

NORYL™ RESIN EM7301F

REGION AMERICAS

DESCRIPTION

10% glass-reinforced. HDT 252F. Good flow and polyurethane foam adhesion. Black only.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	68	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	5	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	96	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	3640	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	69	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	122	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.12	-	ASTM D 792
INJECTION MOLDING			
Drying Temperature	100 – 105	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	270 – 300	°C	
Nozzle Temperature	270 – 300	°C	
Front - Zone 3 Temperature	260 – 300	°C	
Middle - Zone 2 Temperature	250 – 295	°C	
Rear - Zone 1 Temperature	240 – 290	°C	
Mold Temperature	65 – 95	°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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