NORYL™ Resin EM7301F

REGION AMERICAS

DESCRIPTION

NORYL EM7301F resin is a 10% glass fiber reinforced blend of polyphenylene ether (PPE) + polystyrene (PS). This injection moldable grade exhibits high heat resistance, good flow and polyurethane foam adhesion along with creep resistance, dimensional stability, and hydrolytic stability. NORYL EM7301F resin is an excellent candidate for automotive interior applications such as audio speaker components. This material is available only in black.

GENERAL INFORMATION	
Features	Hydrolytic Stability, Low Warpage, Amorphous, Low Shrinkage, Low Moisture Absorption, Low Specific Gravity, Food contact, Dimensional stability, High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polyphenylene Ether + PS (PPE+PS)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Interiors

TYPICAL PROPERTY VALUES

Revision 20240530

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, brk, Type I, 5 mm/min	68	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	5	%	ASTM D638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	96	MPa	ASTM D790
Flexural Modulus, 2.6 mm/min, 100 mm span	3640	MPa	ASTM D790
IMPACT [1]			
Izod Impact, notched, 23°C	69	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 6.4 mm, unannealed	122	°C	ASTM D648
PHYSICAL [1]			
Specific Gravity	1.12	-	ASTM D792
INJECTION MOLDING [2]			
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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	

(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) 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.

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