

**NORYL® PX4058**Americas: **COMMERCIAL***Modified PPO® Alloy*

PPO, polyolefin blend. Improved chemical resistance. 253F (125C) HDT.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Str, yld, Type I, 50 mm/min	44	MPa	ASTM D 638
Tensile Elong, brk, Type I, 50 mm/min	114	%	ASTM D 638
Flex Stress, yld, 2.6 mm/min, 100 mm span	65	MPa	ASTM D 790
Flex Mod, 2.6 mm/min, 100 mm span	1790	MPa	ASTM D 790
Hardness, Rockwell R	96	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	8	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	1981	J/m	ASTM D 4812
Izod Impact, unnotched, -30°C	267	J/m	ASTM D 4812
Izod Impact, notched, 23°C	481	J/m	ASTM D 256
Izod Impact, notched, -40°C	150	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	2	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	3	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	140	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	123	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.07	%	ASTM D 570



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	95 - 100	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	240 - 280	°C
Rear - Zone 1 Temperature	225 - 275	°C
Mold Temperature	70 - 95	°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