NORYL PPX™ RESIN PPX7110

REGION ASIA

DESCRIPTION

NORYL PPX™ 7110 resin is a non-reinforced alloy of polyphenylene ether (PPE) + Polypropylene (PP). This injection moldable grade exhibits high impact resistance and good heat resistance along with hydrolytic and dimensional stability. NORYL PPX7110 resin is an excellent candidate for applications requiring high impact, chemical resistance, and good heat performance.

TYPICAL PROPERTY VALUES

Revision 20190925

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
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
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	
Middle - Zone 2 Temperature	240 – 280	°C	
Rear - Zone 1 Temperature	225 – 275	°C	
Mold Temperature	30 – 50	°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	0.038 – 0.051	mm	

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