



NORYL GTX™ Resin GTX673

Americas: COMMERCIAL

Conductive NORYL GTX resin designed for profile extrusion. This grade can be electrostatic or powder coat painted without the need for a primer. In addition, its high heat capability allows it to be painted on the same line as metal.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	660	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	640	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	3.8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	6.1	%	ASTM D 638
Tensile Modulus, 5 mm/min	24600	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1010	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25600	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 50 mm/min	66	MPa	ISO 527
Tensile Stress, break, 50 mm/min	64	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	4	%	ISO 527
Tensile Strain, break, 50 mm/min	7.1	%	ISO 527
Tensile Modulus, 1 mm/min	2670	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	103	MPa	ISO 178
Flexural Modulus, 2 mm/min	2470	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	5	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	50	cm-kgf	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	10	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	6	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	12	kJ/m ²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	197	°C	ASTM D 1525



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THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	187	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.8E-05	1/°C	ASTM E 831
CTE, 23°C to 60°C, flow	8.1E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.6E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Pass	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	197	°C	ISO 306
Vicat Softening Temp, Rate B/120	198	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	184	°C	ISO 75/Bf
PHYSICAL			
Specific Gravity	1.1	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	1.3 - 1.5	%	SABIC Method
Melt Flow Rate, 300°C/5.0 kgf	7.8	g/10 min	ASTM D 1238
Density	1.1	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	4	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.4	%	ISO 62
Melt Volume Rate, MVR at 300°C/5.0 kg	7	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+03 - 1.E+04	Ohm-cm	SABIC Method



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Profile Extrusion		
Drying Temperature	105 - 110	°C
Drying Time	8	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.03	%
Melt Temperature	245 - 260	°C
Barrel - Zone 1 Temperature	245 - 260	°C
Barrel - Zone 2 Temperature	245 - 260	°C
Barrel - Zone 3 Temperature	245 - 260	°C
Barrel - Zone 4 Temperature	245 - 260	°C
Adapter Temperature	245 - 260	°C
Die Temperature	245 - 260	°C
Calibrator Temperature	35 - 75	°C
Water Bath Temperature	40 - 50	°C