

# NORYL PPX<sup>TM</sup> RESIN PPX7115F

REGION AMERICAS

## DESCRIPTION

High modulus/impact/heat PPE+PP

## TYPICAL PROPERTY VALUES

Revision 20181012

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
Tensile Stress, yld, Type I, 50 mm/min	35	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	34	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	125	%	ASTM D 638
Tensile Modulus, 50 mm/min	1240	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	1370	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	35	MPa	ISO 527
Tensile Strain, break, 50 mm/min	75	%	ISO 527
Tensile Modulus, 1 mm/min	1370	MPa	ISO 527
<b>IMPACT</b>			
Izod Impact, notched, 23°C	534	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	37	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	30	J	ASTM D 3763
<b>THERMAL</b>			
Vicat Softening Temp, Rate B/50	86	°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	1.62E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.72E-05	1/°C	ASTM E 831
Vicat Softening Temp, Rate A/50	131	°C	ISO 306
<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	14	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 260°C/5.0 kg	12	cm <sup>3</sup> /10 min	ISO 1133
<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	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	250 – 290	°C	
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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