

# NORYL PPX™ RESIN PPX7112

REGION AMERICAS

## DESCRIPTION

PPE+PP blend. Suitable for painted exterior automotive applications.

## TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	34	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	33	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	120	%	ASTM D 638
Tensile Modulus, 50 mm/min	1170	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	49	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1340	MPa	ASTM D 790
<b>IMPACT</b>			
Izod Impact, notched, 23°C	587	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	37	J	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	85	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	112	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	85	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.55E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-05	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
<b>PHYSICAL</b>			
Specific Gravity	0.99	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.6 – 0.8	%	SABIC method
Melt Flow Rate, 260°C/5.0 kgf	10.5	g/10 min	ASTM D 1238
<b>FLAME CHARACTERISTICS</b>			
UL Recognized, 94HB Flame Class Rating	1.52	mm	UL 94
<b>INJECTION MOLDING</b>			
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	
Middle - Zone 2 Temperature	240 – 280	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	
<b>SHEET EXTRUSION</b>			
Drying Temperature	60 – 65	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	4	hrs	
Melt Temperature	270 – 280	°C	
Barrel - Zone 1 Temperature	145 – 155	°C	
Barrel - Zone 2 Temperature	255 – 265	°C	
Barrel - Zone 3 Temperature	270 – 280	°C	
Barrel - Zone 4 Temperature	270 – 280	°C	
Adapter Temperature	265 – 270	°C	
Die Temperature	265 – 270	°C	

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