+135-3858-6433 (GuangDong)
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+852-6957-5415 (HongKong)

NORYL GTX™ Resin GTX910

Americas: COMMERCIAL

Unfilled grade for automotive on-line painted components. Dimensional stability. Excellent chemical resistance. Class A surface appearance.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	600	kgf/cm²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	560	kgf/cm²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	60	%	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	22900	kgf/cm²	ASTM D 790
Hardness, Rockwell R	116	-	ASTM D 785
IMPACT			
Izod Impact, notched, 23°C	24	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	13	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	518	cm-kgf	ASTM D 3763
Instrumented Impact Energy @ peak, -30	403	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	232	°C	ASTM D 1525
HDT, 0.45 MPa, 6.4 mm, unannealed	193	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	143	°C	ASTM D 648
CTE, -40°C to 95°C, flow	9.E-05	1/°C	ASTM E 831
CTE, -40°C to 95°C, xflow	9.E-05	1/°C	ASTM E 831
CTE, 60°C to 138°C, flow	1.26E-04	1/°C	ASTM E 831
CTE, 60°C to 138°C, xflow	1.26E-04	1/°C	ASTM E 831
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	1.1	-	ASTM D 792

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Density	1.107	g/cm³	ASTM D 792
Water Absorption, 50% RH, equilib	1	%	ASTM D 570
Moisture Absorption, 50% RH, 24 hrs	0.5	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	1.1 - 1.3	%	SABIC Method
Mold Shrink, flow, annealed 130C 1hr (5)	1.6 - 1.8	%	ASTM D 955
Mold Shrinkage, xflow, 3.2 mm (5)	1 - 1.2	%	SABIC Method
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	3	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	1	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

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• Do NOT mix NORYL GTX* resin with other grades of NORYL* resins.

PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.07	%
Minimum Moisture Content	0.02	%
Melt Temperature	280 - 305	°C
Nozzle Temperature	280 - 305	°C
Front - Zone 3 Temperature	275 - 305	°C
Middle - Zone 2 Temperature	270 - 305	°C
Rear - Zone 1 Temperature	265 - 305	°C
Mold Temperature	75 - 120	°C
Back Pressure	0.3 - 1.4	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 50	%
Vent Depth	0.013 - 0.038	mm