



NORYL GTX™ Resin GTX918W

Americas: COMMERCIAL

High flow NORYL GTX resin for under-the-hood and electrical applications requiring retention of properties under thermal load

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	630	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	53	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1000	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	24100	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	20	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	414	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	188	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	148	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.09	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	1.3 - 1.6	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	1 - 1.3	%	SABIC Method



NORYL GTX™ Resin GTX918W

Americas: COMMERCIAL

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

PROCESSING PARAMETERS	TYPICAL 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	270 - 295	°C
Nozzle Temperature	270 - 295	°C
Front - Zone 3 Temperature	265 - 295	°C
Middle - Zone 2 Temperature	260 - 295	°C
Rear - Zone 1 Temperature	255 - 295	°C
Mold Temperature	65 - 95	°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