NORYL™ RESIN EM7304F

REGION ASIA

DESCRIPTION

NORYL™ EM7304F resin is a 15% glass reinforced blend of polyphenylene ether (PPE) + high impact polystyrene (HIPS). This injection moldable grade has enhanced polyurethane foam adhesion and high flow along with creep resistance, dimensional stability, and hydrolytic stability. NORYL EM7304F resin is an excellent candidate for automotive interior applications such as instrument panel retainers.

TYPICAL PROPERTY VALUES

Revision 20191015

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	77	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	108	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	4550	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	64	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	123	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.15	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm	0.2 – 0.3	%	SABIC method
Mold Shrinkage, xflow, 3.2 mm	0.25 – 0.45	%	SABIC method
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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