

NORYL PPX™ PPX7110 resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

Message:

PPE+PP blend. High Impact, Good Heat Resistance

General Information			
Features	Impact resistance, high		
	Heat resistance, high		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.968	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.80 - 1.2	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	1340	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	35.9	MPa	ASTM D638
Fracture	32.4	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	6.5	%	ASTM D638
Fracture	200	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	1550	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	51.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	150	J/m	ASTM D256
23°C	440	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	27.8	J	ASTM D3763
23°C, Total Energy	38.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	113	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	77.2	°C	ASTM D648
Vicat Softening Temperature	139	°C	ASTM D1525 ⁶
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	8.1E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	1.1E-4	cm/cm/°C	ASTM E831

RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating (1.52 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	60.0 - 65.6	°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	227 - 277	°C	
Middle Temperature	238 - 282	°C	
Front Temperature	249 - 288	°C	
Nozzle Temperature	260 - 288	°C	
Processing (Melt) Temp	260 - 288	°C	
Mold Temperature	32.2 - 48.9	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.038 - 0.051	mm	
NOTE			
1.	50 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	1.3 mm/min		
5.	1.3 mm/min		
6.	标准 B (120°C/h), 载荷2 (50N)		

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