NORYL™ RESIN PX1860

REGION EUROPE

DESCRIPTION

This injection moldable grade offers improved hydrolytic stability, very low moisture absorption, heat / hot water resistance and was developed for water management applications. NORYL PX1630 has been certified for potable water applications up to 85C in Europe and North America in limited colors. *NSF certification is color dependent.

GENERAL INFORMATION	
Features	Flame Retardant, Hydrolytic Stability, Low Warpage, Amorphous, Low Shrinkage, Low Moisture Absorption, Low Specific Gravity, Non Cl/Br flame retardant, Non halogenated flame retardant, Dimensional stability
Fillers	Unreinforced
Polymer Types	Polyphenylene Ether + PS (PPE+PS)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Electronic Components, Mobile Phone - Computer - Tablets

TYPICAL PROPERTY VALUES

Revision 20260206

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	52	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	49	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	3.6	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	7.3	%	ASTM D638
Tensile Modulus, 50 mm/min	3140	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2770	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	61	MPa	ISO 527
Tensile Stress, break, 50 mm/min	53	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.5	%	ISO 527
Tensile Strain, break, 50 mm/min	8	%	ISO 527
Tensile Modulus, 1 mm/min	2510	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	89	MPa	ISO 178
Flexural Modulus, 2 mm/min	2420	MPa	ISO 178
IMPACT [1]			
Izod Impact, notched, 23°C	38	J/m	ASTM D256
Izod Impact, notched, -30°C	27	J/m	ASTM D256
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m²	ISO 179/1eA
THERMAL [1]			
Vicat Softening Temp, Rate B/50	110	°C	ASTM D1525

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT, 1.82 MPa, 3.2mm, unannealed	90	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.4E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	7.4E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	7.4E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.4E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	111	°C	ISO 306
Vicat Softening Temp, Rate B/120	114	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	92	°C	ISO 75/Af
Relative Temp Index, Elec [2]	65	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	65	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	65	°C	UL 746B
PHYSICAL [1]			
Specific Gravity	1.1	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm [3]	0.5 – 0.7	%	SABIC method
Density	1.1	g/cm³	ISO 1183
Water Absorption, (23°C/saturated)	0.13	%	ISO 62-1
Moisture Absorption (23°C / 50% RH)	0.02	%	ISO 62
Melt Volume Rate, MVR at 280°C/1.2 kg	15	cm³/10 min	ISO 1133
Melt Volume Rate, MVR at 280°C/2.16 kg	34	cm³/10 min	ISO 1133
ELECTRICAL [1]			
Volume Resistivity	4.E+16	Ω.cm	ASTM D257
Surface Resistivity	1.E+14	Ω	ASTM D257
Relative Permittivity, 1 MHz	2.7	-	ASTM D150
Dissipation Factor, 1 MHz	0.02	-	ASTM D150
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
Volume Resistivity	4.E+16	Ω.cm	IEC 60093
Surface Resistivity, ROA	1.E+14	Ω	IEC 60093
Dielectric Strength, in oil, 1.6 mm	28.6	kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.7	-	IEC 60250
Dissipation Factor, 1 MHz	0.02	-	IEC 60250
Comparative Tracking Index [4]	250	V	IEC 60112
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E45329-100037005	-	-
UL Recognized, 94V-1 Flame Class Rating	≥1.5	mm	UL 94
Glow Wire Flammability Index 960°C, passes at [4]	3	mm	IEC 60695-2-12
Oxygen Index (LOI)	30	%	ISO 4589
INJECTION MOLDING [5]			
Drying Temperature	70 – 80	°C	
Drying Time	2 – 3	Hrs	
Melt Temperature	260 – 295	°C	
Nozzle Temperature	250 – 280	°C	
Front - Zone 3 Temperature	260 – 295	°C	
Middle - Zone 2 Temperature	240 – 270	°C	
Rear - Zone 1 Temperature	210 – 230	°C	
Hopper Temperature	65 – 85	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Temperature	45 – 70	°C	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
(2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
(3) 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.
(4) Value shown here is based on internal measurement.
(5) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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