

NORYL™ RESIN EM6101

REGION AMERICAS

DESCRIPTION

Automotive interiors. Improved flow characteristics/overall processing economy. 250F DTUL. Good property retention/wide temperature range.

TYPICAL PROPERTY VALUES

Revision 20180905

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	53	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	50	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	81	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2300	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	320	J/m	ASTM D 256
Izod Impact, notched, -40°C	160	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	53	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	25	J	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 6.4 mm, unannealed	123	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
CTE, 0°C to 100°C, flow	9.36E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.05	-	ASTM D 792
Water Absorption, 24 hours	0.2	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
INJECTION MOLDING			
Drying Temperature	95 – 105	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	265 – 295	°C	
Nozzle Temperature	265 – 295	°C	
Front - Zone 3 Temperature	255 – 295	°C	
Middle - Zone 2 Temperature	245 – 290	°C	
Rear - Zone 1 Temperature	230 – 280	°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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