

NORYL™ RESIN EX130

REGION ASIA

DESCRIPTION

NORYL EX130 resin is a non-reinforced blend of polyphenylene ether (PPE) + polystyrene (PS). This injection molding grade exhibits a good balance of impact resistance and surface aesthetics. NORYL EX130 resin, with its low warpage and dimensional stability, is an excellent candidate for automotive exterior applications.

GENERAL INFORMATION	
Features	Hydrolytic Stability, Low Warpage, Amorphous, Low Shrinkage, Low Moisture Absorption, Low Specific Gravity, Dimensional stability, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polyphenylene Ether + PS (PPE+PS)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Lighting, Automotive Exteriors
Electrical and Electronics	Lighting

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yield	53	MPa	SABIC - Japan Method
Tensile Strain, break	50	%	SABIC - Japan Method
Flexural Stress	78	MPa	ASTM D790
Flexural Modulus	2160	MPa	ASTM D790
IMPACT ⁽¹⁾			
Izod Impact, notched, 23°C	235	J/m	ASTM D256
THERMAL ⁽¹⁾			
HDT, 1.82 MPa, 6.4 mm, unannealed	127	°C	ASTM D648
CTE, -30°C to 30°C	5.50E-05 – 7.50E-05	1/°C	TMA
PHYSICAL ⁽¹⁾			
Melt Flow Rate, 250°C/10.0 kgf	4.6	g/10 min	ASTM D1238
Specific Gravity	1.06	-	ASTM D792
Water Absorption, (23°C/24hrs)	0.06	%	ASTM D570
Mold Shrinkage, flow, 3.2 mm ⁽²⁾	0.5 – 0.7	%	SABIC method
INJECTION MOLDING ⁽³⁾			
Drying Temperature	80 – 90	°C	
Drying Time	2 – 4	Hrs	
Melt Temperature	275 – 310	°C	
Nozzle Temperature	270 – 305	°C	
Front - Zone 3 Temperature	270 – 310	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	265 – 300	°C	
Rear - Zone 1 Temperature	245 – 290	°C	
Mold Temperature	70 – 110	°C	
Screw Speed	40 – 60	rpm	
Back Pressure	0.5 – 1.4	MPa	

- (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) 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.
- (3) 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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