



NORYL GTX™ Resin GTX985

Americas: COMMERCIAL

NORYL GTX985 is a 18% mineral filled material. This material combines high stiffness and excellent temperature resistance with conductivity for electrostatic painting.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Modulus, 5 mm/min	600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1120	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	42800	kgf/cm ²	ASTM D 790
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			
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	4	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	101	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	60	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	55	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	4	kJ/m ²	ISO 180/1A



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IMPACT			
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	4	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	195	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	200	°C	ASTM D 648
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			
Specific Gravity	1.25	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	1.1	%	SABIC Method
Melt Flow Rate, 280°C/5.0 kgf	16	g/10 min	ASTM D 1238
Density	1.25	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	1.1	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	15	cm ³ /10 min	ISO 1133



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	100 - 110	°C
Drying Time	2 - 3	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	300 - 320	°C
Nozzle Temperature	280 - 300	°C
Front - Zone 3 Temperature	300 - 320	°C
Middle - Zone 2 Temperature	280 - 300	°C
Rear - Zone 1 Temperature	260 - 280	°C
Hopper Temperature	80 - 100	°C
Mold Temperature	100 - 120	°C