

# NORYL PPX™ PPX630 resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

## Message:

PPX630 is a 30% glass filled alloy of PP and PPO providing design freedom for applications requiring a wide range of stiffness, toughness and temperature. Generic identification acc. ISO11469: PP+PPE-I-GF30

| General Information                           |                                                       |                        |                 |
|-----------------------------------------------|-------------------------------------------------------|------------------------|-----------------|
| UL YellowCard                                 | E45329-100962693                                      |                        |                 |
| Filler / Reinforcement                        | Glass fiber reinforced material, 30% filler by weight |                        |                 |
| Features                                      | Rigid, good                                           |                        |                 |
|                                               | Thermal stability, good                               |                        |                 |
|                                               | Good toughness                                        |                        |                 |
| RoHS Compliance                               | RoHS compliance                                       |                        |                 |
| Processing Method                             | Injection molding                                     |                        |                 |
| Part Marking Code (ISO 11469)                 | >PP+PPE-I-GF30                                        |                        |                 |
| Physical                                      | Nominal Value                                         | Unit                   | Test Method     |
| Density                                       | 1.19                                                  | g/cm <sup>3</sup>      | ISO 1183        |
| Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)    | 3.20                                                  | cm <sup>3</sup> /10min | ISO 1133        |
| Molding Shrinkage <sup>1</sup>                |                                                       |                        | Internal method |
| Flow                                          | 0.20 - 0.30                                           | %                      | Internal method |
| Transverse flow                               | 0.20 - 0.70                                           | %                      | Internal method |
| Water Absorption                              |                                                       |                        |                 |
| Saturated, 23°C                               | 0.20                                                  | %                      | ISO 62          |
| Equilibrium, 23°C, 50% RH                     | 0.040                                                 | %                      | ASTM D570       |
| Hardness                                      | Nominal Value                                         | Unit                   | Test Method     |
| Ball Indentation Hardness (H 358/30)          | 75.0                                                  | MPa                    | ISO 2039-1      |
| Mechanical                                    | Nominal Value                                         | Unit                   | Test Method     |
| Tensile Modulus                               | 6600                                                  | MPa                    | ISO 527-2/1     |
| Tensile Stress (Break)                        | 80.0                                                  | MPa                    | ISO 527-2/5     |
| Tensile Strain (Break)                        | 4.1                                                   | %                      | ISO 527-2/5     |
| Flexural Modulus <sup>2</sup>                 | 5500                                                  | MPa                    | ISO 178         |
| Flexural Stress                               | 120                                                   | MPa                    | ISO 178         |
| Impact                                        | Nominal Value                                         | Unit                   | Test Method     |
| Charpy Notched Impact Strength <sup>3</sup>   |                                                       |                        | ISO 179/1eA     |
| -30°C                                         | 10                                                    | kJ/m <sup>2</sup>      | ISO 179/1eA     |
| 23°C                                          | 15                                                    | kJ/m <sup>2</sup>      | ISO 179/1eA     |
| Charpy Unnotched Impact Strength <sup>4</sup> |                                                       |                        | ISO 179/1eU     |
| -30°C                                         | 50                                                    | kJ/m <sup>2</sup>      | ISO 179/1eU     |

| 23°C                                        | 50            | kJ/m <sup>2</sup> | ISO 179/1eU    |
|---------------------------------------------|---------------|-------------------|----------------|
| Notched Izod Impact <sup>5</sup>            |               |                   | ISO 180/1A     |
| -30°C                                       | 10            | kJ/m <sup>2</sup> | ISO 180/1A     |
| 23°C                                        | 15            | kJ/m <sup>2</sup> | ISO 180/1A     |
| Unnotched Izod Impact Strength <sup>6</sup> |               |                   | ISO 180/1U     |
| -30°C                                       | 46            | kJ/m <sup>2</sup> | ISO 180/1U     |
| 23°C                                        | 48            | kJ/m <sup>2</sup> | ISO 180/1U     |
| Thermal                                     | Nominal Value | Unit              | Test Method    |
| Heat Deflection Temperature <sup>7</sup>    |               |                   |                |
| 0.45 MPa, unannealed, 100 mm span           | 155           | °C                | ISO 75-2/Be    |
| 1.8 MPa, unannealed, 100 mm span            | 135           | °C                | ISO 75-2/Ae    |
| Vicat Softening Temperature                 |               |                   |                |
| --                                          | 125           | °C                | ISO 306/B50    |
| --                                          | 128           | °C                | ISO 306/B120   |
| Ball Pressure Test (125°C)                  | Pass          |                   | IEC 60695-10-2 |
| Linear thermal expansion coefficient        |               |                   | ISO 11359-2    |
| Flow: 23 to 60°C                            | 2.0E-5        | cm/cm/°C          | ISO 11359-2    |
| Lateral: 23 to 60°C                         | 1.2E-4        | cm/cm/°C          | ISO 11359-2    |
| Electrical                                  | Nominal Value | Unit              | Test Method    |
| Surface Resistivity                         | > 1.0E+15     | ohms              | IEC 60093      |
| Volume Resistivity                          | > 1.0E+15     | ohms·cm           | IEC 60093      |
| Dielectric Strength (3.20 mm, in Oil)       | 24            | kV/mm             | IEC 60243-1    |
| Relative Permittivity                       |               |                   | IEC 60250      |
| 50 Hz                                       | 2.40          |                   | IEC 60250      |
| 60 Hz                                       | 2.40          |                   | IEC 60250      |
| 1 MHz                                       | 2.40          |                   | IEC 60250      |
| Dissipation Factor                          |               |                   | IEC 60250      |
| 50 Hz                                       | 3.0E-4        |                   | IEC 60250      |
| 60 Hz                                       | 3.0E-4        |                   | IEC 60250      |
| 1 MHz                                       | 1.0E-3        |                   | IEC 60250      |
| Comparative Tracking Index                  | 500           | V                 | IEC 60112      |
| Flammability                                | Nominal Value | Unit              | Test Method    |
| Flame Rating (1.50 mm)                      | HB            |                   | UL 94          |
| Glow Wire Flammability Index (3.20 mm)      | 650           | °C                | IEC 60695-2-12 |
| Injection                                   | Nominal Value | Unit              |                |
| Drying Temperature                          | 65.0 - 75.0   | °C                |                |
| Drying Time                                 | 2.0 - 4.0     | hr                |                |
| Suggested Max Moisture                      | 0.020         | %                 |                |
| Hopper Temperature                          | 60.0 - 80.0   | °C                |                |
| Rear Temperature                            | 245 - 290     | °C                |                |
| Middle Temperature                          | 250 - 290     | °C                |                |
| Front Temperature                           | 255 - 290     | °C                |                |

|                        |             |    |
|------------------------|-------------|----|
| Nozzle Temperature     | 260 - 300   | °C |
| Processing (Melt) Temp | 260 - 300   | °C |
| Mold Temperature       | 40.0 - 65.0 | °C |

| NOTE |                 |  |
|------|-----------------|--|
| 1.   | Tensile Bar     |  |
| 2.   | 2.0 mm/min      |  |
| 3.   | 80*10*4 sp=62mm |  |
| 4.   | 80*10*4 sp=62mm |  |
| 5.   | 80*10*4         |  |
| 6.   | 80*10*4         |  |
| 7.   | 120*10*4 mm     |  |

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