



NORYL® EM7301F

Americas: **COMMERCIAL**

Modified PPO® Alloy

10% glass-reinforced. HDT 252F. Good flow and polyurethane foam adhesion. Black only.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Str, brk, Type I, 5 mm/min	69	MPa	ASTM D 638
Tensile Elong, brk, Type I, 5 mm/min	5	%	ASTM D 638
Flex Stress, yld, 2.6 mm/min, 100 mm span	97	MPa	ASTM D 790
Flex Mod, 2.6 mm/min, 100 mm span	3650	MPa	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	69	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	122	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.12	-	ASTM D 792



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PROCESSING PARAMETERS	TYPICAL 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