NORYL™ RESIN PX1185

REGION EUROPE

DESCRIPTION

NORYL PX1185 is a special NORYL grade developed for extrusion of automotive trims. NORYL PX1185 offers high heat resistance and good impact performance.

TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 50 mm/min	30	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.5	%	ISO 527
Tensile Strain, break, 50 mm/min	55	%	ISO 527
Tensile Modulus, 1 mm/min	1500	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	45	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	25	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	8	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	22	kJ/m²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.22	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	9.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	110	°C	ISO 306
Vicat Softening Temp, Rate B/120	120	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	115	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	105	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Density	1.06	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.19	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 280°C/10.0 kg	12	cm³/10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Relative Permittivity, 1 MHz	2.6	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.0004	-	IEC 60250
Dissipation Factor, 1 MHz	0.0009	-	IEC 60250
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating	1.6	mm	UL 94 by SABIC-IP

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
INJECTION MOLDING			
Drying Temperature	80 – 100	°C	
Drying Time	2 – 3	hrs	
Melt Temperature	280 – 300	°C	
Nozzle Temperature	260 – 280	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	260 – 280	°C	
Rear - Zone 1 Temperature	240 – 260	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	60 – 100	°C	
PROFILE EXTRUSION			
Drying Temperature	90 – 95	°C	
Drying Time	2 – 3	hrs	
Melt Temperature	240 – 260	°C	
Barrel - Zone 1 Temperature	200 – 220	°C	
Barrel - Zone 2 Temperature	230 – 250	°C	
Barrel - Zone 3 Temperature	240 – 260	°C	
Barrel - Zone 4 Temperature	240 – 260	°C	
Hopper Temperature	40 – 60	°C	
Adapter Temperature	240 – 260	°C	
Die Temperature	240 – 260	°C	
Calibrator Temperature	50 – 70	°C	

DISCLAIMER