NORYL™ RESIN EX130

REGION ASIA

DESCRIPTION

NORYL™ EX130 resin is a non-reinforced blend of polyphenylene ether (PPE) + high impact polystyrene (HIPS). This injection molding grade exhibits a good balance of impact resistance and surface aesthetics. NORYL EX130 resin, with its low warpage and dimensional stability, is an excellent candidate for automotive exterior applications.

TYPICAL PROPERTY VALUES

Revision 20200812

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	53	MPa	SABIC - Japan Method
Tensile Strain, break	50	%	SABIC - Japan Method
Flexural Stress	78	MPa	ASTM D 790
Flexural Modulus	2160	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	235	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	127	°C	ASTM D 648
CTE, -30°C to 30°C	5.50E-05 – 7.50E-05	1/°C	TMA
PHYSICAL			
Melt Flow Rate, 250°C/10.0 kgf	4.6	g/10 min	ASTM D 1238
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, (23°C/24hrs)	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
INJECTION MOLDING			
Drying Temperature	80 – 90	°C	
Drying Time	2 – 4	hrs	
Melt Temperature	275 – 310	°C	
Nozzle Temperature	270 – 305	°C	
Front - Zone 3 Temperature	270 – 310	°C	
Middle - Zone 2 Temperature	265 – 300	°C	
Rear - Zone 1 Temperature	245 – 290	°C	
Mold Temperature	70 – 110	°C	
Screw Speed	40 – 60	rpm	
Back Pressure	0.5 – 1.4	MPa	

DISCLAIMER