

Noryl* Resin EM7304F

Americas: COMMERCIAL

15% glass reinforced, high flow with enhanced polyurethane foam adhesion for instrument panel retainers.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
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	Value	Unit	Standard
Izod Impact, notched, 23°C	64	J/m	ASTM D 256
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 6.4 mm, unannealed	123	°C	ASTM D 648
PHYSICAL	Value	Unit	Standard
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

Source GMD, last updated:12/29/1999

Processing

Parameter	Value	Unit
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

Source GMD, last updated:12/29/1999

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.

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