



**SEQUEL® 2326**  
**PRELIMINARY**

**DESCRIPTION:**

SEQUEL® 2326 engineered polyolefin is designed for mold-in-color automotive interior applications high impact energy management. This product is typically supplied in natural without UV stabilization. The product can be supplied to OEM interior color match with UV protection.

**APPLICATIONS:**

SEQUEL® 2326 engineered polyolefin is especially well suited for applications where the part impact requirements of FMVSS201 are difficult to achieve. This product is recommended for use in pillar trim applications where parts are intended to withstand side airbag impact at -30°C without brittle fracture.

**NOMINAL PROPERTIES:**

PROPERTY	TYPICAL VALUE	UNITS	TEST METHODS
<b>PHYSICAL</b>			
Specific Gravity	0.96	—	ISO 1183
Filler Content	10	wt %	ISO 3451 /ASTM D5630
<b>REHOLOGICAL</b>			
Melt Flow Rate, 230°C / 2.16 kg	17	dg/min	ISO 1133
<b>MECHANICAL</b>			
Tensile Stress at Yield	17	MPa	ISO 527-1, 50mm/min
Tensile Elongation at Yield	10	%	ISO 527-1, 50mm/min
Tensile Modulus	1,100	MPa	ISO 527-1, 1 mm/min
Flexural Modulus, +23°C (4mm thickness)	1,200	MPa	ISO 178, 2 mm/min
Flexural Strength, +23°C (4mm thickness)		MPa	ISO 178, 2 mm/min
Hardness	60	Shore D	ISO 868
<b>THERMAL</b>			
Heat Distortion Temperature			
450 kPa applied stress, un-annealed	80	°C	ISO 75-2
1.8 MPa applied stress, un-annealed	50	°C	ISO 75-2
CLTE, -30°C to +80°C, parallel	~ 7 · 10 <sup>-5</sup>	mm/mm/°C	ASTM D 696
CLTE, -30°C to +80°C, transverse		mm/mm/°C	ASTM D 696
Flammability (FMVSS 302)	< 100	mm/min	ISO 3795
DSC Melting Peak (10°C/min)	163	°C	ASTM D 3417 / 3418
<b>VISUAL</b>			
Five-finger Scratch Resistance			GMN3943, FLTMBN 108-13 DCX LP-463DD-18-1
Minimum Load for No Whitening	3 – 10	N	

**Properties reported are preliminary. This product is still under development and properties may change from those reported here.**

*Tests are made in accordance with the current issue of the ISO, ASTM, or other cited test methods. Test data reported here are nominal values measured on injection molded plaques and test bars.*

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**IMPACT PROPERTIES:**

PROPERTY	TYPICAL VALUE	UNITS	TEST METHODS
<b>IMPACT</b>			
Multi-Axial Instrumented Impact			
at +23°C, 6.7 m/s (15 mph)		J at max load	ASTM D 3763
at 0°C, 6.7 m/s (15 mph)		J at max load	ASTM D 3763
at -30°C, 6.7 m/s (15 mph)	28 (Ductile)	J at max load	ASTM D 3763
Notched Izod Impact, at +23°C	830 (No Break)	J/m	ASTM D 256
Notched Izod Impact, at -30°C	820 (No Break)	J/m	ASTM D 256
Notched Izod Impact, at +23°C		kJ/m <sup>2</sup>	ISO 180/1eA
Notched Izod Impact, at -40°C		kJ/m <sup>2</sup>	ISO 180/1eA
Notched Charpy Impact, at +23°C	78	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Charpy Impact, at -40°C	6	kJ/m <sup>2</sup>	ISO 179/1eA
Gardner Impact, at +23°C	26	J	ASTM D 5420
Gardner Impact, at -30°C	>36	J	ASTM D 5420

**PROCESSING CONDITIONS**

PROPERTY	TYPICAL VALUE		UNITS	TEST METHODS
<b>INJECTION MOLDING SHRINKAGE</b>	Average	Range		
Mold Shrinkage, as molded	0.75	0.55 – 0.95	%	ISO 294-4 / ASTM D955
Mold Shrinkage, after bake, 48hrs/80°C			%	ISO 294-4 / ASTM D955
Mold shrinkage is measured on a laboratory molded flat plaque, 200 x 100 x 3 mm				

MOLDING PARAMETERS		MOLDING PARAMETERS	
Barrel Temperature		Injection Pressure	
Nozzle	215°C / 420°F	High	35 – 105 bar
Front	215°C / 420°F	(first stage)	500 – 1500 psi
Center	210°C / 410°F	Low	25 – 70 bar
Rear	205°C / 400°F	(second stage)	350 – 1000 psi
Hot Runner, Manifold & Tips	215°C / 420°F	Back Pressure	3.5 – 20 bar
Melt Temperature	190 – 240°C		50 – 300 psi
	380 – 460°F	Cushion	6 – 13 mm
Mold Temperatures			¼ to ½ inch
Cavity	30°C / 85°F	Injection Velocity	10 – 80 mm/sec
Core	24°C / 75°F		0.4 – 3.2 in/sec
		Screw Speed	50 – 100 rpm

**Drying:**

Pellet drying is generally unnecessary for SEQUEL engineered polyolefin materials. However, drying may help to improve the aesthetic appearance of SEQUEL engineered polyolefins. Drying with dehumidified air (-20°C dew point or lower) at 50-80°C for 2 to 6 hours is generally sufficient to remove any residual moisture to below 0.05 wt%.

For further information, please contact Solvay Engineered Polymers.

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