NORYL™ RESIN 7310

REGION ASIA

DESCRIPTION

NORYL 7310 resin is a non-reinforced blend of polyphenylene ether (PPE) + polystyrene (PS). This injection moldable grade exhibits good surface appearance, high ductility, and good impact resistance along with low moisture absorption, creep resistance, dimensional stability, and hydrolytic stability. NORYL 7310 resin is an excellent candidate for a variety of applications.

GENERAL INFORMATION	
Features	Hydrolytic Stability, Low Warpage, Amorphous, Low Shrinkage, Low Moisture Absorption, Low Specific Gravity, Dimensional stability, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polyphenylene Ether + PS (PPE+PS)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Consumer Goods, Home Appliances, Commercial Appliance
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yld, Type I, 50 mm/min	54	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	45	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	4	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	30	%	ASTM D638
Tensile Modulus, 5 mm/min	2400	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	75	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2100	MPa	ASTM D790
Tensile Stress, yield, 50 mm/min	54	MPa	ISO 527
Tensile Stress, break, 50 mm/min	47	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	3.3	%	ISO 527
Tensile Strain, break, 50 mm/min	28	%	ISO 527
Tensile Modulus, 1 mm/min	2420	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	1600	J/m	ASTM D4812
Izod Impact, notched, 23°C	180	J/m	ASTM D256
Izod Impact, notched, -30°C	110	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	46	J	ASTM D3763

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Izod Impact, unnotched 80*10*4 +23°C	121	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*4 -30°C	94	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	16	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	11	kJ/m²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	13	kJ/m²	ISO 179/1eA
THERMAL [1]			
Vicat Softening Temp, Rate B/50	133	°C	ASTM D1525
HDT, 1.82 MPa, 3.2mm, unannealed	112	°C	ASTM D648
HDT, 1.82 MPa, 6.4 mm, unannealed	120	°C	ASTM D648
CTE, -40°C to 40°C, flow	7.2E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, xflow	8.E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	7.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.3E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50	133	°C	ISO 306
Vicat Softening Temp, Rate B/120	135	°C	ISO 306
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	112	°C	ISO 75/Af
Relative Temp Index, Elec [2]	105	°C	UL 746B
Relative Temp Index, Mech w/impact [2]	90	°C	UL 746B
Relative Temp Index, Mech w/o impact [2]	105	°C	UL 746B
PHYSICAL [1]			
Specific Gravity	1.08	-	ASTM D792
Mold Shrinkage, flow, 3.2 mm [3]	0.5 – 0.8	%	SABIC method
Melt Flow Rate, 250°C/10.0 kgf	6.4	g/10 min	ASTM D1238
Water Absorption, (23°C/24hrs)	0.13	%	ISO 62-1
Moisture Absorption, (23°C/50% RH/Equilibrium)	0.04	%	ISO 62-4
Melt Volume Rate, MVR at 250°C/10.0 kg	6	cm³/10 min	ISO 1133
ELECTRICAL [1]			
Dielectric Constant, 1.1 GHz	2.55	-	SABIC method
Dissipation Factor, 1.1 GHz	0.00153	-	SABIC method
Dielectric Constant, 1.9 GHz	2.55	-	SABIC method
Dissipation Factor, 1.9 GHz	0.00121	-	SABIC method
Dielectric Constant, 5 GHz	2.52	-	SABIC method
Dissipation Factor, 5 GHz	0.00116	-	SABIC method
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
High Amp Arc Ignition (HAI), PLC 3	≥1.5	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 1	≥1.5	mm	UL 746A
Hot-Wire Ignition (HWI), PLC 2	≥3	mm	UL 746A
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D495
FLAME CHARACTERISTICS [2]			
UL Yellow Card Link	E207780-228539	-	-
UL Yellow Card Link 2	E45587-237006	-	-
UL Recognized, 94HB Flame Class Rating	≥1.5	mm	UL 94
INJECTION MOLDING [4]			
Drying Temperature	105 – 110	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	3 – 4	Hrs	
Drying Time (Cumulative)	8	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 310	°C	
Nozzle Temperature	280 – 310	°C	
Front - Zone 3 Temperature	270 – 310	°C	
Middle - Zone 2 Temperature	260 – 305	°C	
Rear - Zone 1 Temperature	250 – 300	°C	
Mold Temperature	75 – 105	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	20 – 100	rpm	
Shot to Cylinder Size	30 – 70	%	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

(3) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

DISCLAIMER