

# NORYL™ RESIN EM7304F

REGION AMERICAS

## DESCRIPTION

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

## TYPICAL PROPERTY VALUES

Revision 20180906

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL</b>			
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
<b>IMPACT</b>			
Izod Impact, notched, 23°C	64	J/m	ASTM D 256
<b>THERMAL</b>			
HDT, 1.82 MPa, 6.4 mm, unannealed	123	°C	ASTM D 648
<b>PHYSICAL</b>			
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
<b>INJECTION MOLDING</b>			
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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