

NORYLTM RESIN PX1630

REGION EUROPE

DESCRIPTION

NORYL PX1630 Polyphenylene Oxide (PPO) + Polystyrene (PS) resin is a 30 % Glass Reinforced, injection moldable grade with improved hydrolytic stability; this grade has been developed for water management applications. NORYL PX1630 has been certified for potable water applications up to 85C in Europe and North America in limited colours.

TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	106	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	8100	MPa	ISO 527
Flexural Stress, break, 2 mm/min	170	MPa	ISO 178
Flexural Modulus, 2 mm/min	7050	MPa	ISO 178
Taber Abrasion, CS-17, 1 kg	70	mg/1000cy	SABIC method
Hardness, H358/30	130	MPa	ISO 2039-1
IMPACT⁽¹⁾			
Multiaxial Impact	6	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	34	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	30	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	10	kJ/m ²	ISO 180/1A
THERMAL			
CTE, -40°C to 40°C, flow	2.E-5	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-5	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	155	°C	ISO 306
Vicat Softening Temp, Rate B/50	149	°C	ISO 306
Vicat Softening Temp, Rate B/120	158	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	145	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	140	°C	ISO 75/Ae
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.1 – 0.3	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.2 – 0.5	%	SABIC method
Water Absorption, (23°C/sat)	0.2	%	ISO 62
Density	1.3	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 300°C/10.0 kg	16	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Dielectric Strength, in oil, 3.2 mm	18	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.9	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.0006	-	IEC 60250
Dissipation Factor, 1 MHz	0.001	-	IEC 60250
Relative Permittivity, 50/60 Hz	2.9	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating	1.5	mm	UL 94
Oxygen Index (LOI)	26	%	ISO 4589
Glow Wire Flammability Index 750°C, passes at	3	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 3.0 mm	750	°C	IEC 60695-2-13
INJECTION MOLDING			
Drying Temperature	100 – 120	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 300	°C	
Nozzle Temperature	280 – 300	°C	
Front - Zone 3 Temperature	290 – 310	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	250 – 270	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 120	°C	

(1) Multiaxial Impact tested at 23°C

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