+135-3858-6433 (GuangDong)
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NORYL GTX™ Resin APS130
Asia Pacific: COMMERCIAL

PPE+PPS GF30%

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1150	kgf/cm²	SABIC - Japan Method
Tensile Strain, break	8 - 8	%	SABIC - Japan Method
Flexural Stress	1590	kgf/cm²	ASTM D 790
Flexural Modulus	85900	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	267	°C	ASTM D 648
CTE, -30°C to 30°C	2.5E-05 - 5.5E-05	1/°C	TMA
PHYSICAL			
Specific Gravity	1.44	-	ASTM D 792
Water Absorption, 24 hours	0.02	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm (5)	0.25 - 0.7	%	SABIC Method
Melt Flow Rate, 300°C/5.0 kgf	29.1	g/10 min	ASTM D 1238
ELECTRICAL			
Surface Resistivity	1.E+16	Ohm	ASTM D 257
Dielectric Strength, in oil, 1.6 mm	22.1	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	3.3	-	ASTM D 150

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4 - 8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 330	°C
Nozzle Temperature	300 - 330	°C
Front - Zone 3 Temperature	295 - 325	°C
Middle - Zone 2 Temperature	290 - 320	°C
Rear - Zone 1 Temperature	280 - 315	°C
Mold Temperature	95 - 150	°C
Back Pressure	0.7 - 1.4	MPa
Screw Speed	50 - 100	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm