

Noryl* Resin EM7100

Americas: COMMERCIAL

Automotive interiors. 200F DTUL. Excellent processability/economy. Good impact/mechanicals vs styrenics. Trim/instrument panel components.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, yld, Type I, 50 mm/min	41	MPa	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	48	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	62	MPa	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	2200	MPa	ASTM D 790
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	347	J/m	ASTM D 256
Izod Impact, notched, -40°C	160	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	30	J	ASTM D 3763
Instrumented Impact Energy @ peak, -30	11	J	ASTM D 3763
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	101	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	98	°C	ASTM D 648
CTE, 0°C to 100°C, flow	7.38E-05	1/°C	ASTM E 831
PHYSICAL	Value	Unit	Standard
Specific Gravity	1.04	-	ASTM D 792
Water Absorption, 24 hours	0.1	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method

Source GMD, last updated:01/05/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	90 - 95	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	255 - 280	°C
Nozzle Temperature	255 - 280	°C
Front - Zone 3 Temperature	245 - 280	°C
Middle - Zone 2 Temperature	230 - 275	°C
Rear - Zone 1 Temperature	220 - 270	°C
Mold Temperature	65 - 90	°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

Source GMD, last updated:01/05/2000

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

- (1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.
- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.

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