

NORYL GTX™ GTX674PC resin

Polyphenylene Ether + PS + Nylon

SABIC Innovative Plastics

Message:

A conductive PPE/PA blend designed to have improved surface appearance and elevated heat resistance for powder coating. The material is suitable for injection molding. The material is only available in black.

General Information			
Features	Conductivity		
	Heat resistance, high		
	Good appearance		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.0 - 1.3	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2810	MPa	ASTM D638
Tensile Strength			
Yield ²	65.0	MPa	ASTM D638
Fracture ³	64.0	MPa	ASTM D638
Fracture	60.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	3.0	%	ASTM D638
Yield	3.0	%	ISO 527-2/50
Fracture ⁵	4.0	%	ASTM D638
Fracture	4.0	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2890	MPa	ASTM D790
-- ⁷	2480	MPa	ISO 178
Flexural Stress			
--	103	MPa	ISO 178
Yield, 50.0mm span ⁸	109	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	50	J/m	ASTM D256
23°C	74	J/m	ASTM D256

Instrumented Dart Impact (23°C, Total Energy)	4.00	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	188	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁹	185	°C	ISO 75-2/Bf
Vicat Softening Temperature			
--	197	°C	ASTM D1525, ISO 306/B50 8 ¹⁰
--	196	°C	ISO 306/B120
Linear thermal expansion coefficient			
Flow: -40 to 40°C	7.6E-5	cm/cm/°C	ASTM E831
Flow: 23 to 80°C	8.1E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	7.8E-5	cm/cm/°C	ASTM E831
Lateral: 23 to 80°C	8.6E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+3 - 1.0E+4	ohms·cm	Internal method
Injection	Nominal Value	Unit	
Drying Temperature	93.3 - 107	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.070	%	
Suggested Shot Size	30 - 50	%	
Rear Temperature	266 - 304	°C	
Middle Temperature	271 - 304	°C	
Front Temperature	277 - 304	°C	
Nozzle Temperature	282 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	76.7 - 121	°C	
Back Pressure	0.345 - 1.38	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.013 - 0.038	mm	
Injection instructions			
Minimum Moisture Content: .02 %			
NOTE			
1.	5.0 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	Type 1, 50mm/min		
5.	Type 1, 50mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		

9.	80*10*4 mm
10.	标准 B (120°C/h), 载荷2 (50N)

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