

Noryl* Resin PX1180

Europe-Africa-Middle East: COMMERCIAL

Noryl* PX1180 PolyPhenylene Oxide (PPO*) + Polystyrene (PS) resin is an unfilled , injection moldable grade, with improved impact performances, an ISO 306 Vicat B/120 temperature of 120 deg C and a UL94 HB rating . This grade has been developed for automotive interior applications requiring standard ECE dashboard impact test. Noryl PX1180 is only available in black color.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	35	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	50	%	ISO 527
Tensile Modulus, 1 mm/min	1800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	55	MPa	ISO 178
Flexural Modulus, 2 mm/min	1500	MPa	ISO 178
Hardness, H358/30	70	MPa	ISO 2039-1
IMPACT	Value	Unit	Standard
Izod Impact, notched 80*10*4 +23°C	25	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	11	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	25	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
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 A/50	130	°C	ISO 306
Vicat Softening Temp, Rate B/50	115	°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	Value	Unit	Standard
Mold Shrinkage on Tensile Bar, flow (2)	0.5 - 0.7	%	SABIC Method
Density	1.06	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.14	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	12	cm ³ /10 min	ISO 1133
ELECTRICAL	Value	Unit	Standard
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
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
FLAME CHARACTERISTICS	Value	Unit	Standard

Processing

Parameter	Value	Unit
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

Source GMD, last updated:04/21/1995

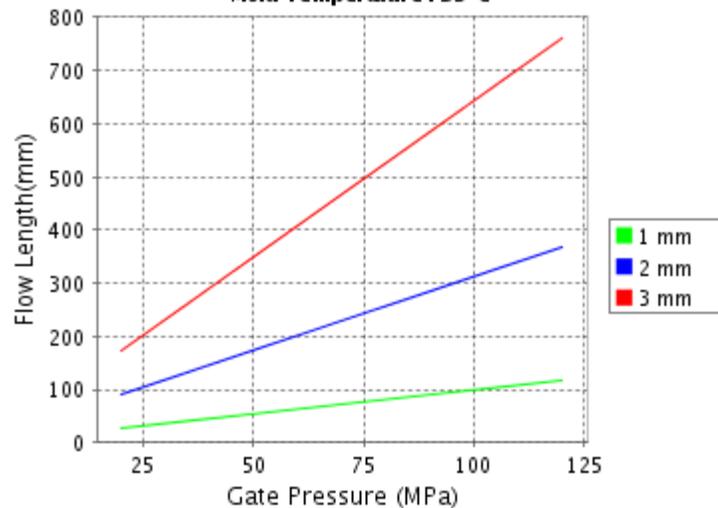
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

LNP Staramide DBG014

Melt Temperature : 270°C

Mold Temperature : 95°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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