



Noryl PPX* Resin PPX7115

Americas: COMMERCIAL

High modulus/impact/heat PPE+PP. NSF Standard 61 Compliant (color limited).

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	35	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	34	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	125	%	ASTM D 638
Tensile Modulus, 50 mm/min	1240	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	51	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	1370	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	534	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	37	J	ASTM D 3763
Instrumented Impact Total Energy, -30°C	44	J	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	86	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	112	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	85	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.62E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.72E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	0.99	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.7	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	14	g/10 min	ASTM D 1238



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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