



NORYL™ Resin 844
Asia Pacific: COMMERCIAL

Medium heat PPO/HIPS alloy used in the automotive industry.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	390	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	41	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	690	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	23800	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	20	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	96	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	108	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.07	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method

(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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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100 - 110	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Melt Temperature	260 - 280	°C
Mold Temperature	60 - 80	°C

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