

Noryl* Resin 731H

Americas: COMMERCIAL

High gloss, general purpose grade. 130C (266F) DTUL. UL 94 HB rated. For multiple plugs, wine filter plates, etc.

Property

TYPICAL PROPERTIES ⁽¹⁾			
	Value	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	66	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2480	MPa	ASTM D 790
Hardness, Rockwell R	119	-	ASTM D 785
IMPACT			
	Value	Unit	Standard
Izod Impact, notched, 23°C	267	J/m	ASTM D 256
Izod Impact, notched, -40°C	133	J/m	ASTM D 256
Gardner, -30°C	25	J	ASTM D 3029
Gardner, -40°C	5	J	ASTM D 3029
THERMAL			
	Value	Unit	Standard
HDT, 0.45 MPa, 6.4 mm, unannealed	137	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	129	°C	ASTM D 648
CTE, -40°C to 95°C, flow	5.94E-05	1/°C	ASTM E 831
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			
	Value	Unit	Standard
Specific Gravity	1.06	-	ASTM D 792
Water Absorption, 24 hours	0.06	%	ASTM D 570
Mold Shrinkage, flow, 3.2 mm	0.5 - 0.7	%	SABIC Method
ELECTRICAL			
	Value	Unit	Standard
Dielectric Strength, in oil, 3.2 mm	21.6	kV/mm	ASTM D 149
Relative Permittivity, 50/60 Hz	2.65	-	ASTM D 150
Dissipation Factor, 50/60 Hz	0.0004	-	ASTM D 150
Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	4	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS			
	Value	Unit	Standard
UL Recognized, 94HB Flame Class Rating (3)	1.47	mm	UL 94

Source GMD, last updated:01/05/2000

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	105 - 110	°C
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	%

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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