

NORYL PPX™ PPX640F resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

Message:

40% GR PPE+PP. High elongation. high stiffness. NSF Standard 61 Compliant (color limited).

General Information			
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Features	High Elongation		
	High Stiffness		
Agency Ratings	NSF 61		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	1.3	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.17 to 0.18	%	
Across Flow : 3.20 mm	0.27 to 0.61	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	95.8	MPa	
Break	95.8	MPa	
Tensile Elongation ² (Break)	6.4	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	8320	MPa	ASTM D790
Flexural Strength ⁴ (Break, 50.0 mm Span)	151	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	96	J/m	
23°C	110	J/m	
Unnotched Izod Impact (23°C)	580	J/m	ASTM D4812
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	14.1	J	
23°C, Total Energy	16.8	J	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	159	°C	
1.8 MPa, Unannealed, 3.20 mm	146	°C	
Vicat Softening Temperature	163	°C	ASTM D1525 ⁵
CLTE			ASTM E831

Flow : -40 to 40°C	1.1E-5	cm/cm/°C
Transverse : -40 to 40°C	6.3E-5	cm/cm/°C
Injection	Nominal Value	Unit
Drying Temperature	65.6 to 76.7	°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	243 to 288	°C
Middle Temperature	249 to 288	°C
Front Temperature	254 to 299	°C
Nozzle Temperature	260 to 304	°C
Processing (Melt) Temp	260 to 304	°C
Mold Temperature	37.8 to 65.6	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	20 to 100	rpm
Vent Depth	0.051 to 0.076	mm

NOTE

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

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