

NORYL GTX™ APS130 resin

Polyphenylene Sulfide + PPE

SABIC Innovative Plastics Asia Pacific

Message:

PPE+PPS GF30%

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/5.0 kg)	29	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.25 to 0.70	%	Internal Method
Water Absorption (24 hr)	0.020	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	113	MPa	Internal Method
Tensile Elongation (Break)	8.0	%	Internal Method
Flexural Modulus	8430	MPa	ASTM D790
Flexural Strength	157	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	88	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm)	267	°C	ASTM D648
CLTE - Flow (-30 to 30°C)	2.5E-5 to 5.5E-5	cm/cm/°C	ASTM E831
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+16	ohms	ASTM D257
Dielectric Strength (1.60 mm, in Oil)	22	kV/mm	ASTM D149
Dielectric Constant			ASTM D150
50 Hz	3.30		
60 Hz	3.30		
Injection	Nominal Value	Unit	
Drying Temperature	121 to 149	°C	
Drying Time	4.0 to 8.0	hr	
Drying Time, Maximum	24	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	282 to 316	°C	
Middle Temperature	288 to 321	°C	
Front Temperature	293 to 327	°C	

Nozzle Temperature	299 to 332	°C
Processing (Melt) Temp	299 to 332	°C
Mold Temperature	93.3 to 149	°C
Back Pressure	0.689 to 1.38	MPa
Screw Speed	50 to 100	rpm
Vent Depth	0.025 to 0.076	mm

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