

Noryl* Resin 731

Europe-Africa-Middle East: COMMERCIAL

NORYL 731 is an unfilled material, with a Vicat B/120 of 140C according ISO 306. NORYL 731 is a general purpose material with high

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Taber Abrasion, CS-17, 1 kg	65	mg/1000cy	SABIC Method
Tensile Stress, yield, 50 mm/min	55	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	5	%	ISO 527
Tensile Strain, break, 50 mm/min	30	%	ISO 527
Tensile Modulus, 1 mm/min	2300	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	75	MPa	ISO 178
Flexural Modulus, 2 mm/min	2200	MPa	ISO 178
Hardness, H358/30	100	MPa	ISO 2039-1
IMPACT			
Izod Impact, notched 80*10*4 +23°C	15	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -30°C	5	kJ/m ²	ISO 180/1A
Charpy 23°C, V-notch Edgew 80*10*4 sp=62mm	15	kJ/m ²	ISO 179/1eA
Charpy -30°C, V-notch Edgew 80*10*4 sp=62mm	5	kJ/m ²	ISO 179/1eA
THERMAL			
Thermal Conductivity	0.22	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
CTE, 23°C to 80°C, xflow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Ball Pressure Test, approximate maximum	133	°C	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	145	°C	ISO 306
Vicat Softening Temp, Rate B/50	135	°C	ISO 306
Vicat Softening Temp, Rate B/120	140	°C	ISO 306

1) Typical values only. Variations within normal tolerances are possible for various colours. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection moulded samples. All samples are prepared according to ISO 294.

2) Only typical data for material selection purpose. 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) Own measurement according to UL.

Source, GMD, Last Update: 06/05/1998

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	130	°C	ISO 75/Be
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	115	°C	ISO 75/Ae
Relative Temp Index, Elec	105	°C	UL 746B
Relative Temp Index, Mech w/impact	90	°C	UL 746B
Relative Temp Index, Mech w/o impact	105	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow (2)	0.5 - 0.7	%	SABIC Method
Density	1.06	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.23	%	ISO 62
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62
Melt Volume Rate, MVR at 280°C/5.0 kg	8	cm ³ /10 min	ISO 1133
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	IEC 60093
Surface Resistivity, ROA	>1.E+15	Ohm	IEC 60093
Dielectric Strength, in oil, 3.2 mm	19	kV/mm	IEC 60243-1
Relative Permittivity, 50/60 Hz	2.7	-	IEC 60250
Relative Permittivity, 1 MHz	2.6	-	IEC 60250
Dissipation Factor, 50/60 Hz	0.002	-	IEC 60250
Dissipation Factor, 1 MHz	0.001	-	IEC 60250
Comparative Tracking Index	175	V	IEC 60112
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating 2nd value (3)	3	mm	UL 94
Glow Wire Flammability Index 750°C, passes at	3.2	mm	IEC 60695-2-12
Oxygen Index (LOI)	22	%	ISO 4589

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	100 - 120	°C
Drying Time	2 - 3	hrs
Melt Temperature	280 - 300	°C
Nozzle Temperature	260 - 280	°C
Front - Zone 3 Temperature	280 - 300	°C
Middle - Zone 2 Temperature	260 - 280	°C
Rear - Zone 1 Temperature	240 - 260	°C
Hopper Temperature	60 - 80	°C
Mold Temperature	80 - 120	°C

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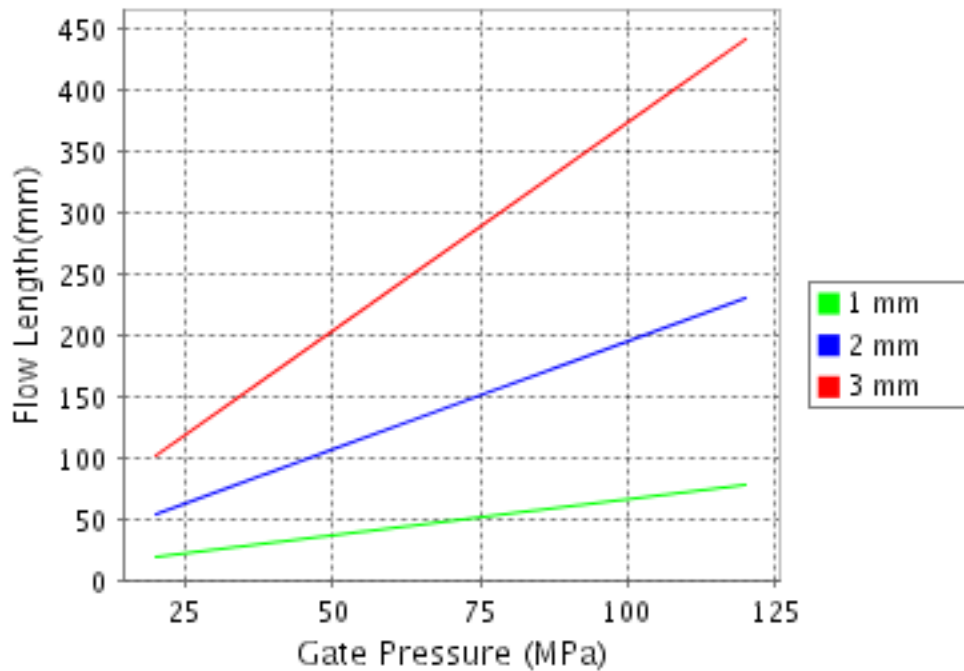
CALCULATED FLOW LENGTH INDICATION

Moldflow® Radial Flow Analysis

Noryl® 731

Melt Temperature : 290°C

Mold Temperature : 100°C



Note: Technical support is recommended if Gate Pressure is greater than 80 MPa. Contact your local representative.

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