

**NORYL® EM6100***Americas: COMMERCIAL*

PPE+PS blend. Unfilled. Good balance of flow/heat/impact. Dimensional stability. Paint adhesion. Suitable for the automotive interior market: HVAC housings, radio components. MS-DB424, WSB-M4D844-A9, GMP.PPE.007.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, break	40	MPa	ASTM D 638
Tensile Stress, yld, Type I, 50 mm/min	43	MPa	ASTM D 638
Tensile Strain, yield	3	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	65	%	ASTM D 638
Tensile Modulus, 5 mm/min	1900	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	67	MPa	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	66	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2100	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2000	MPa	ASTM D 790
Tensile Stress, yield	42	MPa	ISO 527
Tensile Stress, break	40	MPa	ISO 527
Tensile Strain, yield	2.8	%	ISO 527
Tensile Strain, break	60	%	ISO 527
Tensile Modulus, 1 mm/min	2050	MPa	ISO 527
Flexural Stress	65	MPa	ISO 178
Flexural Modulus	2100	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	454	J/m	ASTM D 256
Izod Impact, notched, -30°C	250	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	37	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	24	J	ASTM D 3763
Instrumented Impact Total Energy, 23°C	42	J	ASTM D 3763
Izod Impact, notched 80*10*4 +23°C	33	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	15	kJ/m ²	ISO 180/1A
Charpy Impact, notched, 23°C	33	kJ/m ²	ISO 179/2C
Charpy Impact, notched, -30°C	19	kJ/m ²	ISO 179/2C
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	124	°C	ASTM D 648
HDT, 1.84 MPa, 3.2mm, unannealed	106	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	115	°C	ASTM D 648

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CTE, 0°C to 100°C, flow	1.17E-04	1/°C	ASTM E 831
Vicat Softening Temp, Rate B/50	119	°C	ISO 306
Vicat Softening Temp, Rate B/120	123	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	126	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	110	°C	ISO 75/Af
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.05	-	ASTM D 792
Water Absorption, 24 hours	0.2	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	GE Method
Melt Flow Rate, 280°C/5.0 kgf	15	g/10 min	ASTM D 1238
Melt Volume Rate, MVR at 280°C/5.0 kg	15	cm ³ /10 min	ISO 1133
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	95 - 105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	265 - 295	°C
Nozzle Temperature	265 - 295	°C
Front - Zone 3 Temperature	255 - 295	°C
Middle - Zone 2 Temperature	245 - 290	°C
Rear - Zone 1 Temperature	230 - 280	°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