



NORYL™ Resin PX1005X

Americas: LIMITED USE

PPE+PS blend. Unfilled. Non-brominated, non-chlorinated FR system. UL94 V0/5VA rated. UL746C F1. Excellent dielectric strength. Suitable for E/E market in indoor/outdoor applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	560	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	420	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3.1	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	17	%	ASTM D 638
Tensile Modulus, 50 mm/min	24400	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	810	kgf/cm ²	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	810	kgf/cm ²	ASTM D 790
Flexural Modulus	24700	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	22400	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	53	MPa	ISO 527
Tensile Stress, break, 50 mm/min	43	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.8	%	ISO 527
Tensile Strain, break, 50 mm/min	12.5	%	ISO 527
Tensile Modulus, 1 mm/min	2460	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	76	MPa	ISO 178
Flexural Modulus, 2 mm/min	2480	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	119	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	30	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	9	cm-kgf/cm	ASTM D 256
Izod Impact, notched 80*10 ⁴ +23°C	22	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10 ⁴ sp=62mm	23	kJ/m ²	ISO 179/1eA

(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.
 (6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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THERMAL			
Vicat Softening Temp, Rate B/50	107	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	84	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	72	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	88	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	78	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.03E-04	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	94	°C	ISO 306
Vicat Softening Temp, Rate B/120	97	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	88	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	75	°C	ISO 75/Ae
Relative Temp Index, Elec	95	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	95	°C	UL 746B
PHYSICAL			
Specific Gravity	1.12	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2) (5)	0.5 - 0.7	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	37	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 280°C/5.0 kg	37	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	3.3E+16	Ohm-cm	ASTM D 257
Surface Resistivity	>1.E+16	Ohm	ASTM D 257
Dielectric Strength, in oil, 3.2 mm	17.7	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.67	-	ASTM D 150

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
Relative Permittivity, 1 MHz	2.53	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.012	-	ASTM D 150
Dissipation Factor, 1 MHz	0.0026	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	2	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.01	mm	UL 94
UL Recognized, 94V-0 Flame Class Rating (3)	1.47	mm	UL 94
UL Recognized, 94-5VA Rating (3)	2.99	mm	UL 94
UV-light, water exposure/immersion	F1	-	UL 746C

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
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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