



NORYL PPX™ Resin PPX7200
Asia Pacific: COMMERCIAL

PP+PPE+PS. Improved chemical resistance and surface aesthetics in injection molded applications. NSF61-capable. UL-94 HB listed.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	340	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	280	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	10	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D 638
Tensile Modulus, 50 mm/min	12600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	490	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	14700	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	34	MPa	ISO 527
Tensile Stress, break, 50 mm/min	28	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	8.2	%	ISO 527
Tensile Strain, break, 50 mm/min	115	%	ISO 527
Tensile Modulus, 1 mm/min	1670	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	48	MPa	ISO 178
Flexural Modulus, 2 mm/min	1600	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	147	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	15	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	0	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	368	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10'4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80°10'4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80°10'4 +23°C	14	kJ/m ²	ISO 180/1A

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(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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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	12	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	80	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	146	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	110	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	71	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.08E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	9.9E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.08E-04	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	-	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	103	°C	ISO 306
Vicat Softening Temp, Rate B/120	107	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	73	°C	ISO 75/AF
PHYSICAL			
Specific Gravity	0.99	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	16	g/10 min	ASTM D 1238
Density	0.99	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.05	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.02	%	ISO 62

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

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Melt Volume Rate, MVR at 260°C/5.0 kg	18	cm ³ /10 min	ISO 1133

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	60 - 65	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	240 - 280	°C
Rear - Zone 1 Temperature	225 - 275	°C
Mold Temperature	30 - 50	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm

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