

## Noryl\* Resin 844

Asia Pacific: COMMERCIAL

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

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	39	MPa	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	68	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2340	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	197	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
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	Value	Unit	Standard
Specific Gravity	1.07	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method

Source GMD, last updated:06/18/1999

### Processing

Parameter	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

Source GMD, last updated:06/18/1999

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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