



NORYL PPX™ Resin PPX7110
Americas: COMMERCIAL

PPE+PP blend. High Impact, Good Heat Resistance

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	360	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	330	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6.5	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	195	%	ASTM D 638
Tensile Modulus, 50 mm/min	13700	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	520	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	15800	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	44	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	15	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	387	cm-kgf	ASTM D 3763
Instrumented Impact Total Energy, -30°C	283	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	138	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	113	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	77	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.1E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.12E-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	0.97	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.8 - 1.2	%	SABIC Method



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PHYSICAL			
Melt Flow Rate, 260°C/5.0 kgf	10.6	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.52	mm	UL 94



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- No drying is required if extruder is vented. Melt temperature is measurement of the melt exiting the die.

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
Sheet Extrusion		
Drying Temperature	60 - 65	°C
Drying Time	2 - 4	hrs
Drying Time (Cumulative)	4	hrs
Melt Temperature	270 - 280	°C
Barrel - Zone 1 Temperature	145 - 155	°C
Barrel - Zone 2 Temperature	255 - 265	°C
Barrel - Zone 3 Temperature	270 - 280	°C
Barrel - Zone 4 Temperature	270 - 280	°C
Adapter Temperature	265 - 270	°C
Die Temperature	265 - 270	°C

- Melt temperatures below 270°C (520°F) may result in slight surface texture on thermoformed parts.
- It is recommended that sheet be cured 24 hrs prior to thermoforming.