

NORYL PPX™ PPX7115F resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

Message:

High modulus/impact/heat PPE+PP

General Information			
Features	High Heat Resistance		
	High Impact Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.988	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	14	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	12.0	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.60 to 0.70	%	
Across Flow : 3.20 mm	0.60 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1240	MPa	ASTM D638
--	1380	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	35.9	MPa	ASTM D638
Yield	35.0	MPa	ISO 527-2/50
Break ³	34.5	MPa	ASTM D638
Tensile Elongation			
Yield ⁴	8.0	%	ASTM D638
Break ⁵	130	%	ASTM D638
Break	75	%	ISO 527-2/50
Flexural Modulus ⁶ (50.0 mm Span)	1380	MPa	ASTM D790
Flexural Strength ⁷ (Yield, 50.0 mm Span)	51.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	530	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	30.0	J	
23°C, Total Energy	37.0	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, Unannealed, 3.20 mm	113	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁸	116	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	85.0	°C	ASTM D648
Vicat Softening Temperature			
--	86.7	°C	ASTM D1525 ⁹
--	131	°C	ISO 306/A50
CLTE			ASTM E831
Flow : -40 to 40°C	1.6E-4	cm/cm/°C	
Transverse : -40 to 40°C	9.7E-5	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.	1.3 mm/min
8.	80*10*4 mm
9.	Rate B (120°C/h), Loading 2 (50 N)

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