NORYL PPX™ RESIN PPX630

REGION ASIA

DESCRIPTION

NORYL PPX™ 630 resin is a 30% glass reinforced alloy of polyphenylene ether (PPE) + polypropylene (PP). This injection moldable grade exhibits high elongation and high stiffness along with temperature performance, impact resistance, hydrolytic and dimensional stability. NORYL PPX630 resin is an excellent candidate for hot water system exteriors, condensate housings, and printer internals. *See NORYL PPX630F resin for NSF 61.

TYPICAL PROPERTY VALUES

Revision 20191004

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	79	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	79	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	7.7	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	129	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	5550	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	827	J/m	ASTM D 4812
Izod Impact, notched, 23°C	165	J/m	ASTM D 256
Izod Impact, notched, -30°C	101	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	19	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	20	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	162	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	155	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	133	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.44E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.74E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.19	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.2 – 0.23	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.25 – 0.76	%	SABIC method
Melt Flow Rate, 260°C/5.0 kgf	2.6	g/10 min	ASTM D 1238
INJECTION MOLDING			
Drying Temperature	65 – 75	°C	
Drying Time	2 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	260 – 300	°C	
Nozzle Temperature	260 – 300	°C	
Front - Zone 3 Temperature	255 – 295	°C	
Middle - Zone 2 Temperature	250 – 290	°C	
Rear - Zone 1 Temperature	245 – 290	°C	
Mold Temperature	40 – 65	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	
Vent Depth	0.051 – 0.076	mm	

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