

NORYL™ PPX640 resin

Polyphenylene Ether + PS + PP

SABIC Innovative Plastics

Message:

40% GR PPE+PP. High elongation. high stiffness.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Features	Rigidity, high		
	Extended tensile rate		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	1.3	g/10 min	ASTM D1238
Molding Shrinkage			Internal method
Flow: 3.20mm	0.17 - 0.18	%	Internal method
Transverse flow: 3.20mm	0.27 - 0.61	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	95.8	MPa	ASTM D638
Fracture	95.8	MPa	ASTM D638
Tensile Elongation ² (Break)	6.4	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	8320	MPa	ASTM D790
Flexural Strength ⁴ (Break, 50.0 mm Span)	151	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C	96	J/m	ASTM D256
23°C	110	J/m	ASTM D256
Unnotched Izod Impact (23°C)	580	J/m	ASTM D4812
Instrumented Dart Impact			ASTM D3763
-30°C, Total Energy	14.1	J	ASTM D3763
23°C, Total Energy	16.8	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	159	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	146	°C	ASTM D648
Vicat Softening Temperature	163	°C	ASTM D1525 ⁵
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	1.1E-5	cm/cm/°C	ASTM E831

Lateral: -40 to 40°C	6.3E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
Drying Temperature	66 - 77	°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	243 - 288	°C	
Middle Temperature	249 - 288	°C	
Front Temperature	254 - 299	°C	
Nozzle Temperature	260 - 304	°C	
Processing (Melt) Temp	260 - 304	°C	
Mold Temperature	38 - 66	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	20 - 100	rpm	
Vent Depth	0.051 - 0.076	mm	
NOTE			
1.	Type 1, 5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	标准 B (120°C/h), 载荷2 (50N)		

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