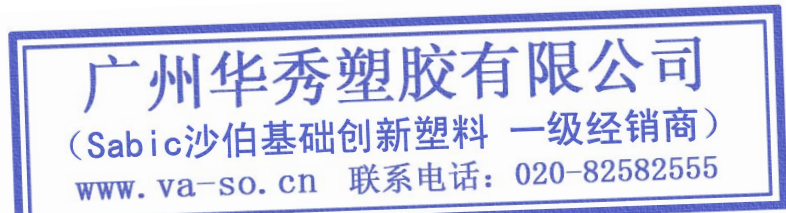




**NORYL™ Resin PX2790C**  
**Asia Pacific: COMMERCIAL**

PPE/HIPS unfilled FR-V1, 90C

| TYPICAL PROPERTIES <sup>1</sup>             | TYPICAL VALUE | Unit                | Standard             |
|---|---------------|---------------------|----------------------|
| <b>MECHANICAL</b>                           |               |                     |                      |
| Tensile Stress, yield                       | 380           | kgf/cm <sup>2</sup> | SABIC - Japan Method |
| Tensile Strain, break                       | 80            | %                   | SABIC - Japan Method |
| Flexural Stress                             | 650           | kgf/cm <sup>2</sup> | ASTM D 790           |
| Flexural Modulus                            | 23700         | kgf/cm <sup>2</sup> | ASTM D 790           |
| Hardness, Rockwell R                        | 115           | -                   | ASTM D 785           |
| <b>IMPACT</b>                               |               |                     |                      |
| Izod Impact, notched, 23°C                  | 26            | cm-kgf/cm           | ASTM D 256           |
| <b>THERMAL</b>                              |               |                     |                      |
| HDT, 1.82 MPa, 6.4 mm, unannealed           | 90            | °C                  | ASTM D 648           |
| CTE, -30°C to 30°C                          | 7.E-05        | 1/°C                | TMA                  |
| <b>PHYSICAL</b>                             |               |                     |                      |
| Specific Gravity                            | 1.1           | -                   | ASTM D 792           |
| Water Absorption, 24 hours                  | 0.07          | %                   | ASTM D 570           |
| Mold Shrinkage, flow, 3.2 mm (5)            | 0.6           | %                   | SABIC Method         |
| Melt Flow Rate, 250°C/10.0 kgf              | 33            | g/10 min            | ASTM D 1238          |
| <b>ELECTRICAL</b>                           |               |                     |                      |
| Surface Resistivity                         | 1.E+16        | Ohm                 | ASTM D 257           |
| Arc Resistance, Tungsten (PLC)              | 7             | PLC Code            | ASTM D 495           |
| <b>FLAME CHARACTERISTICS</b>                |               |                     |                      |
| UL Recognized, 94V-1 Flame Class Rating (3) | 1.5           | mm                  | UL 94                |
| UL Recognized, 94V-0 Flame Class Rating (3) | 6             | mm                  | UL 94                |



(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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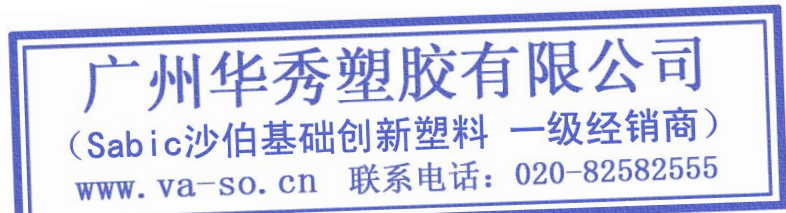
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| PROCESSING PARAMETERS       | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| Drying Temperature          | 75 - 80       | °C   |
| Drying Time                 | 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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