

# NORYL GTX™ RESIN GTX4610

REGION ASIA

## DESCRIPTION

NORYL GTX GTX4610 resin is a high performance, 10% glass filled blend of PPE/PA that exhibits an excellent balance of non-halogenated flame retardance, dimensional stability, high heat resistance, strength, and flow. The material is available in limited colors for injection molding.

## TYPICAL PROPERTY VALUES

Revision 20180906

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 5 mm/min	88	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	88	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Modulus, 5 mm/min	5000	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	145	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	4600	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	88	MPa	ISO 527
Tensile Stress, break, 5 mm/min	88	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3	%	ISO 527
Tensile Strain, break, 5 mm/min	7	%	ISO 527
Tensile Modulus, 1 mm/min	5000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	145	MPa	ISO 178
Flexural Modulus, 2 mm/min	4600	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched, 23°C	80	J/m	ASTM D 256
Izod Impact, notched, -30°C	65	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	12	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	7	kJ/m <sup>2</sup>	ISO 179/1eA
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	218	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	220	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.1E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.1E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.4E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	218	°C	ISO 306
Vicat Softening Temp, Rate B/120	220	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	224	°C	ISO 75/Bf
<b>PHYSICAL</b>			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.88 – 0.94	%	SABIC method

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, xflow, 3.2 mm	0.95 – 1.01	%	SABIC method
Melt Flow Rate, 300°C/5.0 kgf	18	g/10 min	ASTM D 1238
Density	1.21	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	3.8	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.5	%	ISO 62
Melt Volume Rate, MVR at 300°C/5.0 kg	15	cm <sup>3</sup> /10 min	ISO 1133
<b>ELECTRICAL</b>			
Volume Resistivity	1.E+16	Ohm-cm	ASTM D 257
Dielectric Strength, in air, 1.6 mm	23.2	kV/mm	ASTM D 149
Dielectric Strength, in oil, 1.6 mm	24.4	kV/mm	ASTM D 149
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index	425	V	IEC 60112
<b>FLAME CHARACTERISTICS</b>			
UL Compliant, 94V-1 Flame Class Rating	0.8	mm	UL 94 by SABIC-IP
UL Compliant, 94-5VA Rating	2	mm	UL 94 by SABIC-IP
UL Compliant, 94-5VB Rating	2	mm	UL 94 by SABIC-IP
Glow Wire Flammability Index 960°C, passes at	2	mm	IEC 60695-2-12
Glow Wire Ignitability Temperature, 1.0 mm	825	°C	IEC 60695-2-13
<b>INJECTION MOLDING</b>			
Drying Temperature	95 – 105	°C	
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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