

NORYL PPX™ PPX7200 resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

Message:

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

General Information			
Features	Good Chemical Resistance		
	Good Surface Finish		
Agency Ratings	NSF 61		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.988	g/cm ³	ASTM D792
--	0.990	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	16	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	18.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.60 to 0.80	%	
Across Flow : 3.20 mm	0.60 to 0.80	%	
Water Absorption			ISO 62
Saturation, 23°C	0.050	%	
Equilibrium, 23°C, 50% RH	0.020	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1240	MPa	ASTM D638
--	1670	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	33.8	MPa	ASTM D638
Yield	34.0	MPa	ISO 527-2/50
Break ³	27.6	MPa	ASTM D638
Break	28.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	10	%	ASTM D638
Yield	8.2	%	ISO 527-2/50
Break ⁵	130	%	ASTM D638
Break	120	%	ISO 527-2/50
Flexural Modulus			

50.0 mm Span ⁶	1450	MPa	ASTM D790
-- ⁷	1610	MPa	ISO 178
Flexural Stress			
--	48.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	49.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	6.1	kJ/m ²	
23°C	12	kJ/m ²	
Charpy Unnotched Impact Strength ¹⁰			ISO 179/1eU
-30°C	80	kJ/m ²	
23°C	No Break		
Notched Izod Impact			
-30°C	0.85	J/m	ASTM D256
23°C	150	J/m	ASTM D256
-30°C ¹¹	8.0	kJ/m ²	ISO 180/1A
23°C ¹²	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1400	J/m	ASTM D4812
-30°C ¹³	No Break		ISO 180/1U
23°C ¹⁴	No Break		ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	36.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	110	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	71.1	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁵	73.4	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	146	°C	ASTM D1525 ¹⁶
--	103	°C	ISO 306/B50
--	107	°C	ISO 306/B120
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	9.9E-5	cm/cm/°C	
Transverse : -40 to 40°C	1.1E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	60.0 to 65.6	°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	227 to 277	°C	

Middle Temperature	238 to 282	°C
Front Temperature	249 to 288	°C
Nozzle Temperature	260 to 288	°C
Processing (Melt) Temp	260 to 288	°C
Mold Temperature	32.2 to 48.9	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.038 to 0.051	mm

NOTE

1.	50 mm/min
2.	Type I, 50 mm/min
3.	Type I, 50 mm/min
4.	Type I, 50 mm/min
5.	Type I, 50 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4 sp=62mm
10.	80*10*4 sp=62mm
11.	80*10*4
12.	80*10*4
13.	80*10*4
14.	80*10*4
15.	80*10*4 mm
16.	Rate B (120°C/h), Loading 2 (50 N)

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