D 648
CTE, 0°C to 100°C, flow	7.38E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	125	°C	ISO 306
Vicat Softening Temp, Rate B/120	128	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	122	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	107	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	13.7	g/10 min	ASTM D 1238



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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	275 - 305	°C
Nozzle Temperature	275 - 305	°C
Front - Zone 3 Temperature	265 - 305	°C
Middle - Zone 2 Temperature	255 - 300	°C
Rear - Zone 1 Temperature	245 - 295	°C
Mold Temperature	70 - 100	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm