

Noryl* Resin CRX1005

Europe-Africa-Middle East: LIMITED USE

NORYL CRX1005 is unfilled material with a HDT of 105 °C according ISO 75. NORYL CRX1005 is designed for improved chemical resistance. Can be used for extrusion and injection purposes.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yield, 50 mm/min	35	MPa	ISO 527
Tensile Stress, break, 50 mm/min	35	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	70	%	ISO 527
Tensile Modulus, 1 mm/min	1750	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	55	MPa	ISO 178
Flexural Modulus, 2 mm/min	1800	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	50	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	50	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	21	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	16	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
Ball Pressure Test, 75°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/120	110	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	105	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	95	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.08	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 280°C/5.0 kg	6	cm ³ /10 min	ISO 1133

Source GMD, last updated:11/25/2003

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80 - 100	°C
Drying Time	2 - 4	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	60 - 100	°C

Source GMD, last updated:11/25/2003

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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