

Noryl* Resin PX1404

Americas: COMMERCIAL

PPE+PS blend. High Heat. FDA compliant with restrictions. Injection Molding and Extrusion.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	75	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	20	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	104	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2410	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	534	J/m	ASTM D 256
Izod Impact, notched, -40°C	170	J/m	ASTM D 256
Gardner, 23°C	33	J	ASTM D 3029
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	148	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method

Source GMD, last updated:01/05/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	295 - 315	°C
Nozzle Temperature	295 - 315	°C
Front - Zone 3 Temperature	280 - 315	°C
Middle - Zone 2 Temperature	270 - 310	°C
Rear - Zone 1 Temperature	260 - 305	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%

Source GMD, last updated:01/05/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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.

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