# NORYL GTX™ RESIN GTX985

REGION AMERICAS

## DESCRIPTION

NORYL GTX985 resin is a conductive, 18% mineral reinforced alloy of Polyphenylene Ether (PPE) + Polyamide (PA). This injection moldable grade combines high stiffness, excellent chemical resistance, and high heat resistance. NORYL GTX985 is conductive for primerless electrostatic painting and is an excellent candidate for automotive exterior trim applications.

| GENERAL INFORMATION | |
|---|---|
| **Features** | Chemical Resistance, Electrically Conductive, Hydrolytic Stability, Low Warpage, Low Shrinkage, Low Moisture Absorption, Low Specific Gravity, Aesthetics/Visual effects, Dimensional stability, High stiffness/Strength, High temperature resistance, Impact resistant, No PFAS intentionally added |
| **Fillers** | Mineral, Conductive agent |
| **Polymer Types** | Polyphenylene Ether + PA (PPE+Nylon) |
| **Processing Techniques** | Injection Molding |

| INDUSTRY | SUB INDUSTRY |
|---|---|
| Automotive | Automotive Exteriors |

## TYPICAL PROPERTY VALUES

Revision 20231109

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---|---|---|---|
| MECHANICAL [1] | | | |
| **Tensile Stress, yld, Type I, 5 mm/min** | 65 | MPa | ASTM D638 |
| **Tensile Stress, brk, Type I, 5 mm/min** | 60 | MPa | ASTM D638 |
| **Tensile Strain, yld, Type I, 5 mm/min** | 4 | % | ASTM D638 |
| **Tensile Strain, brk, Type I, 5 mm/min** | 7 | % | ASTM D638 |
| **Flexural Stress, yld, 1.3 mm/min, 50 mm span** | 110 | MPa | ASTM D790 |
| **Flexural Modulus, 1.3 mm/min, 50 mm span** | 4200 | MPa | ASTM D790 |
| **Tensile Stress, yield, 5 mm/min** | 65 | MPa | ISO 527 |
| **Tensile Stress, break, 5 mm/min** | 60 | MPa | ISO 527 |
| **Tensile Strain, yield, 5 mm/min** | 4 | % | ISO 527 |
| **Tensile Strain, break, 5 mm/min** | 7 | % | ISO 527 |
| **Tensile Modulus, 1 mm/min** | 4400 | MPa | ISO 527 |
| **Flexural Stress, yield, 2 mm/min** | 105 | MPa | ISO 178 |
| **Flexural Modulus, 2 mm/min** | 4350 | MPa | ISO 178 |
| IMPACT [1] | | | |
| **Izod Impact, notched, 23°C** | 45 | J/m | ASTM D256 |
| **Izod Impact, notched, -30°C** | 40 | J/m | ASTM D256 |
| **Instrumented Dart Impact Total Energy, 23°C** | 10 | J | ASTM D3763 |
| **Izod Impact, unnotched 80*10*3 +23°C** | 60 | kJ/m² | ISO 180/1U |
| **Izod Impact, unnotched 80*10*3 -30°C** | 55 | kJ/m² | ISO 180/1U |
| **Izod Impact, notched 80*10*4 +23°C** | 4 | kJ/m² | ISO 180/1A |
| **Izod Impact, notched 80*10*4 -30°C** | 4 | kJ/m² | ISO 180/1A |

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---|---|---|---|
| Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm | 4 | kJ/m² | ISO 179/1eA |
| THERMAL [1] | | | |
| Vicat Softening Temp, Rate B/50 | 195 | °C | ASTM D1525 |
| HDT, 0.45 MPa, 3.2 mm, unannealed | 200 | °C | ASTM D648 |
| CTE, 23°C to 60°C, flow | 6.E-05 | 1/°C | ISO 11359-2 |
| CTE, 23°C to 60°C, xflow | 6.5E-05 | 1/°C | ISO 11359-2 |
| Vicat Softening Temp, Rate B/50 | 195 | °C | ISO 306 |
| Vicat Softening Temp, Rate B/120 | 200 | °C | ISO 306 |
| HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm | 205 | °C | ISO 75/Bf |
| PHYSICAL [1] | | | |
| Mold Shrinkage, flow, 3.2 mm [2] | 0.8 – 1.2 | % | SABIC method |
| Mold Shrinkage, xflow, 3.2 mm [2] | 0.8 – 1.2 | % | SABIC method |
| Specific Gravity | 1.25 | - | ASTM D792 |
| Melt Flow Rate, 280°C/5.0 kgf | 16 | g/10 min | ASTM D1238 |
| Density | 1.25 | g/cm³ | ISO 1183 |
| Moisture Absorption (23°C / 50% RH) | 1.1 | % | ISO 62 |
| Melt Volume Rate, MVR at 280°C/5.0 kg | 15 | cm³/10 min | ISO 1133 |
| INJECTION MOLDING [3] | | | |
| Drying Temperature | 100 – 110 | °C | |
| Drying Time | 2 – 3 | Hrs | |
| Maximum Moisture Content | 0.02 | % | |
| Melt Temperature | 280 – 300 | °C | |
| Nozzle Temperature | 270 – 290 | °C | |
| Front - Zone 3 Temperature | 280 – 300 | °C | |
| Middle - Zone 2 Temperature | 270 – 290 | °C | |
| Rear - Zone 1 Temperature | 260 – 280 | °C | |
| Hopper Temperature | 80 – 100 | °C | |
| Mold Temperature | 100 – 120 | °C | |

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

## ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

## DISCLAIMER