

# NORYL PPX™ RESIN PPX630

REGION ASIA

## DESCRIPTION

30% GR PPE+PP. High elongation. high stiffness. NSF Standard 61 Compliant (color limited).

## TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	79	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	79	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	7.7	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	129	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	5550	MPa	ASTM D 790
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	827	J/m	ASTM D 4812
Izod Impact, notched, 23°C	165	J/m	ASTM D 256
Izod Impact, notched, -30°C	101	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	19	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	20	J	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	162	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	155	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	133	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.44E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.74E-05	1/°C	ASTM E 831
<b>PHYSICAL</b>			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.2 – 0.23	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.25 – 0.76	%	SABIC method
Melt Flow Rate, 260°C/5.0 kgf	2.6	g/10 min	ASTM D 1238
<b>INJECTION MOLDING</b>			
Drying Temperature	65 – 75	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 300	°C	
Nozzle Temperature	260 – 300	°C	
Front - Zone 3 Temperature	255 – 295	°C	
Middle - Zone 2 Temperature	250 – 290	°C	
Rear - Zone 1 Temperature	245 – 290	°C	
Mold Temperature	40 – 65	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	

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Shot to Cylinder Size	30 – 70	%	
Vent Depth	0.051 – 0.076	mm	

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