

# NORYL GTX™ RESIN GTX674PC

REGION EUROPE

## DESCRIPTION

A conductive PPE/PA blend designed to have improved surface appearance and elevated heat resistance for powder coating. The material is suitable for injection molding. The material is only available in black.

## TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	65	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	64	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Modulus, 5 mm/min	2810	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	109	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2890	MPa	ASTM D 790
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3	%	ISO 527
Tensile Strain, break, 50 mm/min	4	%	ISO 527
Flexural Stress, yield, 2 mm/min	103	MPa	ISO 178
Flexural Modulus, 2 mm/min	2480	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	74	J/m	ASTM D 256
Izod Impact, notched, -30°C	50	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	4	J	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	197	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	188	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.8E-05	1/°C	ASTM E 831
CTE, 23°C to 80°C, flow	8.1E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	8.6E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	197	°C	ISO 306
Vicat Softening Temp, Rate B/120	196	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	185	°C	ISO 75/Bf
<b>PHYSICAL</b>			
Specific Gravity	1.11	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	1 – 1.3	%	SABIC method
Melt Flow Rate, 300°C/5.0 kgf	25	g/10 min	ASTM D 1238
<b>ELECTRICAL</b>			
Volume Resistivity	1000 – 10000	Ohm-cm	SABIC method
<b>INJECTION MOLDING</b>			
Drying Temperature	95 – 105	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.07	%	
Minimum Moisture Content	0.02	%	
Melt Temperature	280 – 305	°C	
Nozzle Temperature	280 – 305	°C	
Front - Zone 3 Temperature	275 – 305	°C	
Middle - Zone 2 Temperature	270 – 305	°C	
Rear - Zone 1 Temperature	265 – 305	°C	
Mold Temperature	75 – 120	°C	
Back Pressure	0.3 – 1.4	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 50	%	
Vent Depth	0.013 – 0.038	mm	

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