

Noryl GTX* Resin GTX8408

Americas: COMMERCIAL

Noryl GTX* GTX8408 Resin is a blend of Polyphenylene Ether(PPE) + Polyamide(PA) resin that is glass filled and suitable for injection molding. The elongation of this material is higher than GTX8410W. The glass content enables the material to be used in structural applications and electrical connectors.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	84	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	80	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4.3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	10.2	%	ASTM D 638
Tensile Modulus, 5 mm/min	3560	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	92	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3320	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	87	MPa	ISO 527
Tensile Stress, break, 5 mm/min	82	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4.5	%	ISO 527
Tensile Strain, break, 5 mm/min	10	%	ISO 527
Tensile Modulus, 1 mm/min	4000	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	133	MPa	ISO 178
Flexural Modulus, 2 mm/min	3520	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	82	J/m	ASTM D 256
Izod Impact, notched, -30°C	45	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	4	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	7	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	3	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	8	kJ/m ²	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	224	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	239	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.83E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.46E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	6.83E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.46E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	224	°C	ISO 306
Vicat Softening Temp, Rate B/120	224	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	240	°C	ISO 75/Bf
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.15	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.8	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	26.3	g/10 min	ASTM D 1238
Density	1.15	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62

Moisture Absorption (23°C / 50% RH)	0.35	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	22	cm ³ /10 min	ISO 1133

Source GMD, last updated:09/05/2007

Processing

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

Parameter	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

Source GMD, last updated:09/05/2007

- Polystyrene and acrylic regrind are effective purging Materials. Use temperature range appropriate for particular purging resin.
- Regrind must also be dried. Maximum 25% regrind.
- Dry at recommended temperatures and times for optimum performance. Overdrying can cause loss of physical properties and/or create appearance defects. Do not exceed recommended basic drying time and temperature above or:
 - 4-8 hrs at 95°C (200°F), 10 hrs max
 - 6-12 hrs at 80°C (175°F), 16 hrs max
 - 8-16 hrs at 65°C (150°F), 24 hrs max
- Avoid melt temperature in excess of 300°C (575°F) and residence times over 6-8 minutes (may affect properties and/or appearance).
- Nozzle temperature controls assist in elimination of drool premature freeze-off.
- Shot sizes in excess of 50% barrel capacity can lead to difficulties in providing a consistent, homogenous plastic melt.

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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