NORYL™ RESIN 7310F

REGION ASIA

DESCRIPTION

NORYL™ 7310F resin is a non-reinforced blend of polyphenylene ether (PPE) + high impact polystyrene (HIPS). This FDA Food Contact compliant, injection moldable grade exhibits good surface appearance, high ductility, and good impact resistance along with low moisture absorption, creep resistance, dimensional stability, and hydrolytic stability.

TYPICAL PROPERTY VALUES

Revision 20191126

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	54	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	45	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	30	%	ASTM D 638
Tensile Modulus, 5 mm/min	2400	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	75	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2100	MPa	ASTM D 790
Tensile Stress, yield, 50 mm/min	40	MPa	ISO 527
Tensile Stress, break, 50 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	70	%	ISO 527
Tensile Strain, break, 50 mm/min	70	%	ISO 527
Tensile Modulus, 1 mm/min	2100	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	800	J/m	ASTM D 4812
Izod Impact, notched, 23°C	150	J/m	ASTM D 256
Izod Impact, notched, -30°C	120	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	55	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	60	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	55	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	16	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	11	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	13	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	133	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	110	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	124	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.3E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	133	°C	ISO 306

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	112	°C	ISO 75/Af
Relative Temp Index, Elec [1]	105	°C	UL 746B
Relative Temp Index, Mech w/impact [1]	90	°C	UL 746B
Relative Temp Index, Mech w/o impact [1]	105	°C	UL 746B
PHYSICAL			
Specific Gravity	1.08	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 280°C/5.0 kgf	11	g/10 min	ASTM D 1238
Water Absorption, 23°C/24hrs	0.13	%	ISO 62-1
Moisture Absorption, 50% RH, Equilibrium	0.04	%	ISO 62-4
Melt Volume Rate, MVR at 280°C/5.0 kg	12	cm³/10 min	ISO 1133
ELECTRICAL			
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
High Amp Arc Ignition (HAI), PLC 3	≥1.5	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 1	≥1.5	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E207780-228539	-	-
UL Yellow Card Link 2	E45587-237006	-	-
UL Recognized, 94HB Flame Class Rating	≥1.5	mm	UL 94
INJECTION MOLDING			
Drying Temperature	105 – 110	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	8	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 310	°C	
Nozzle Temperature	280 – 310	°C	
Front - Zone 3 Temperature	270 – 310	°C	
Middle - Zone 2 Temperature	260 – 305	°C	
Rear - Zone 1 Temperature	250 – 300	°C	
Mold Temperature	75 – 105	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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