

# NORYLTM RESIN PX0888

# **REGION ASIA**

# **DESCRIPTION**

Unfilled, non-FR. Higher heat resistance than N110 (BOZ) and px0844 (USA). For automotive interiors. 250F (121C) DTUL.

# **TYPICAL PROPERTY VALUES**

Revision 20180906

PROPERTIES         TYPICAL VALUES         UNITS         TEST METHODS           MECHANICA.         Ternis Stress, yld, Type 1, 50 mm/min         58         ASTM D 638           Tensils Strain, brk, Type 1,50 mm/min         9         48         ASTM D 638           Flexural Stress, yld, 2,6 mm/min, 100 mm span         93         MPa         ASTM D 790           Flexural Stress, yld, 2,6 mm/min, 100 mm span         93         MPa         ASTM D 790           Hardness, Rockwell R         18         19         MPa         ASTM D 296           Hardness, Rockwell R         19         1/m         ASTM D 256           Lod Impact, notched, 23°C         197         1/m         ASTM D 256           Lod Impact, notched, 40°C         197         47m         ASTM D 256           Lod Impact, notched, 40°C         19         47m         ASTM D 256           Lod Impact, notched, 40°C         19         47m         ASTM D 256           Lod Impact, notched, 40°C         20         ASTM D 256           Lod Impact, notched, 40°C         20         ASTM D 256           Lod Impact, 100°C         40         ASTM D 256           Lod Impact, 100°C         100°C         ASTM D 256           Lod Impact, 100°C         100°C         ASTM D 256 <th></th> <th></th> <th></th> <th></th>				
Tensile Stress, yid, Type I, 50 mm/min         58         MFe         ASTM D 638           Tensile Strain, bir, Type I, 50 mm/min         30         48         ASTM D 638           Flexural Modulus, 2.6 mm/min, 100 mm span         29         MPa         ASTM D 790           Herbural Modulus, 2.6 mm/min, 100 mm span         2950         MPa         ASTM D 790           Hardness, Rockwell R         18         2         3 MD 785           HOPACT         Use of mpact, notched, 23°C         19         2         ASTM D 256           Lood Impact, notched, 40°C         19         1/m Ca         ASTM D 256         ASTM D 256           HOPACT         19         1/m Ca         ASTM D 256         ASTM D 256           HOPACT         19         2         4         ASTM D 256         ASTM D 256           HOPACT         19         2         4         ASTM D 256         A	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Tensile Strain, brk, Type J, 50 mm/min         30         %         ASMD 638           Flexural Stress, yld, 2.6 mm/min, 100 mm span         93         MPa         ASTM D 790           Flexural Modulus, 2.6 mm/min, 100 mm span         2350         MPa         ASTM D 790           Hardness, Rockwell R         118         2         OSTM D 785           MPACT         V         V         V           Izod Impact, notched, 23°C         197         J/m         ASTM D 256           Izod Impact, notched, 40°C         133         J/m         ASTM D 256           Izod Impact, notched, 40°C         129         "C         ASTM D 648           HDT, 0.45 MPa, 6.4 mm, unannealed         129         "C         ASTM D 648           HDT, 0.45 MPa, 6.4 mm, unannealed         129         "C         ASTM D 648           HDT, 0.45 MPa, 6.4 mm, unannealed         129         "C         ASTM D 648           WEST         1, 182 MPa, 6.4 mm, unannealed         129         "C         ASTM D 648           HDT, 0.45 MPa, 6.4 mm, unannealed         129         "C         ASTM D 648           WEST         1, 182 MPa, 6.4 mm, unannealed         129         "ASTM D 648           WEST         1, 182 MPa, 6.4 mm, unannealed         129         "ASTM D 648	MECHANICAL			
Blexural Stress, yid, 2.6 mm/min, 100 mm span         93         MPa         ASTM D 790           Flexural Modulus, 2.6 mm/min, 100 mm span         2350         MPa         ASTM D 785           Hardness, Rockwell R         118         2	Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Beaural Modulus, 2.6 mm/min, 100 mm span         2350         MPa         ASTM D 785           Hardness, Rockwell R         18	Tensile Strain, brk, Type I, 50 mm/min	30	%	ASTM D 638
Hardness, Rockwell R       188       colspan="4">col	Flexural Stress, yld, 2.6 mm/min, 100 mm span	93	MPa	ASTM D 790
IMPACT           Ize of Impact, notched, 23°C         197         Jm         ASTM D 256           Ize of Impact, notched, 40°C         133         Jm         ASTM D 256           IMPACT           IXE of Impact, notched, 40°C         133         Jm         256         256           IXE OF IMPACT         150         25	Flexural Modulus, 2.6 mm/min, 100 mm span	2350	MPa	ASTM D 790
Izod Impact, notched, 2°C       197       J/m       ASTM D 256         Izod Impact, notched, 40°C       133       J/m       ASTM D 256         THERMAL         HDT, 0.45 MPa, 6.4 mm, unannealed       129       °C       ASTM D 648         HDT, 182 MPa, 6.4 mm, unannealed       127       °C       ASTM D 648         CTC, 0°C to 100°C, flow       25       X       ASTM D 648         CTC, 0°C to 100°C, flow       3       ASTM D 648       ASTM D 648         CHYSICAT       V       ASTM D 648       ASTM D 648         LYSCE       V       ASTM D 648       ASTM D 648         Water Absorption, 24 hours       10.4       2       ASTM D 679       ASTM D 679         Mold Shrinkage, flow, 3.2 mm       0.5       0.7       %       ASTM D 670       ASTM D 670         Melk Volume Rate, MVR at 300°C/2.16 kg       0.5       0.7       %       ASTM D 670       ASTM D 670         Drying Time       10 <th>Hardness, Rockwell R</th> <th>118</th> <th>-</th> <th>ASTM D 785</th>	Hardness, Rockwell R	118	-	ASTM D 785
Ized Impact, notched, 40°C       ASTM D 256         THERMAL         HDT, 0.45 MPa, 6.4 mm, unannealed       129       °C       ASTM D 648         HDT, 1.82 MPa, 6.4 mm, unannealed       127       °C       ASTM D 648         CTE, 0°C to 100°C, flow       3.80E 0.3       ASTM D 648         CTE, 0°C to 100°C, flow       ASTM D 648         CTE, 0°C to 100°C, flow       ASTM D 670         Mold Shrinkage, flow, 3.2 mm       5.0 - 0.7       8       ASIM D 670         Melt Yolume Rate, MVR at 300°C/2.16 kg       5.0 - 0.7       8       ASIM D 670       ASIM D 670         Drying Temperature       105 - 110       °C         Drying Time (Cumulative)       8       9.2         Maximum Moisture Content       280 - 310       °C         Nozzle Temperature       280 - 310       °C         Nozzle Temperature       280 - 310       °C         Mel Temperature       280	IMPACT			
HERNAL           HDT, 0.45 MPa, 6.4 mm, unannealed         129         °C         ASM D 648           HDT, 1.82 MPa, 6.4 mm, unannealed         127         °C         ASM D 648           CTE, 0°C to 100°C, flow         7.88-05         1/°C         ASM D 648           HYSICAL           Secrific Gravity         1.04         -         ASM D 792           Water Absorption, 24 hours         0.1         %         ASM D 570           Mold Shrinkage, flow, 3.2 mm         0.5 - 0.7         %         ASIM D 792           Melt Volume Rate, MVR at 300°C/2.16 kg         0.5 - 0.7         m³/10 min         SI 133           Drying Temperature         105 - 110         °C         SI 133           Drying Time (Cumulative)         8         hrs         SI 133           Maximum Moisture Content         200 - 310         °C         SI 134           Mozzle Temperature         200 - 310         °C         SI 134           Mozzle Temperature         200 - 30         °C         SI 134           Moidle-Zone 2 Temperature         200 - 30         °C         SI 134           Moidle-Zone 2 Temperature         200 - 30         °C         SI 134           Moidle-Zone 2 Temperatur	Izod Impact, notched, 23°C	197	J/m	ASTM D 256
HDT, 0.45 MPa, 6.4 mm, unannealed         199         ℃         ASTM D 648           HDT, 1.82 MPa, 6.4 mm, unannealed         127         ℃         ASTM D 648           CTE, 0°C to 100°C, flow         7.88-05         1/°         ASTM D 648           PMSICAL         V         SEMINE 831         ASTM D 792           Water Absorption, 24 hours         0.4         %         ASTM D 792           Mold Shrinkage, flow, 3.2 mm         0.5 - 0.7         %         ASIM D 792           Melt Volume Rate, MVR at 300°C/2.16 kg         0.5 - 0.7         %         ASIM D 792           Drying Temperature         105 - 110         °         No.1         SIM D 792           Drying Time (Gunulative)         3 - 4         Ns         SIM D 793         SIM D 792           Makimum Moisture Content         8         Ns         SIM D 793         SIM D 792         SIM D 792           Melt Temperature         280 - 310         °         SIM D 793         SIM D 792	Izod Impact, notched, -40°C	133	J/m	ASTM D 256
HDT, 1.82 MPa, 6.4 mm, unannealed         127         °C         ASTM D 648           CTE, 0°C to 100°C, flow         7.38±05         1/°C         ASTM E 831           PHYSICAL           Specific Gravity         1.04         -         ASTM D 792           Water Absorption, 24 hours         0.1         %         ASTM D 570           Mold Shrinkage, flow, 3.2 mm         0.5 − 0.7         %         ABIC method           Melt Volume Rate, MVR at 300°C/2.16 kg         0.5 − 10         °C         TURING           Drying Temperature         105 − 110         °C         TURING           Drying Time (Cumulative)         3 − 4         his         TURING           Maximum Moisture Content         200-2         %         TURING           Melt Temperature         280 − 310         °C         TURING           Tomazie Temperature         280 − 310         °C         TURING           Rear-Zone 1 Temperature         260 − 305         °C         TURING           Mold Temperature         50 − 300         °C         TURING           Rear-Zone 1 Temperature         250 − 300         °C         TURING           Rear Zone 1 Temperature         250 − 300         °C         TURING	THERMAL			
CFE, 0°C to 100°C, flow         7.38-05         1,°C         ASTM E 831           PHYSICAL           Specific Gravity         1.04         -         ASTM D 792           Water Absorption, 24 hours         0.1         %         ASTM D 570           Mold Shrinkage, flow, 3.2 mm         0.5 − 0.7         %         ASBIC method           Melt Volume Rate, MVR at 300°C/2.16 kg         6         m³/10 min         ISO 1133           INJECTION MOLDING           Drying Temperature         105 − 110         °C         C           Drying Time (Cumulative)         8         hrs         C           Maximum Moisture Content         90.2         %         C           Melt Temperature         280 − 310         °C         C           Nozzle Temperature         290 − 310         °C         C           Front - Zone 3 Temperature         260 − 305         °C         C           Rear - Zone 1 Temperature         250 − 300         °C         C           Mold Temperature         75 − 105         °C         C           Back Pressure         30 − 30         M²         C           Back Pressure         30 − 100         M²         C	HDT, 0.45 MPa, 6.4 mm, unannealed	129	°C	ASTM D 648
PHYSICAL           Specific Gravity         1.04         - 2.0         ASTM D 792           Water Absorption, 24 hours         0.1         %         ASTM D 570           Mold Shrinkage, flow, 3.2 mm         0.5 - 0.7         %         SABIC method           Melt Volume Rate, MVR at 300°C/2.16 kg         6         cm³/l 0 min         50 1133           Drying Temperature           Drying Time         3 - 4         hrs         - 2           Melt Temperature         8         hrs         - 2           Melt Temperature         280 - 310         °C         - 2           Nozzle Temperature         280 - 310         °C         - 2           Front - Zone 3 Temperature         20 - 30         °C         - 2           Middle - Zone 2 Temperature         20 - 30         °C         - 2           Rear - Zone 1 Temperature         25 - 300         °C         - 2           Mold Temperature         75 - 105         °C         - 2           Back Pressure         30 - 30         MPa         - 2           Back Pressure         30 - 30         MPa         - 2	HDT, 1.82 MPa, 6.4 mm, unannealed	127	°C	ASTM D 648
Specific Gravity1.04-ASTM D 792Water Absorption, 24 hours0.1%ASTM D 570Mold Shrinkage, flow, 3.2 mm0.5 – 0.7%ABIC methodMelt Volume Rate, MVR at 300°C/2.16 kg6m²/10 minISO 1133INJECTION MOLDINGDrying Temperature105 – 110°C-Drying Time (Cumulative)3 – 4hrs-Maximum Moisture Content2002%-Mozel Temperature280 – 310°C-Nozel Temperature290 – 310°C-Font - Zone 3 Temperature270 – 310°C-Middle - Zone 2 Temperature250 – 300°C-Mold Temperature250 – 300°C-Mold Temperature250 – 300°C-Mold Temperature30 – 0.7MPa-Back Pressure0.3 – 0.7MPa-Terew Speed20 – 100mpm-	CTE, 0°C to 100°C, flow	7.38E-05	1/°C	ASTM E 831
Water Absorption, 24 hours         0.1         %         ASTM D 570           Mold Shrinkage, flow, 3.2 mm         0.5 − 0.7         %         ABIC method           Melt Volume Rate, MVR at 300°C/2.16 kg         6         cm³/10 min         ISO 1133           INJECTION MOLDING           Drying Temperature         105 − 110         °C         C           Drying Time (Cumulative)         8         hrs         C         C           Maximum Moisture Content         0.02         %         C         C           Nozzle Temperature         280 − 310         °C         C         C           Front - Zone 3 Temperature         270 − 310         °C         C         C           Middle - Zone 2 Temperature         260 − 305         °C         <	PHYSICAL			
Mold Shrinkage, flow, 3.2 mm         0.5 − 0.7         %         SABIC method           Melt Volume Rate, MVR at 300°C/2.16 kg         6         cm³/10 min         ISO 1133           INJECTION MOLDING           Drying Temperature         105 − 110         °C         C           Drying Time (Cumulative)         8         hrs         C         C           Maximum Moisture Content         0.02         %         C	Specific Gravity	1.04	-	ASTM D 792
Melt Volume Rate, MVR at 300°C/2.16 kg       6       cm³/10 min       ISO 1133         INJECTION MOLDING         Drying Temperature       105 – 110       °C         Drying Time       1 ms       C         Maximum (cumulative)       8       hrs         Melt Temperature       280 – 310       °C         Nozzle Temperature       280 – 310       °C         Front - Zone 3 Temperature       270 – 310       °C         Middle - Zone 2 Temperature       250 – 300       °C         Rear - Zone 1 Temperature       250 – 300       °C         Mold Temperature       75 – 105       °C         Back Pressure       0.3 – 0.7       MPa         Screw Speed       20 – 100       mpm	Water Absorption, 24 hours	0.1	%	ASTM D 570
INJECTION MOLDING  Drying Temperature 105 – 110 3 – 4	Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Drying Temperature         105 – 110         °C           Drying Time         3 – 4         hrs           Drying Time (Cumulative)         8         hrs           Maximum Moisture Content         0.02         %           Melt Temperature         280 – 310         °C           Nozzle Temperature         270 – 310         °C           Middle - Zone 3 Temperature         260 – 305         °C           Rear - Zone 1 Temperature         250 – 300         °C           Mold Temperature         75 – 105         °C           Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Melt Volume Rate, MVR at 300°C/2.16 kg	6	cm³/10 min	ISO 1133
Drying Time         3 - 4         hrs           Drying Time (Cumulative)         8         hrs           Maximum Moisture Content         0.02         %           Melt Temperature         280 - 310         °C           Nozzle Temperature         280 - 310         °C           Front - Zone 3 Temperature         270 - 310         °C           Middle - Zone 2 Temperature         260 - 305         °C           Rear - Zone 1 Temperature         250 - 300         °C           Mold Temperature         75 - 105         °C           Back Pressure         0.3 - 0.7         MPa           Screw Speed         20 - 100         rpm	INJECTION MOLDING			
Drying Time (Cumulative)  Maximum Moisture Content  Melt Temperature  280 – 310  Nozzle Temperature  280 – 310  C Front - Zone 3 Temperature  270 – 310  C Rear - Zone 1 Temperature  250 – 300  C Mold Temperature  75 – 105  C Back Pressure  0.3 – 0.7  MPa  Temperature  10.0 – 100  Temperature  10	Drying Temperature	105 – 110	°C	
Maximum Moisture Content         0.02         %           Melt Temperature         280 – 310         °C           Nozzle Temperature         280 – 310         °C           Front - Zone 3 Temperature         270 – 310         °C           Middle - Zone 2 Temperature         260 – 305         °C           Rear - Zone 1 Temperature         250 – 300         °C           Mold Temperature         75 – 105         °C           Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Drying Time	3 – 4	hrs	
Melt Temperature         280-310         °C           Nozzle Temperature         280-310         °C           Front - Zone 3 Temperature         270-310         °C           Middle - Zone 2 Temperature         260-305         °C           Rear - Zone 1 Temperature         250-300         °C           Mold Temperature         75-105         °C           Back Pressure         0.3-0.7         MPa           Screw Speed         20-100         rpm	Drying Time (Cumulative)	8	hrs	
Nozzle Temperature         280 – 310         °C           Front - Zone 3 Temperature         270 – 310         °C           Middle - Zone 2 Temperature         260 – 305         °C           Rear - Zone 1 Temperature         250 – 300         °C           Mold Temperature         75 – 105         °C           Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Maximum Moisture Content	0.02	%	
Front - Zone 3 Temperature         270 – 310         °C           Middle - Zone 2 Temperature         260 – 305         °C           Rear - Zone 1 Temperature         250 – 300         °C           Mold Temperature         75 – 105         °C           Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Melt Temperature	280 – 310	°C	
Middle - Zone 2 Temperature         260 – 305         °C           Rear - Zone 1 Temperature         250 – 300         °C           Mold Temperature         75 – 105         °C           Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Nozzle Temperature	280 – 310	°C	
Rear - Zone 1 Temperature         250 – 300         °C           Mold Temperature         75 – 105         °C           Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Front - Zone 3 Temperature	270 – 310	°C	
Mold Temperature         75 – 105         °C           Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Middle - Zone 2 Temperature	260 – 305	°C	
Back Pressure         0.3 – 0.7         MPa           Screw Speed         20 – 100         rpm	Rear - Zone 1 Temperature	250 – 300	°C	
Screw Speed         20 – 100         rpm	Mold Temperature	75 – 105	°C	
·	Back Pressure	0.3 – 0.7	MPa	
Shot to Cylinder Size 30 – 70 %	Screw Speed	20 – 100	rpm	
	Shot to Cylinder Size	30 – 70	%	



# **DISCLAIMER**

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