NORYL GTX™ RESIN GTX202

REGION ASIA

DESCRIPTION

NORYL™ GTX202 is a low cost GTX grade especially developed for automotive (wheel)trims.

TYPICAL PROPERTY VALUES

Revision 20191202

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	59	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	56	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	9	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	52	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	89	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2240	MPa	ASTM D 790
Hardness, Rockwell R	118	-	ASTM D 785
Taber Abrasion, CS-17, 1 kg	19	mg/1000cy	ASTM D 1044
IMPACT			
Izod Impact, unnotched, 23°C	3204	J/m	ASTM D 4812
Izod Impact, unnotched, -30°C	3204	J/m	ASTM D 4812
Izod Impact, unnotched, -40°C	3204	J/m	ASTM D 4812
Izod Impact, notched, 23°C	272	J/m	ASTM D 256
Izod Impact, notched, -30°C	117	J/m	ASTM D 256
Izod Impact, notched, -40°C	53	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	46	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	36	J	ASTM D 3763
Instrumented Impact Energy @ peak, -40°C	19	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	232	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	155	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	127	°C	ASTM D 648
CTE, -20°C to 150°C, flow	9.00E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.08	-	ASTM D 792
Water Absorption, 24 hours	0.4	%	ASTM D 570
Water Absorption, equilibrium, 23C	3.6	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.9 – 1.2	%	SABIC method
Mold Shrink, flow, annealed 130C 1hr	1.1 – 1.5	%	ASTM D 955
Mold Shrinkage, xflow, 3.2 mm	0.8 – 1.1	%	SABIC method
INJECTION MOLDING			
Drying Temperature	95 – 105	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	

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Maximum Moisture Content	0.07	%	
Minimum Moisture Content	0.02	%	
Melt Temperature	275 – 300	°C	
Nozzle Temperature	275 – 300	°C	
Front - Zone 3 Temperature	270 – 300	°C	
Middle - Zone 2 Temperature	265 – 300	°C	
Rear - Zone 1 Temperature	260 – 300	°C	
Mold Temperature	65 – 95	°C	
Back Pressure	0.3 – 1.4	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 50	%	
Vent Depth	0.013 – 0.038	mm	

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