

NORYL™ EM7430 resin

Polyphenylene Ether + PS

SABIC Innovative Plastics

Message:

30% glass reinforced, high flow PPO. Automotive. Energy management material.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	High Flow		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Multi-Point Data	Coefficient of Thermal Expansion vs. Temperature (ASTM E831)		
	Flexural DMA (ASTM D4065)		
	Pressure-Volume-Temperature (PVT - Zoller Method)		
	Tensile Stress vs. Strain (ASTM D638)		
	Thermal Conductivity vs. Temperature (ASTM E1530)		
	Viscosity vs. Shear Rate (ASTM D3835)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage			Internal Method
Flow : 3.20 mm	0.10 to 0.20	%	
Across Flow : 3.20 mm	0.20 to 0.40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	7760	MPa	ASTM D638
Tensile Strength ² (Break)	108	MPa	ASTM D638
Tensile Elongation ³ (Break)	1.5	%	ASTM D638
Flexural Modulus			ASTM D790
100 mm Span ⁴	7170	MPa	
50.0 mm Span ⁵	8340	MPa	
Flexural Strength			ASTM D790
Break, 50.0 mm Span ⁶	162	MPa	
Break, 100 mm Span ⁷	131	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	91	J/m	ASTM D256
Unnotched Izod Impact (23°C)	260	J/m	ASTM D4812
Instrumented Dart Impact (23°C, Total Energy)	14.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	129	°C	
1.8 MPa, Unannealed, 3.20 mm	122	°C	
Vicat Softening Temperature	131	°C	ASTM D1525 ⁸
CLTE			ASTM E831
Flow : -40 to 40°C	2.0E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.7E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	98.9 to 104	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	30 to 70	%	
Rear Temperature	238 to 288	°C	
Middle Temperature	249 to 293	°C	
Front Temperature	260 to 299	°C	
Nozzle Temperature	271 to 299	°C	
Processing (Melt) Temp	271 to 299	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	20 to 100	rpm	
Vent Depth	0.038 to 0.051	mm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	2.6 mm/min		
5.	1.3 mm/min		
6.	1.3 mm/min		
7.	2.6 mm/min		
8.	Rate B (120°C/h), Loading 2 (50 N)		

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