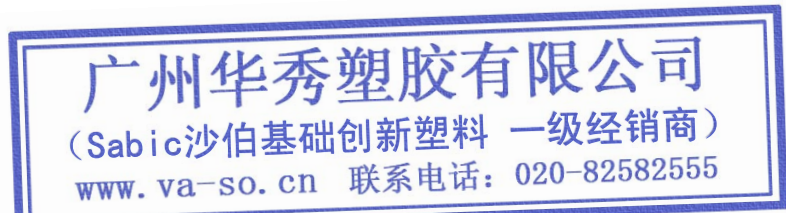




**NORYL™ Resin PVX516**  
**Americas: COMMERCIAL**

PREVEX\* PVX516 resin is a high flow, non FR grade, 110 C HDT

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	480	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	420	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	2.7	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	23	%	ASTM D 638
Tensile Modulus, 5 mm/min	25100	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	760	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25900	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, yield, 50 mm/min	45	MPa	ISO 527
Tensile Stress, break, 50 mm/min	42	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	2.4	%	ISO 527
Tensile Strain, break, 50 mm/min	28	%	ISO 527
Tensile Modulus, 1 mm/min	2420	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	65	MPa	ISO 178
Flexural Modulus, 2 mm/min	2360	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	22	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	244	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -40°C	122	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	16	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	9	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	16	kJ/m <sup>2</sup>	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.

Source GMD, last updated:

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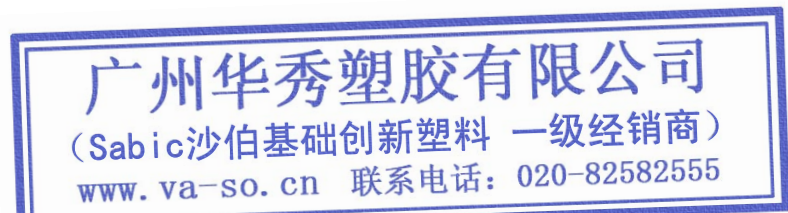
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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>IMPACT</b>			
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	8	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	124	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	118	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	103	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	120	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	110	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	101	°C	ISO 75/Af
<b>PHYSICAL</b>			
Water Absorption, (23°C/sat)	0.07	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	16	cm <sup>3</sup> /10 min	ISO 1133
Melt Viscosity, 280°C, 1500 sec-1	145	Pa-s	ISO 11443



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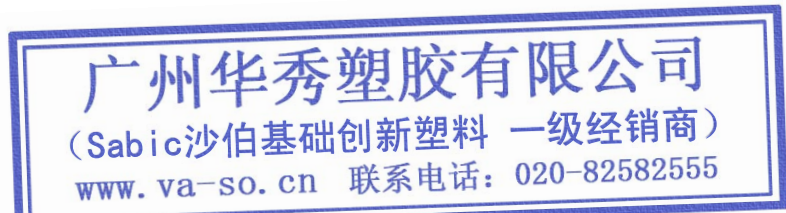
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	60 - 65	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	230 - 290	°C
Nozzle Temperature	230 - 290	°C
Front - Zone 3 Temperature	225 - 280	°C
Middle - Zone 2 Temperature	220 - 275	°C
Rear - Zone 1 Temperature	220 - 270	°C
Mold Temperature	40 - 70	°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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