+135-3858-6433 (GuangDong)
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NORYL GTX™ Resin GTX626

Americas: COMMERCIAL

Blowmolding and extrusion. High heat and chemical resistant.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	630	kgf/cm²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	83	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	970	kgf/cm²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	23200	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	34	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	12	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	317	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -30	373	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	179	°C	ASTM D 648
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.09	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	1.3 - 1.4	%	SABIC Method
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

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• Dry for recommended time and temperature as overdrying can cause loss of physical properties and/or create appearance defects.

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Extrusion Blow Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Drying Time (Cumulative)	16	hrs
Melt Temperature (Parison)	275 - 290	°C
Barrel - Zone 1 Temperature	270 - 280	°C
Barrel - Zone 2 Temperature	270 - 280	°C
Barrel - Zone 3 Temperature	270 - 280	°C
Barrel - Zone 4 Temperature	270 - 280	°C
Adapter - Zone 5 Temperature	275 - 290	°C
Head - Zone 6 - Top Temperature	275 - 290	°C
Head - Zone 7 - Bottom Temperature	275 - 290	°C
Mold Temperature	80	°C
Die Temperature	275 - 290	°C

• As screw speed is increased, shear heating increases; reducing barrel temperatures helps keep melt temperature under control.
• Processing temperature must be measured with a hand-held probe as opposed to an internal-head probe.
• A reverse barrel profile may increase output while maintaining the melt temperature.