

NORYL™ PX4605 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

PPE+PS blend. 20% Glass reinforced. High heat. Dimensional stability. Suitable for automotive and E/E applications.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Dimensional Stability		
	High Heat Resistance		
Uses	Automotive Applications		
	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.21	g/cm ³	ASTM D792
--	1.24	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.40	%	Internal Method
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	7560	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	112	MPa	
Break ²	110	MPa	
Tensile Elongation			ASTM D638
Yield	2.4	%	
Break ³	2.4	%	
Flexural Modulus			ASTM D790
50.0 mm Span ⁴	5520	MPa	
100 mm Span ⁵	5240	MPa	
Flexural Strength			ASTM D790
Yield, 100 mm Span ⁶	148	MPa	
Break, 50.0 mm Span ⁷	170	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	100	J/m	
23°C	110	J/m	

Instrumented Dart Impact (23°C, Total Energy)	20.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	160	°C	
1.8 MPa, Unannealed, 3.20 mm	154	°C	
1.8 MPa, Unannealed, 6.40 mm	154	°C	
Injection	Nominal Value	Unit	
Drying Temperature	110 to 121	°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	266 to 316	°C	
Middle Temperature	277 to 321	°C	
Front Temperature	288 to 327	°C	
Nozzle Temperature	299 to 327	°C	
Processing (Melt) Temp	299 to 327	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	20 to 100	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.6 mm/min		
6.	2.6 mm/min		
7.	1.3 mm/min		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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