

NORYL™ PVX0901 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics Asia Pacific

Message:

Multi purpose V1 grade

General Information			
UL YellowCard	E207780-100089947		
Features	General Purpose		
Uses	General Purpose		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	50	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (280°C/5.0 kg)	52.0	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	Internal Method
Water Absorption			ISO 62
Saturation, 23°C	0.24	%	
Equilibrium, 23°C, 50% RH	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2500	MPa	ASTM D638
--	2440	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	60.0	MPa	ASTM D638
Yield	59.0	MPa	ISO 527-2/50
Break ³	45.0	MPa	ASTM D638
Break	44.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	3.3	%	ASTM D638
Yield	3.3	%	ISO 527-2/50
Break ⁵	6.6	%	ASTM D638
Break	8.8	%	ISO 527-2/50
Flexural Modulus			
50.0 mm Span ⁶	2300	MPa	ASTM D790
-- ⁷	2450	MPa	ISO 178
Flexural Stress			
--	95.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	86.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	12	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C	80	J/m	ASTM D256
23°C	180	J/m	ASTM D256
-30°C ¹⁰	10	kJ/m ²	ISO 180/1A
23°C ¹¹	13	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	37.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	92.0	°C	ASTM D648
1.8 MPa, Unannealed, 6.40 mm	92.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	89.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	116	°C	ASTM D1525, ISO 306/B50 ¹³
--	109	°C	ISO 306/B120
CLTE			
Flow : -40 to 40°C	7.5E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	7.4E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	8.1E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	7.8E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm, Testing by SABIC)	V-1	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 82.2	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 to 70	%	
Rear Temperature	216 to 266	°C	
Middle Temperature	227 to 271	°C	
Front Temperature	238 to 277	°C	
Nozzle Temperature	249 to 277	°C	
Processing (Melt) Temp	249 to 277	°C	
Mold Temperature	54.4 to 76.7	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	20 to 100	rpm	
Vent Depth	0.038 to 0.051	mm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 50 mm/min		

3.	Type I, 50 mm/min
4.	Type I, 50 mm/min
5.	Type I, 50 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4 sp=62mm
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	Rate B (120°C/h), Loading 2 (50 N)

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