

## Noryl GTX\* Resin GTX6203

Americas: COMMERCIAL

NORYL GTX6203 is a 20% talc filled material with superior dimensional stability, excellent processability and surface appearance.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 5 mm/min	65	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	65	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3	%	ASTM D 638
Tensile Modulus, 5 mm/min	4600	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	100	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	3800	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	60	MPa	ISO 527
Tensile Stress, break, 50 mm/min	60	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	2.5	%	ISO 527
Tensile Strain, break, 5 mm/min	10	%	ISO 527
Tensile Strain, break, 50 mm/min	10	%	ISO 527
Tensile Modulus, 1 mm/min	4900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	4000	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	60	J/m	ASTM D 256
Izod Impact, notched, -30°C	50	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	10	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	50	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m <sup>2</sup>	ISO 179/1eA
THERMAL	Value	Unit	Standard
Vicat Softening Temp, Rate B/50	185	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	190	°C	ASTM D 648
CTE, -40°C to 40°C, flow	6.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.8E-05	1/°C	ASTM E 831
Thermal Conductivity	0.26	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	7.5E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	9.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	190	°C	ISO 306
Vicat Softening Temp, Rate B/120	190	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	190	°C	ISO 75/Be
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.25	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.6 - 0.9	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm	0.6 - 0.9	%	SABIC Method

Melt Flow Rate, 280°C/5.0 kgf	20	g/10 min	ASTM D 1238
Density	1.24	g/cm <sup>3</sup>	ISO 1183
Water Absorption, (23°C/sat)	3.2	%	ISO 62
Moisture Absorption (23°C / 50% RH)	1.1	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	20	cm <sup>3</sup> /10 min	ISO 1133

Source GMD, last updated:06/25/2007

## Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	100 - 110	°C
Drying Time	2 - 3	hrs
Maximum Moisture Content	0.07	%
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	60 - 80	°C
Mold Temperature	80 - 100	°C

Source GMD, last updated:06/25/2007

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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