

NORYL PPX™ PPX630 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 reinforced material, 30% filler by weight		
Features	Rigidity, high		
	Extended tensile rate		
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: 3.20mm	0.20 - 0.23	%	Internal method
Transverse flow: 3.20mm	0.25 - 0.76	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	79.3	MPa	ASTM D638
Fracture	79.3	MPa	ASTM D638
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	ASTM D256
23°C	170	J/m	ASTM D256
Unnotched Izod Impact (23°C)	830	J/m	ASTM D4812
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	20.4	J	ASTM D3763
23°C, Total Energy	19.1	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	155	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	134	°C	ASTM D648
Vicat Softening Temperature	162	°C	ASTM D1525 ⁵
Linear thermal expansion coefficient			ASTM E831

Flow: -40 to 40°C	1.4E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.7E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
Drying Temperature	65.6 - 76.7	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 - 70	%	
Rear Temperature	243 - 288	°C	
Middle Temperature	249 - 288	°C	
Front Temperature	254 - 293	°C	
Nozzle Temperature	260 - 299	°C	
Processing (Melt) Temp	260 - 299	°C	
Mold Temperature	37.8 - 65.6	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.051 - 0.076	mm	

NOTE

1. Type 1, 5.0 mm/min
2. Type 1, 5.0 mm/min
3. 1.3 mm/min
4. 1.3 mm/min
5. 标准 B (120°C/h), 载荷2 (50N)

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