



**NORYL™ Resin PX2790C**  
**Asia Pacific: COMMERCIAL**

PPE/HIPS unfilled FR-V1, 90C

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yield	380	kgf/cm <sup>2</sup>	SABIC - Japan Method
Tensile Strain, break	80	%	SABIC - Japan Method
Flexural Stress	650	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus	23700	kgf/cm <sup>2</sup>	ASTM D 790
Hardness, Rockwell R	115	-	ASTM D 785
<b>IMPACT</b>			
Izod Impact, notched, 23°C	26	cm-kgf/cm	ASTM D 256
<b>THERMAL</b>			
HDT, 1.82 MPa, 6.4 mm, unannealed	90	°C	ASTM D 648
CTE, -30°C to 30°C	7.E-05	1/°C	TMA
<b>PHYSICAL</b>			
Specific Gravity	1.1	-	ASTM D 792
Water Absorption, 24 hours	0.07	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.6	%	SABIC Method
Melt Flow Rate, 250°C/10.0 kgf	33	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Surface Resistivity	1.E+16	Ohm	ASTM D 257
Arc Resistance, Tungsten (PLC)	7	PLC Code	ASTM D 495
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94V-1 Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	6	mm	UL 94

(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.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	75 - 80	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 275	°C
Nozzle Temperature	250 - 275	°C
Front - Zone 3 Temperature	240 - 275	°C
Middle - Zone 2 Temperature	225 - 270	°C
Rear - Zone 1 Temperature	215 - 265	°C
Mold Temperature	55 - 75	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm

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