



NORYL PPX™ Resin PPX7200
Americas: COMMERCIAL

PP+PPE+PS. Improved chemical resistance and surface aesthetics in injection molded applications. NSF61-capable. UL-94 HB listed.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	340	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	280	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	10	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	130	%	ASTM D 638
Tensile Modulus, 50 mm/min	12600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	490	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	14700	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	34	MPa	ISO 527
Tensile Stress, break, 50 mm/min	28	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	8.2	%	ISO 527
Tensile Strain, break, 50 mm/min	115	%	ISO 527
Tensile Modulus, 1 mm/min	1670	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	48	MPa	ISO 178
Flexural Modulus, 2 mm/min	1600	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	147	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	15	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	0	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	368	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1A



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IMPACT			
Izod Impact, notched 80*10*4 -30°C	8	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	12	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	6	kJ/m ²	ISO 179/1eA
Charpy 23°C, Unnotch Edgew 80*10*4 sp=62mm	NB	kJ/m ²	ISO 179/1eU
Charpy -30°C, Unnotch Edgew 80*10*4 sp=62mm	80	kJ/m ²	ISO 179/1eU
THERMAL			
Vicat Softening Temp, Rate B/50	146	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	110	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	71	°C	ASTM D 648
CTE, -40°C to 40°C, flow	9.9E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.08E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	9.9E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	1.08E-04	1/°C	ISO 11359-2
Ball Pressure Test, 75°C +/- 2°C	-	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	103	°C	ISO 306
Vicat Softening Temp, Rate B/120	107	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	73	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	0.99	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	16	g/10 min	ASTM D 1238
Density	0.99	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.05	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.02	%	ISO 62



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PHYSICAL Melt Volume Rate, MVR at 260°C/5.0 kg	18	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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
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