

NORYL PPX™ RESIN PPX7110

REGION ASIA

DESCRIPTION

PPE+PP blend. High Impact, Good Heat Resistance

TYPICAL PROPERTY VALUES

Revision 20180906

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	35	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	32	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	195	%	ASTM D 638
Tensile Modulus, 50 mm/min	1340	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	51	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1550	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	437	J/m	ASTM D 256
Izod Impact, notched, -30°C	149	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	37	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	27	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	138	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	113	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	77	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.1E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.12E-04	1/°C	ASTM E 831
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	0.97	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.8 – 1.2	%	SABIC method
Melt Flow Rate, 260°C/5.0 kgf	10.6	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating	1.52	mm	UL 94
INJECTION MOLDING			
Drying Temperature	60 – 65	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 290	°C	
Nozzle Temperature	260 – 290	°C	
Front - Zone 3 Temperature	250 – 290	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	240 – 280	°C	
Rear - Zone 1 Temperature	225 – 275	°C	
Mold Temperature	30 – 50	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	
Vent Depth	0.038 – 0.051	mm	

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