



NORYL™ Resin ZM3640
Asia Pacific: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4	%	ASTM D 638
Flexural Stress, yield, 6.4 mm	1040	kgf/cm ²	ASTM D 790
Flexural Modulus, 6.4 mm	47100	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	103	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.2E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.8E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.22	-	ASTM D 792
Melt Flow Rate, 300°C/2.16 kgf	24	g/10 min	ASTM D 1238
FLAME CHARACTERISTICS			
UL Recognized, 94V-1 Flame Class Rating (3)	1.5	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL 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