

Noryl* Resin PX1278

Americas: COMMERCIAL

Primarily EXTRUSION material. Automotive. Passes FMVSS 302. Heat resistance of 130 C (266 F).

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	29	%	ASTM D 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	2370	MPa	ASTM D 790
Hardness, Rockwell R	121	-	ASTM D 785
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	250	J/m	ASTM D 256
Izod Impact, notched, -30°C	122	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	140	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	132	°C	ASTM D 648
CTE, -40°C to 95°C, flow	5.4E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.07	-	ASTM D 792
Specific Volume	0.93	cm ³ /g	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570

Source GMD, last updated:01/05/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	275 - 305	°C
Nozzle Temperature	275 - 305	°C
Front - Zone 3 Temperature	265 - 305	°C
Middle - Zone 2 Temperature	255 - 300	°C
Rear - Zone 1 Temperature	245 - 295	°C
Mold Temperature	70 - 100	°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
Parameter		
Extrusion		
Drying Temperature	105 - 115	°C
Drying Time	2 - 4	hrs

Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	245 - 270	°C
Barrel - Zone 1 Temperature	205 - 215	°C
Barrel - Zone 2 Temperature	205 - 215	°C
Barrel - Zone 3 Temperature	215 - 240	°C
Barrel - Zone 4 Temperature	215 - 240	°C
Adapter Temperature	240 - 260	°C
Die Temperature	240 - 260	°C

Source GMD, last updated:01/05/2000

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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