NORYL PPX™ PPX7110 resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

Message:

PPE+PP blend. High Impact, Good Heat Resistance

General Information	
UL YellowCard	E121562-221229
Features	Impact resistance, high Heat resistance, high
Processing Method	Sheet extrusion molding Injection molding
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831) Flexural DMA (ASTM D4065) Pressure-Volume-Temperature (PVT - Zoller Method) Shear DMA (ASTM D4065) Specific Heat vs. Temperature (ASTM D3417) Tensile Creep (ASTM D2990) Tensile Stress vs. Strain (ASTM D638) Viscosity vs. Shear Rate (ASTM D3835)

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.968	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.80 - 1.2	%	Internal method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [1]	1340	MPa	ASTM D638
Tensile Strength [2]			ASTM D638
Yield	35.9	MPa	ASTM D638
Fracture	32.4	MPa	ASTM D638
Tensile Elongation [3]			ASTM D638
Yield	6.5	%	ASTM D638
Fracture	200	%	ASTM D638
Flexural Modulus [4] (50.0 mm Span)	1550	MPa	ASTM D790
Flexural Strength [5] (Yield, 50.0 mm Span)	51.7	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-30°C	150	J/m	ASTM D256

23°C	440	J/m	ASTM D256
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	27.8	J	ASTM D3763
23°C, Total Energy	38.0	J	ASTM D3763
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	113	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	77.2	°C	ASTM D648
Vicat Softening Temperature	139	°C	ASTM D1525 [6]
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	8.1E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	1.1E-4	cm/cm/°C	ASTM E831
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Flammability	**Nominal Value**		**Test Method**
Flame Rating (1.52 mm)	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	60.0 - 65.6	°C	
Drying Time	2.0 - 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 - 70	%	
Rear Temperature	227 - 277	°C	
Middle Temperature	238 - 282	°C	
Front Temperature	249 - 288	°C	
Nozzle Temperature	260 - 288	°C	
Processing (Melt) Temp	260 - 288	°C	
Mold Temperature	32.2 - 48.9	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.038 - 0.051	mm	
Extrusion	**Nominal Value**	**Unit**	
Drying Temperature	60.0 - 65.6	°C	
Drying Time	2.0 - 4.0	hr	
Cylinder Zone 1 Temp.	143 - 154	°C	
Cylinder Zone 2 Temp.	254 - 266	°C	
Cylinder Zone 3 Temp.	271 - 282	°C	
Cylinder Zone 4 Temp.	271 - 282	°C	
Adapter Temperature	263 - 268	°C	
Melt Temperature	271 - 279	°C	
Die Temperature	263 - 268	°C	

Extrusion instructions	
Drying Time (Cumulative): 4 hrs	
NOTE	
1.	50 mm/min
2.	Type 1, 50mm/min
3.	Type 1, 50mm/min
4.	1.3 mm/min
5.	1.3 mm/min
6.	标准 B (120°C/h), 载荷2 (50N)

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