

Noryl* Resin PX1134

Europe-Africa-Middle East: COMMERCIAL

NORYL PX1134 is an unfilled material with a Vicat B/120 of 120°C according ISO 306. NORYL PX1134 offers improved impact performance to meet the standard ECE dashboard impact tests in the automotive industry. Available in several colours, which meet the various automotive standards for interior colours.

Property

| TYPICAL PROPERTIES ⁽¹⁾ | | | |
|---|-----------|-------------------------|----------------|
| MECHANICAL | Value | Unit | Standard |
| Taber Abrasion, CS-17, 1 kg | 65 | mg/1000cy | SABIC Method |
| Tensile Stress, yield, 50 mm/min | 40 | MPa | ISO 527 |
| Tensile Stress, break, 50 mm/min | 40 | MPa | ISO 527 |
| Tensile Strain, yield, 50 mm/min | 3 | % | ISO 527 |
| Tensile Strain, break, 50 mm/min | 40 | % | ISO 527 |
| Tensile Modulus, 1 mm/min | 2100 | MPa | ISO 527 |
| Flexural Stress, yield, 2 mm/min | 85 | MPa | ISO 178 |
| Flexural Modulus, 2 mm/min | 1900 | MPa | ISO 178 |
| Hardness, H358/30 | 80 | MPa | ISO 2039-1 |
| IMPACT | Value | Unit | Standard |
| Izod Impact, notched 80*10*4 +23°C | 18 | kJ/m ² | ISO 180/1A |
| Izod Impact, notched 80*10*4 -30°C | 10 | kJ/m ² | ISO 180/1A |
| Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm | 19 | kJ/m ² | ISO 179/1eA |
| Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm | 14 | kJ/m ² | ISO 179/1eA |
| THERMAL | Value | Unit | Standard |
| Thermal Conductivity | 0.23 | W/m.°C | ISO 8302 |
| CTE, 23°C to 80°C, flow | 7.E-05 | 1/°C | ISO 11359-2 |
| CTE, 23°C to 80°C, xflow | 9.E-05 | 1/°C | ISO 11359-2 |
| Ball Pressure Test, 75°C +/- 2°C | PASSES | - | IEC 60695-10-2 |
| Vicat Softening Temp, Rate A/50 | 130 | °C | ISO 306 |
| Vicat Softening Temp, Rate B/50 | 115 | °C | ISO 306 |
| Vicat Softening Temp, Rate B/120 | 125 | °C | ISO 306 |
| HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm | 120 | °C | ISO 75/Be |
| HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm | 105 | °C | ISO 75/Ae |
| PHYSICAL | Value | Unit | Standard |
| Mold Shrinkage on Tensile Bar, flow (2) | 0.5 - 0.7 | % | SABIC Method |
| Density | 1.06 | g/cm ³ | ISO 1183 |
| Water Absorption, (23°C/sat) | 0.14 | % | ISO 62 |
| Moisture Absorption (23°C / 50% RH) | 0.06 | % | ISO 62 |
| Melt Volume Rate, MVR at 280°C/5.0 kg | 10 | cm ³ /10 min | ISO 1133 |
| ELECTRICAL | Value | Unit | Standard |
| Volume Resistivity | 1.E+15 | Ohm-cm | IEC 60093 |
| Surface Resistivity, ROA | >1.E+15 | Ohm | IEC 60093 |
| Dielectric Strength, in oil, 3.2 mm | 17 | kV/mm | IEC 60243-1 |
| Relative Permittivity, 50/60 Hz | 2.7 | - | IEC 60250 |
| Relative Permittivity, 1 MHz | 2.6 | - | IEC 60250 |
| Dissipation Factor, 50/60 Hz | 0.0004 | - | IEC 60250 |

| | | | |
|--|--------|------|-------------|
| Dissipation Factor, 1 MHz | 0.0009 | - | IEC 60250 |
| FLAME CHARACTERISTICS | Value | Unit | Standard |
| UL Compliant, 94HB Flame Class Rating (3)(4) | 1.6 | mm | UL 94 by GE |

Source GMD, last updated:03/23/2000

Processing

| Parameter | Value | Unit |
|-----------------------------|-----------|------|
| Injection Molding | | |
| Drying Temperature | 100 - 120 | °C |
| Drying Time | 2 - 3 | hrs |
| Melt Temperature | 280 - 300 | °C |
| Nozzle Temperature | 260 - 280 | °C |
| Front - Zone 3 Temperature | 280 - 300 | °C |
| Middle - Zone 2 Temperature | 260 - 280 | °C |
| Rear - Zone 1 Temperature | 240 - 260 | °C |
| Hopper Temperature | 60 - 80 | °C |
| Mold Temperature | 80 - 120 | °C |

Source GMD, last updated:03/23/2000

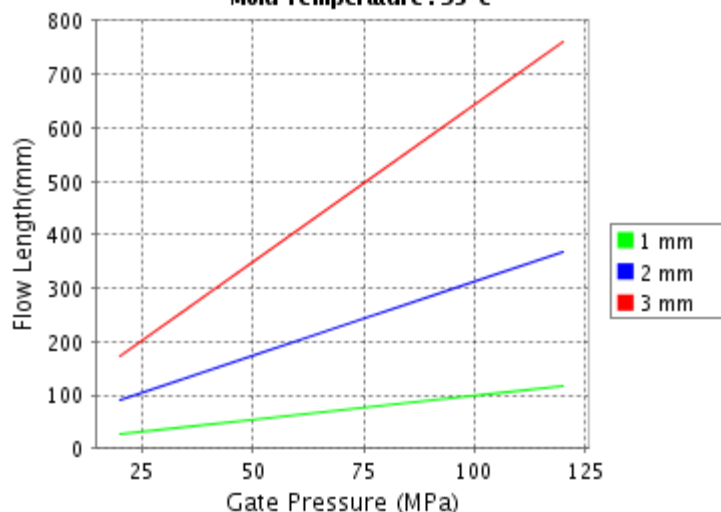
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

LNP Staramide DBG014

Melt Temperature : 270°C

Mold Temperature : 95°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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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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