

NORYL GTX™ RESIN GTX918W

REGION ASIA

DESCRIPTION

High flow NORYL GTX resin for under-the-hood and electrical applications requiring retention of properties under thermal load

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	53	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	98	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2360	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	202	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	40	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	188	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	148	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.09	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	1.3 – 1.6	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	1 – 1.3	%	SABIC method
INJECTION MOLDING			
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	270 – 295	°C	
Nozzle Temperature	270 – 295	°C	
Front - Zone 3 Temperature	265 – 295	°C	
Middle - Zone 2 Temperature	260 – 295	°C	
Rear - Zone 1 Temperature	255 – 295	°C	
Mold Temperature	65 – 95	°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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