



NORYL PPX™ Resin PPX630
Asia Pacific: COMMERCIAL

30% GR PPE+PP. High elongation. high stiffness. NSF Standard 61 Compliant (color limited).

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	800	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	800	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	7.7	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1320	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	56600	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	84	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	16	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	194	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	208	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	162	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	155	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	133	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.44E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.74E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.23	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.25 - 0.76	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	2.6	g/10 min	ASTM D 1238

(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.

(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	65 - 75	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 300	°C
Nozzle Temperature	260 - 300	°C
Front - Zone 3 Temperature	255 - 295	°C
Middle - Zone 2 Temperature	250 - 290	°C
Rear - Zone 1 Temperature	245 - 290	°C
Mold Temperature	40 - 65	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.051 - 0.076	mm

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