

NORYL PPX™ PPX630F resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

Message:

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

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	High Elongation		
	High Stiffness		
Agency Ratings	NSF 61		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	2.6	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.20 to 0.23	%	
Across Flow : 3.20 mm	0.25 to 0.76	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	79.3	MPa	
Break	79.3	MPa	
Tensile Elongation ² (Break)	7.7	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	5560	MPa	ASTM D790
Flexural Strength ⁴ (Break, 50.0 mm Span)	130	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	100	J/m	
23°C	170	J/m	
Unnotched Izod Impact (23°C)	830	J/m	ASTM D4812
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	20.4	J	
23°C, Total Energy	19.1	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	155	°C	
1.8 MPa, Unannealed, 3.20 mm	134	°C	
Vicat Softening Temperature	162	°C	ASTM D1525 ⁵
CLTE			ASTM E831

Flow : -40 to 40°C	1.4E-5	cm/cm/°C
Transverse : -40 to 40°C	7.7E-5	cm/cm/°C
Flammability	Nominal Value	Test Method
Flame Rating (1.50 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	65.6 to 76.7	°C
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	30 to 70	%
Rear Temperature	243 to 288	°C
Middle Temperature	249 to 288	°C
Front Temperature	254 to 293	°C
Nozzle Temperature	260 to 299	°C
Processing (Melt) Temp	260 to 299	°C
Mold Temperature	37.8 to 65.6	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.051 to 0.076	mm
NOTE		
1.	Type I, 5.0 mm/min	
2.	Type I, 5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	
5.	Rate B (120°C/h), Loading 2 (50 N)	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

