



NORYL™ Resin FE1630PW
Europe-Africa-Middle East: COMMERCIAL

Noryl* FE1630PW Polyphenylene Oxide (PPO) + Polystyrene (PS) resin is a 30 % Glass Reinforced, injection moldable grade with improved hydrolytic stability; this grade has been developed for fluid engineering applications. Noryl* FE1630PW has been certified for potable water applications up to 85C in Europe and North America in limited colours

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1360	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Modulus, 5 mm/min	97600	kgf/cm ²	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	79100	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	133	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.5	%	ISO 527
Tensile Modulus, 1 mm/min	9600	MPa	ISO 527
Flexural Stress, break, 2 mm/min	192	MPa	ISO 178
Flexural Modulus, 2 mm/min	8120	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	51	cm-kgf/cm	ASTM D 4812
Izod Impact, unnotched, -30°C	47	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	7	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	30	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	7	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	10	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	9	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	30	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	30	kJ/m ²	ISO 179/1eU



(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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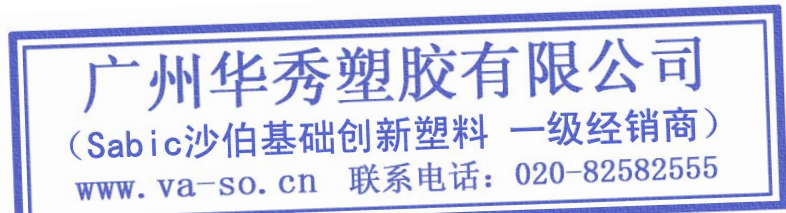
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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	145	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.5E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate A/50	165	°C	ISO 306
Vicat Softening Temp, Rate B/50	154	°C	ISO 306
Vicat Softening Temp, Rate B/120	158	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	150	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	145	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage, flow, 3.2 mm (5)	0.1 - 0.3	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.2 - 0.5	%	SABIC Method
Melt Flow Rate, 300°C/5.0 kgf	9	g/10 min	ASTM D 1238
Density	1.3	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.2	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 300°C/10.0 kg	30	cm ³ /10 min	ISO 1133



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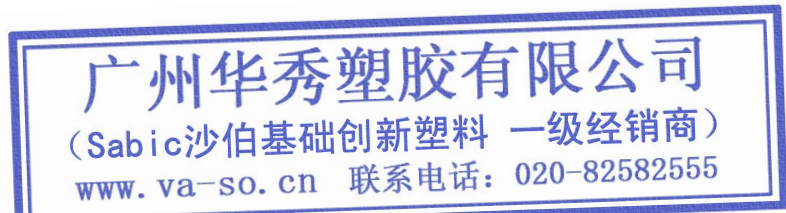
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100 - 120	°C
Drying Time	2 - 4	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	280 - 300	°C
Nozzle Temperature	280 - 300	°C
Front - Zone 3 Temperature	290 - 310	°C
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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