NORYL™ RESIN 731F

REGION ASIA

DESCRIPTION

NORYL™ 731F resin is a non-reinforced blend of polyphenylene ether (PPE) + high impact polystyrene (HIPS). This NSF/ANSI 61* listed for potable water use, 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. NORYL 731F resin is an excellent candidate for a variety of water management applications such as valves, filtration components, and water meter internals.

TYPICAL PROPERTY VALUES

Revision 20191004

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	58	MPa	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	49	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	7.2	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	28.1	%	ASTM D 638
Tensile Modulus, 50 mm/min	2860	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	89	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2640	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2420	MPa	ASTM D 790
Hardness, Rockwell R	119	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	57	MPa	ISO 527
Tensile Stress, break, 50 mm/min	51	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.5	%	ISO 527
Tensile Strain, break, 50 mm/min	17	%	ISO 527
Tensile Modulus, 1 mm/min	2700	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	95	MPa	ISO 178
Flexural Modulus, 2 mm/min	2550	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	213	J/m	ASTM D 256
Izod Impact, notched, -40°C	133	J/m	ASTM D 256
Gardner, -30°C	25	J	ASTM D 3029
Gardner, -40°C	5	J	ASTM D 3029
Instrumented Impact Total Energy, 23°C	48	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	17	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	17	kJ/m²	ISO 179/1eA
THERMAL			
Vicat Softening Temp, Rate B/50	148	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	131	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	117	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D 648

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, flow	9.18E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	9.54E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	9.18E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	9.54E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	140	°C	ISO 306
Vicat Softening Temp, Rate B/120	143	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	120	°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	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 280°C/5.0 kgf	9.2	g/10 min	ASTM D 1238
Density	1.06	g/cm³	ISO 1183
Water Absorption, (23°C/sat)	0.23	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	9	cm³/10 min	ISO 1133
ELECTRICAL			
Dielectric Strength, in oil, 3.2 mm	21.6	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.65	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0004	-	ASTM D 150
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
Oxygen Index (LOI)	22	%	ASTM D 2863
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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