



## NORYL™ Resin FE1520PW Europe-Africa-Middle East: COMMERCIAL

Noryl\* FE1520PW resin is a blend of polyphenylene oxide (PPO) and polystyrene (PS) resin that contains 20% glass reinforcement. The resin is suitable for injection molding. Noryl FE1520PW resin has been developed for fluid engineering applications that require improved hydrolytic stability. Noryl FE1520PW resin has been certified for potable water applications up to 85C in Europe and North America in limited colors.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	1210	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.6	%	ASTM D 638
Tensile Modulus, 5 mm/min	72400	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1780	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	71000	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, break, 5 mm/min	119	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	7170	MPa	ISO 527
Flexural Stress, break, 2 mm/min	165	MPa	ISO 178
Flexural Modulus, 2 mm/min	6040	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	40	cm-kgf/cm	ASTM D 4812
Izod Impact, unnotched, -30°C	40	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	4	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	23	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	kJ/m <sup>2</sup>	ISO 180/1A
Charpy Impact, notched, 23°C	6	kJ/m <sup>2</sup>	ISO 179/2C
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy Impact, notched, -30°C	27	kJ/m <sup>2</sup>	ISO 179/2C

(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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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>IMPACT</b>			
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	30	kJ/m <sup>2</sup>	ISO 179/1eU
<b>THERMAL</b>			
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate A/50	150	°C	ISO 306
Vicat Softening Temp, Rate B/120	144	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	132	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	139	°C	ISO 75/Ae
<b>PHYSICAL</b>			
Water Absorption, 50% RH, equilib	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.4	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.3 - 0.6	%	SABIC Method
Density	1.24	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	0.2	%	ISO 62
Melt Volume Rate, MVR at 280°C/10.0 kg	22	cm <sup>3</sup> /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
<b>Injection Molding</b>		
Drying Temperature	100 - 120	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 300	°C
Nozzle Temperature	280 - 300	°C
Front - Zone 3 Temperature	290 - 310	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	250 - 270	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	80 - 120	°C

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