

NORYL™ RESIN ZM3640

REGION ASIA

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	60	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4	%	ASTM D 638
Flexural Stress, yield, 6.4 mm	102	MPa	ASTM D 790
Flexural Modulus, 6.4 mm	4620	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	35	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	103	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.8E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Melt Flow Rate, 300°C/2.16 kgf	24	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating	1.5	mm	UL 94
INJECTION MOLDING			
Drying Temperature	90 – 95	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	255 – 280	°C	
Nozzle Temperature	255 – 280	°C	
Front - Zone 3 Temperature	245 – 280	°C	
Middle - Zone 2 Temperature	230 – 275	°C	
Rear - Zone 1 Temperature	220 – 270	°C	
Mold Temperature	65 – 90	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	
Vent Depth	0.038 – 0.051	mm	

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