

Zytel® 73G35HSL BK262

NYLON RESIN

Common features of Zytel® nylon resin include mechanical and physical properties such as high mechanical strength, excellent balance of stiffness and toughness, good high temperature performance, good electrical and flammability properties, good abrasion and chemical resistance. In addition, Zytel® nylon resins are available in different modified and reinforced grades to create a wide range of products with tailored properties for specific processes and end-uses. Zytel® nylon resin, including most flame retardant grades, offer the ability to be coloured.

The good melt stability of Zytel® nylon resin normally enables the recycling of properly handled production waste. If recycling is not possible, we recommend, as the preferred option, incineration with energy recovery (-31kJ/g of base polymer) in appropriately equipped installations. For disposal, local regulations have to be observed.

Zytel® nylon resin typically is used in demanding applications in the automotive, furniture, domestic appliances, sporting goods and construction industry.

Zytel® 73G35HSL BK262 is a 35% glass fiber reinforced, heat stabilised, black polyamide 6 resin for injection moulding.

Product information

Resin Identification	PA6-GF35	ISO 1043
Part Marking Code	>PA6-GF35<	ISO 11469
ISO designation	ISO 16396-PA6,GF35,M1CGHR,S14-110	

Rheological properties

	dry/cond.		
Viscosity number	143/*	cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage, parallel	0.1/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.6/-	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile Modulus	11000/6500	MPa	ISO 527-1/-2
Stress at break, 5mm/min	190/120	MPa	ISO 527-1/-2
Strain at break, 5mm/min	3.2/6	%	ISO 527-1/-2
Flexural Modulus	9500/6000	MPa	ISO 178
Flexural Strength	280/150	MPa	ISO 178
Tensile creep modulus, 1h	*/6000 ^[DS]	MPa	ISO 899-1
Tensile creep modulus, 1000h	*/5000 ^[DS]	MPa	ISO 899-1
Charpy impact strength, 23°C	85/90	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	80/90	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	14/22	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10/10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -40°C	11/12	kJ/m ²	ISO 179/1eA
Puncture energy, 23°C	3/6	J	ISO 6603-2
Izod notched impact strength, 23°C	13/20	kJ/m ²	ISO 180/1A
Poisson's ratio	0.34/0.35		

Zytel® 73G35HSL BK262

NYLON RESIN

[DS]: Derived from similar grade

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	221 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	55 / 15	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	208 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220 / *	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	215 / *	°C	ISO 306
Coeff. of linear therm. expansion, parallel, -40-23°C	21 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel	18 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel, 55-160°C	15 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	72 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	102 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, 55-160°C	147 / *	E-6/K	ISO 11359-1/-2
RTI, electrical, 1.5mm	65	°C	UL 746B
RTI, impact, 1.5mm	65	°C	UL 746B
RTI, strength, 1.5mm	65 / *	°C	UL 746B

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thicken.	HB / *	class	UL 94
Thickness tested	1.5 / *	mm	UL 94
UL recognition	yes / *		UL 94
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	24	mm/min	ISO 3795 (FMVSS 302)

Other properties

	dry/cond.		
Humidity absorption, 2mm	2.1 / *	%	Sim. to ISO 62
Water absorption, 2mm	5.8 / *	%	Sim. to ISO 62
Water absorption, Immersion 24h	1 / *	%	Sim. to ISO 62
Density	1410 / -	kg/m³	ISO 1183

[1]: wall thickness 3mm

Injection

Drying Recommended	yes		
Drying Time, Dehumidified Dryer	2 - 4 h		
Processing Moisture Content	≤0.2 %		
Melt Temperature Optimum	270 °C		Internal
Min. melt temperature	260 °C		
Max. melt temperature	280 °C		
Screw tangential speed	≤0.2 m/s		
Mold Temperature Optimum	100 °C		
Min. mould temperature	70 °C		

Zytel® 73G35HSL BK262

NYLON RESIN

Max. mould temperature

120 °C

Hold pressure range

50 - 100 MPa

Hold pressure time

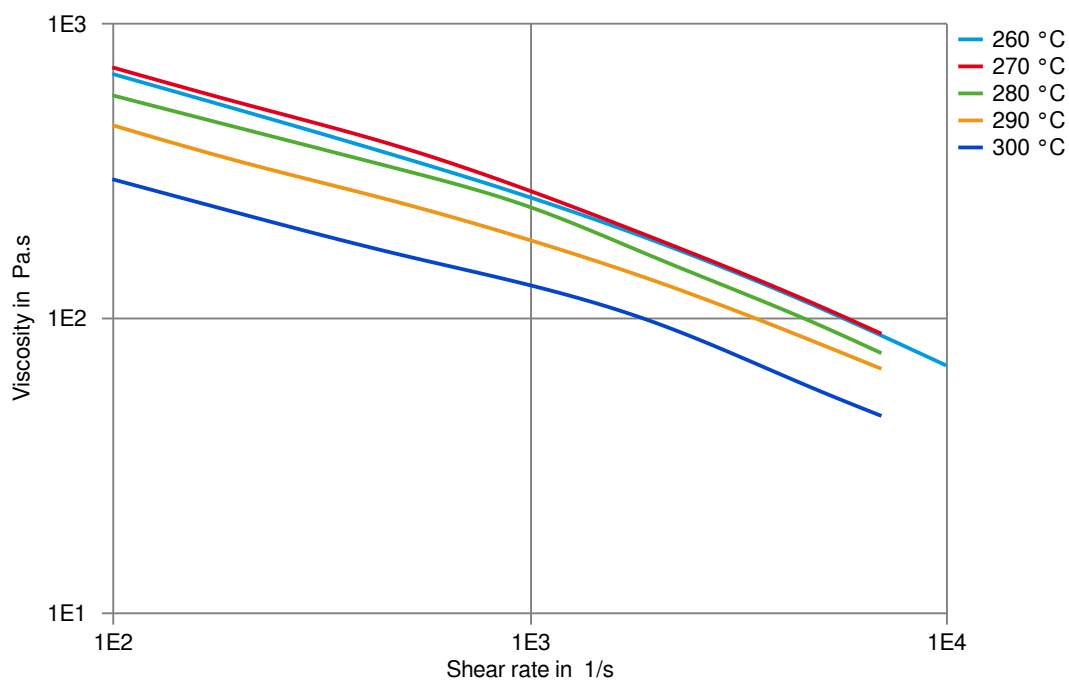
3 s/mm

Characteristics

Additives

Release agent

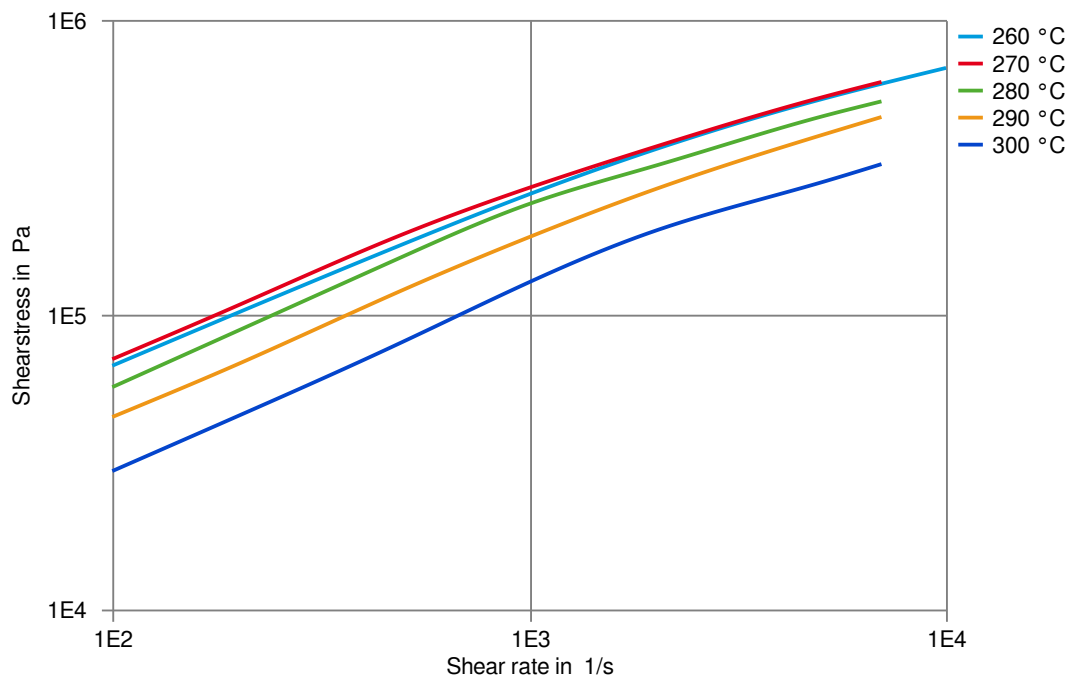
Viscosity-shear rate



Zytel® 73G35HSL BK262

NYLON RESIN

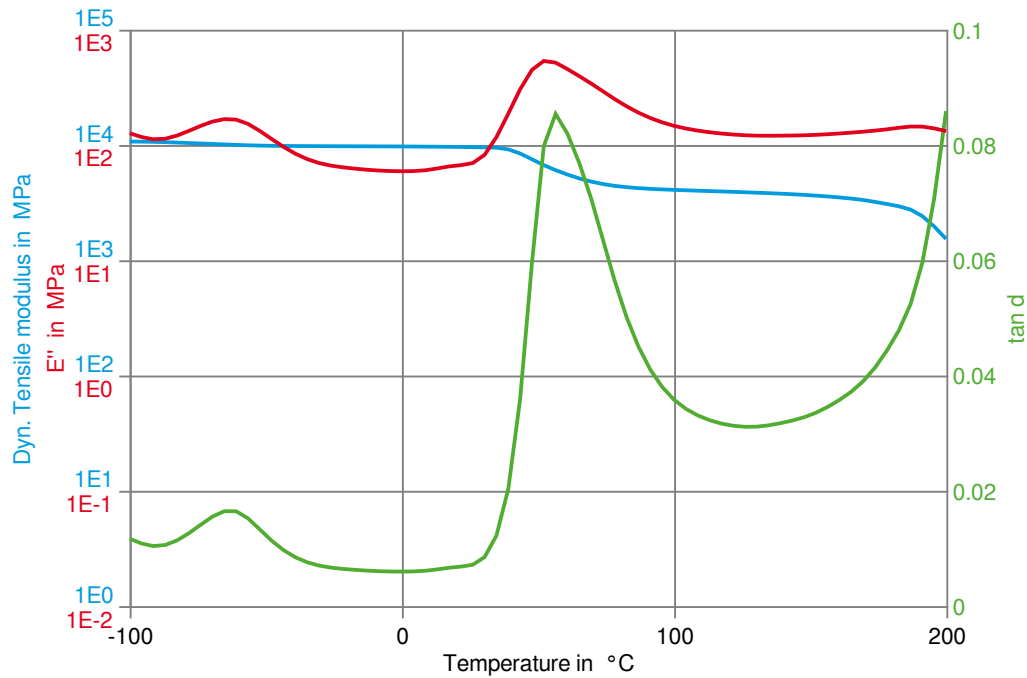
Shearstress-shear rate



Zytel® 73G35HSL BK262

NYLON RESIN

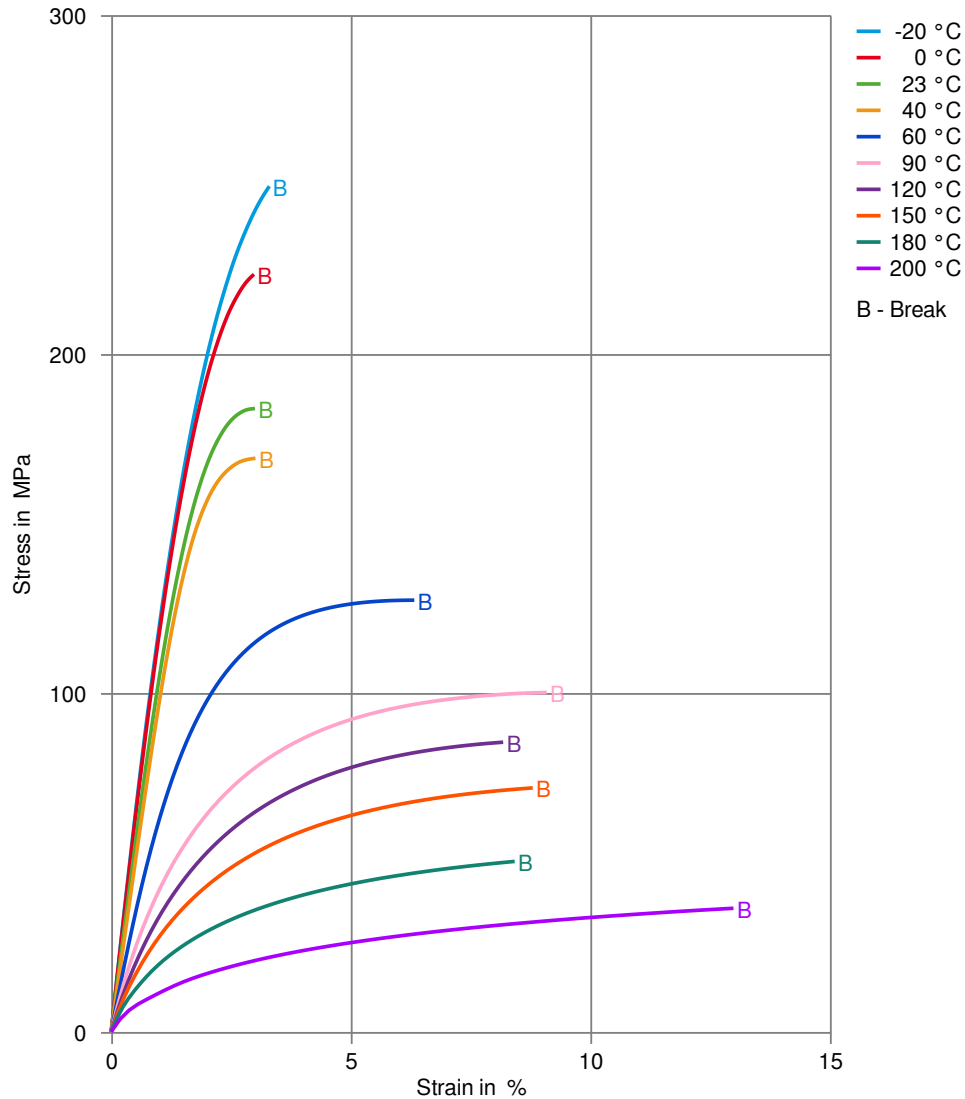
Dynamic Tensile modulus-temperature (dry)



Zytel® 73G35HSL BK262

NYLON RESIN

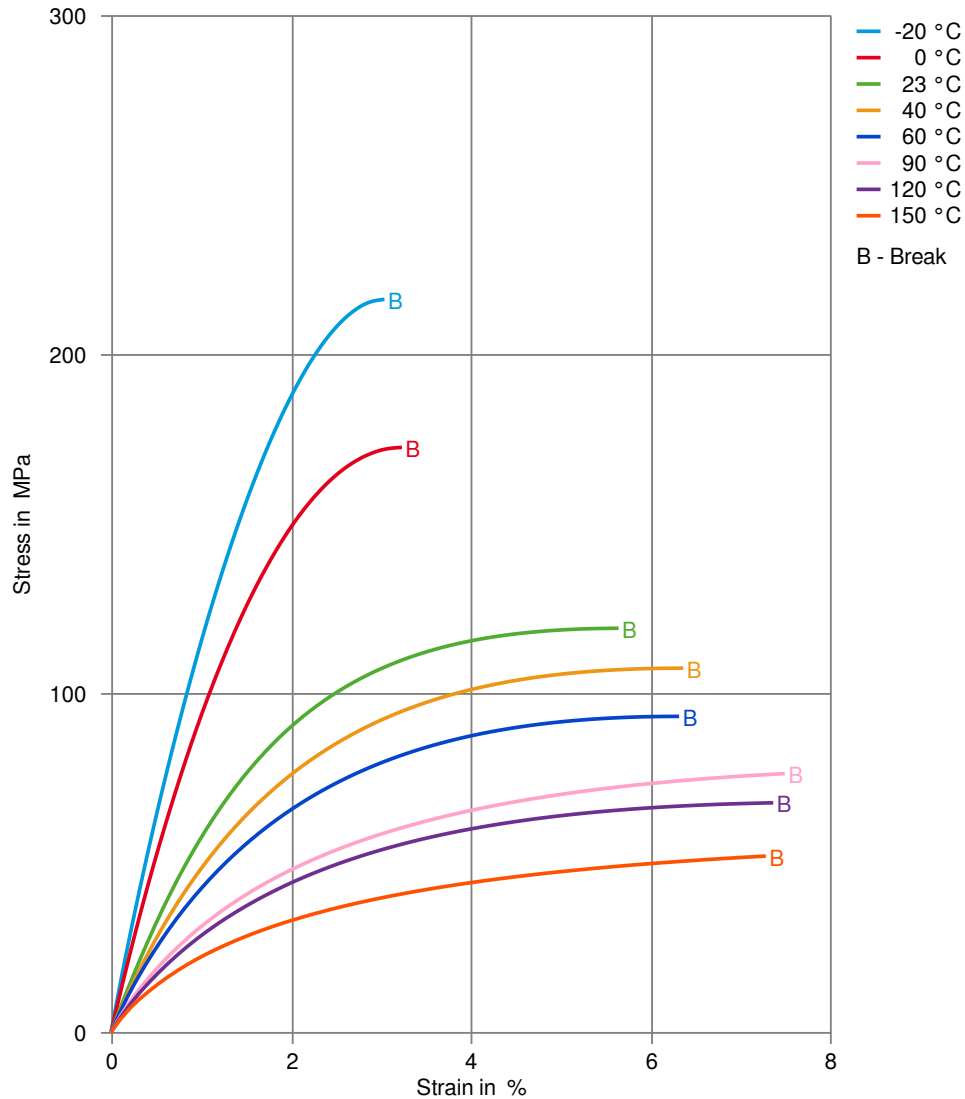
Stress-strain (dry)



Zytel® 73G35HSL BK262

NYLON RESIN

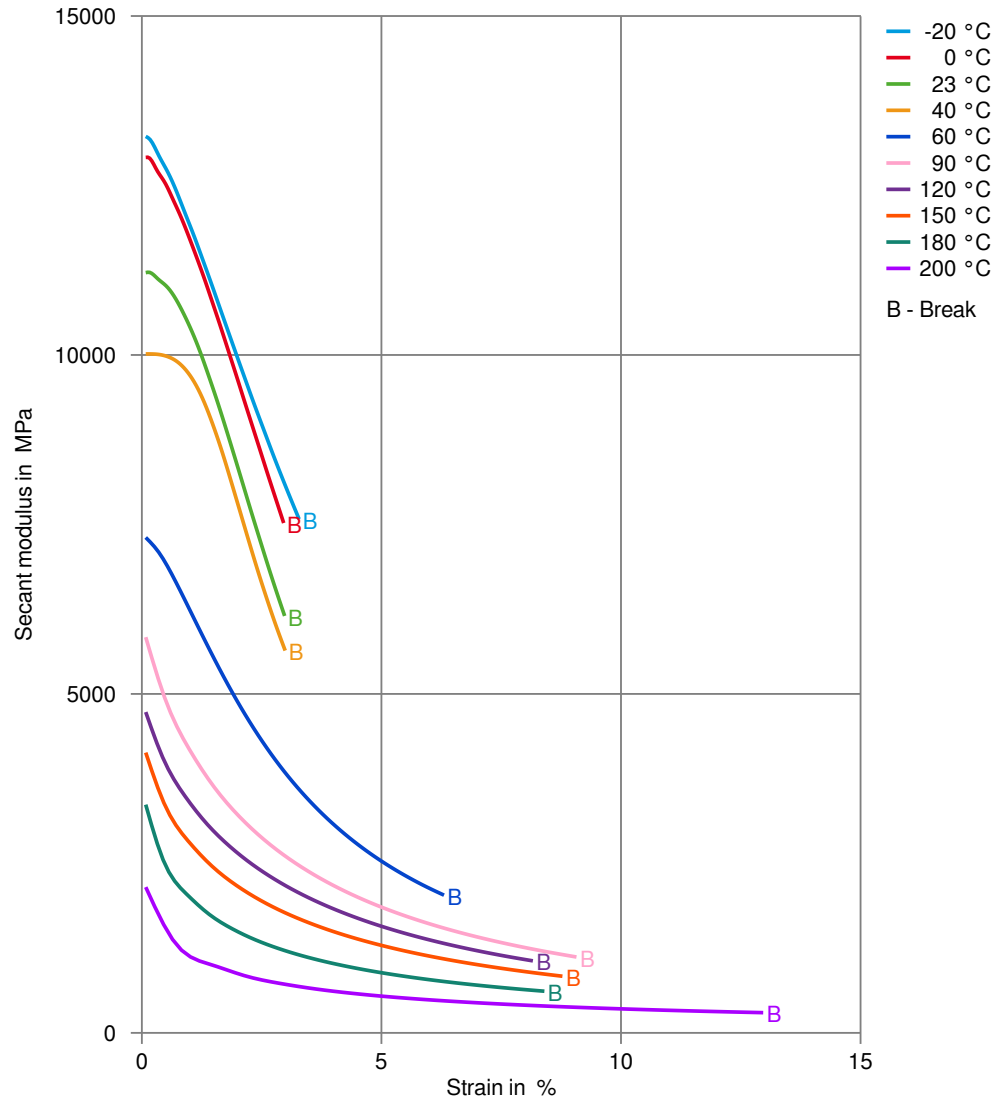
Stress-strain (cond.)



Zytel® 73G35HSL BK262

NYLON RESIN

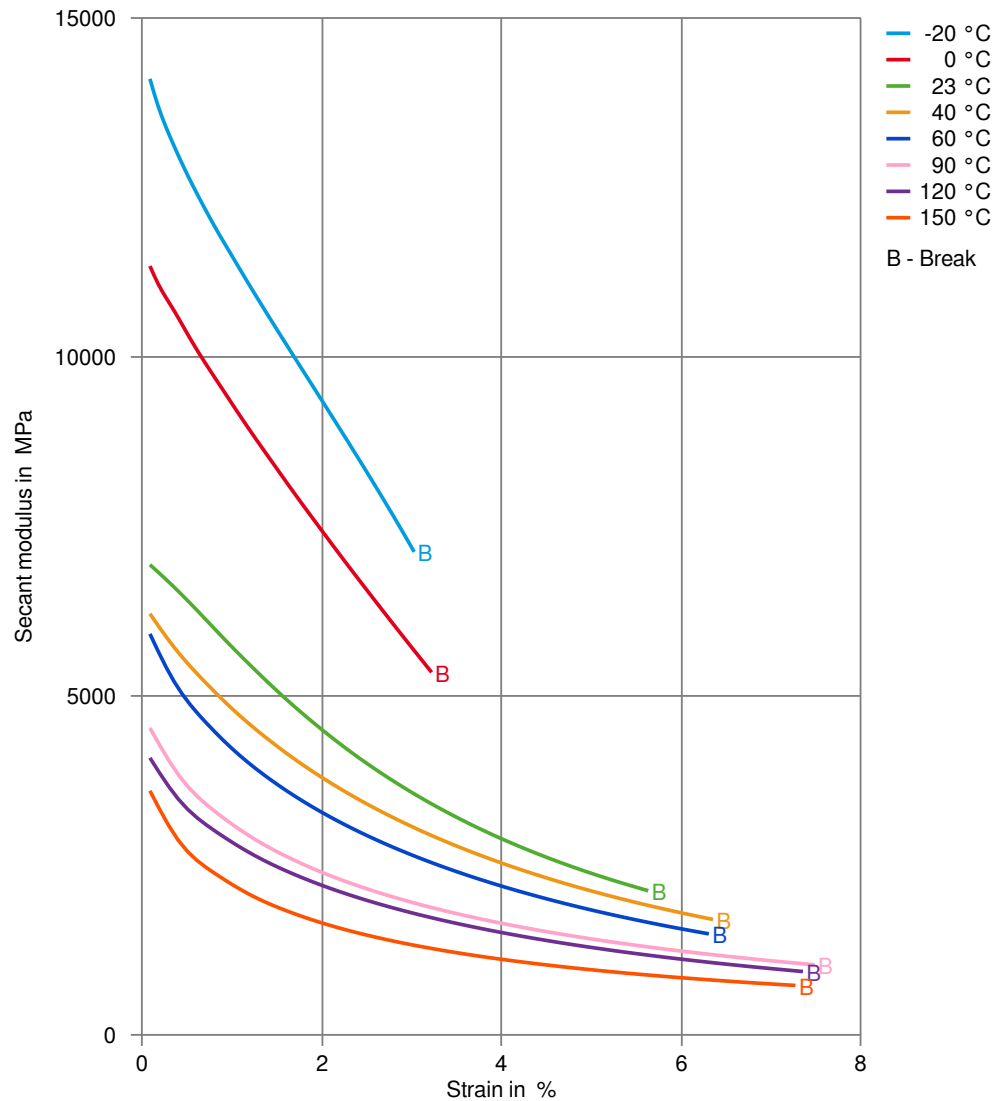
Secant modulus-strain (dry)



Zytel® 73G35HSL BK262

NYLON RESIN

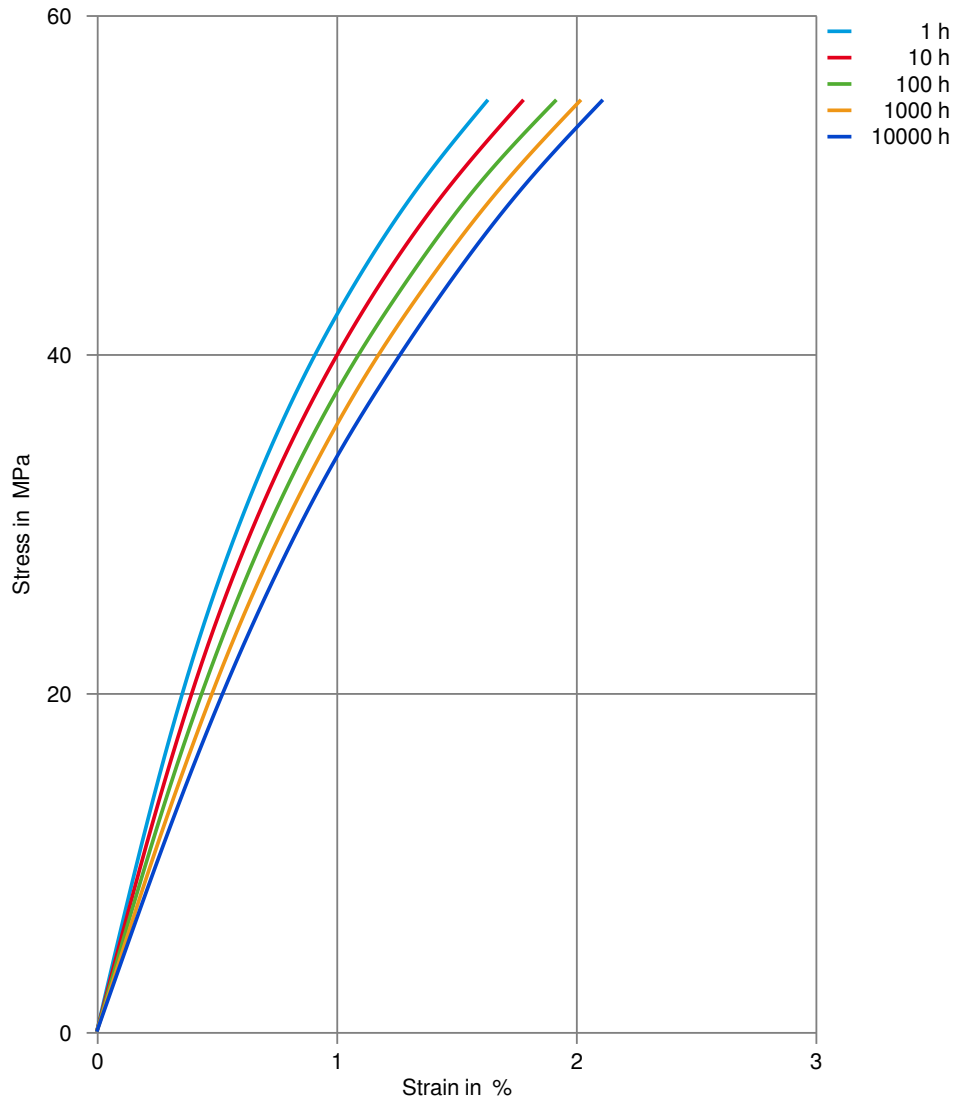
Secant modulus-strain (cond.)



Zytel® 73G35HSL BK262

NYLON RESIN

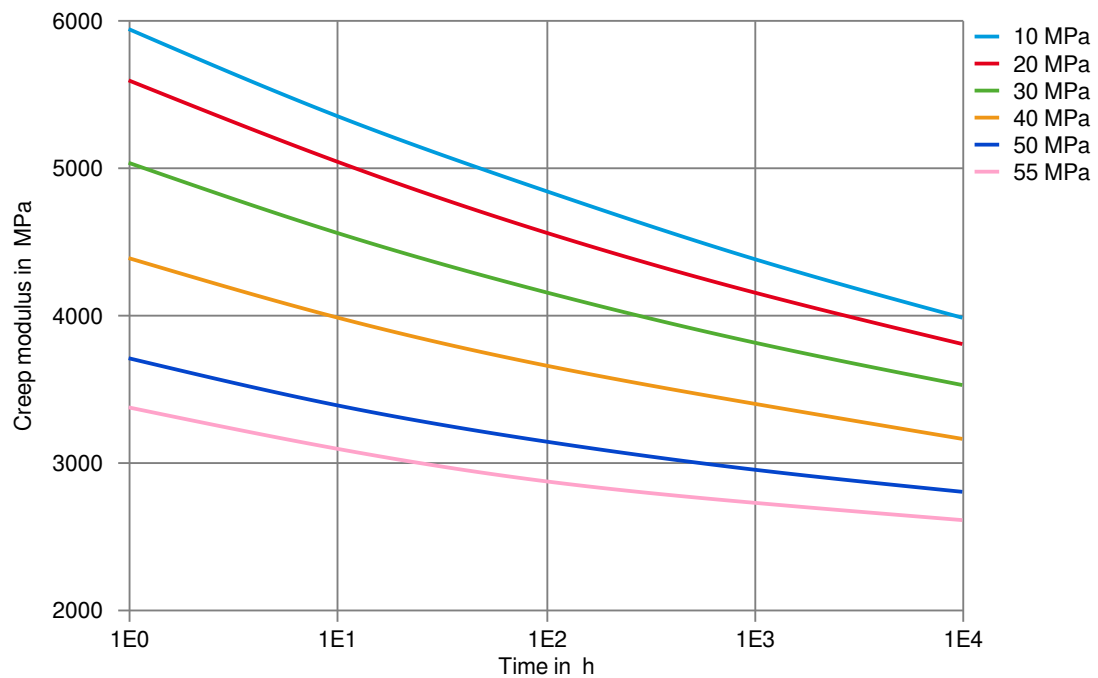
Stress-strain (isochronous) 23°C (cond.)



Zytel® 73G35HSL BK262

NYLON RESIN

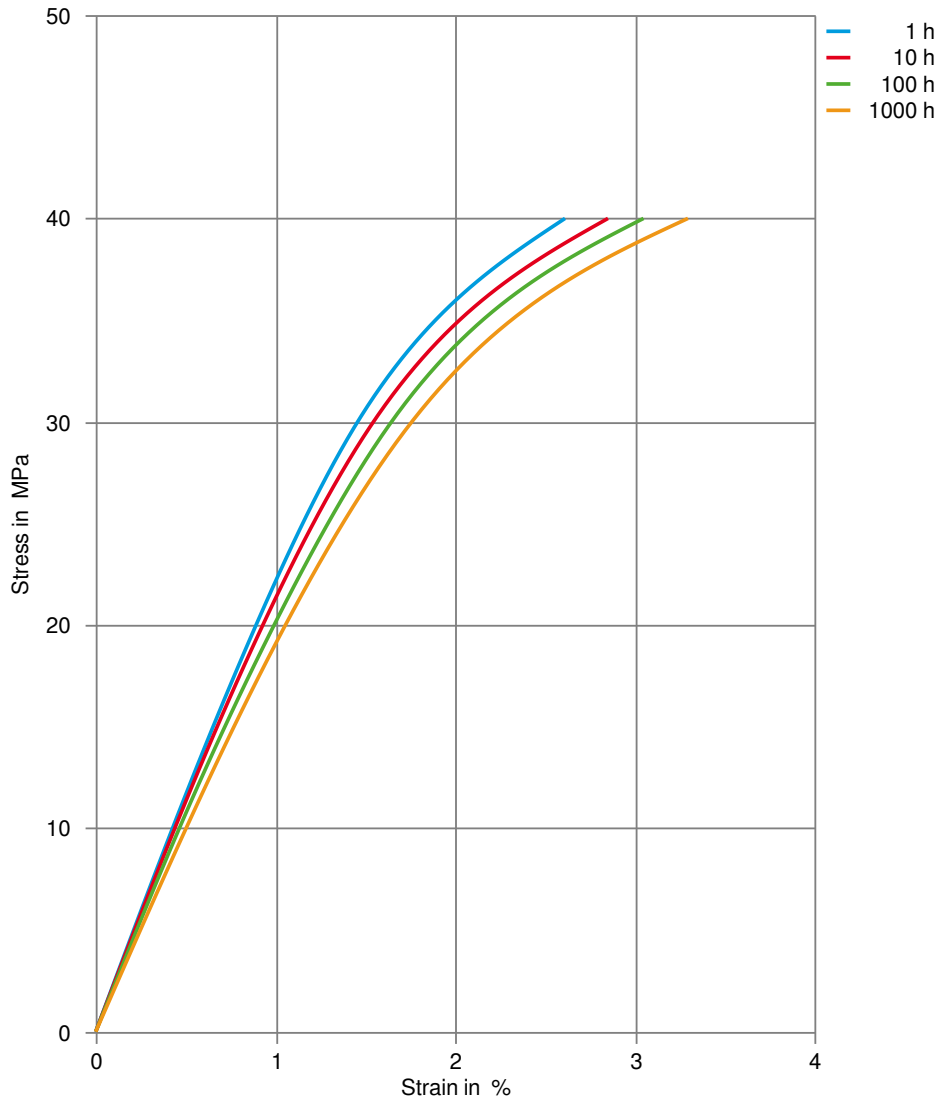
Creep modulus-time 23°C (cond.)



Zytel® 73G35HSL BK262

NYLON RESIN

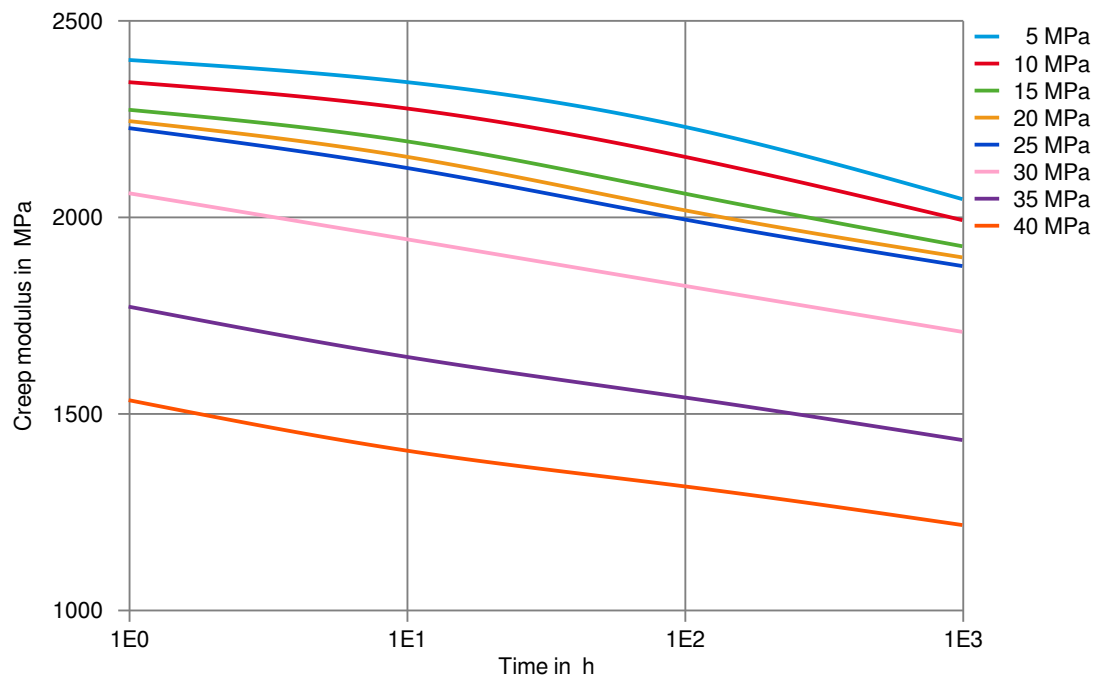
Stress-strain (isochronous) 150°C (dry)



Zytel® 73G35HSL BK262

NYLON RESIN

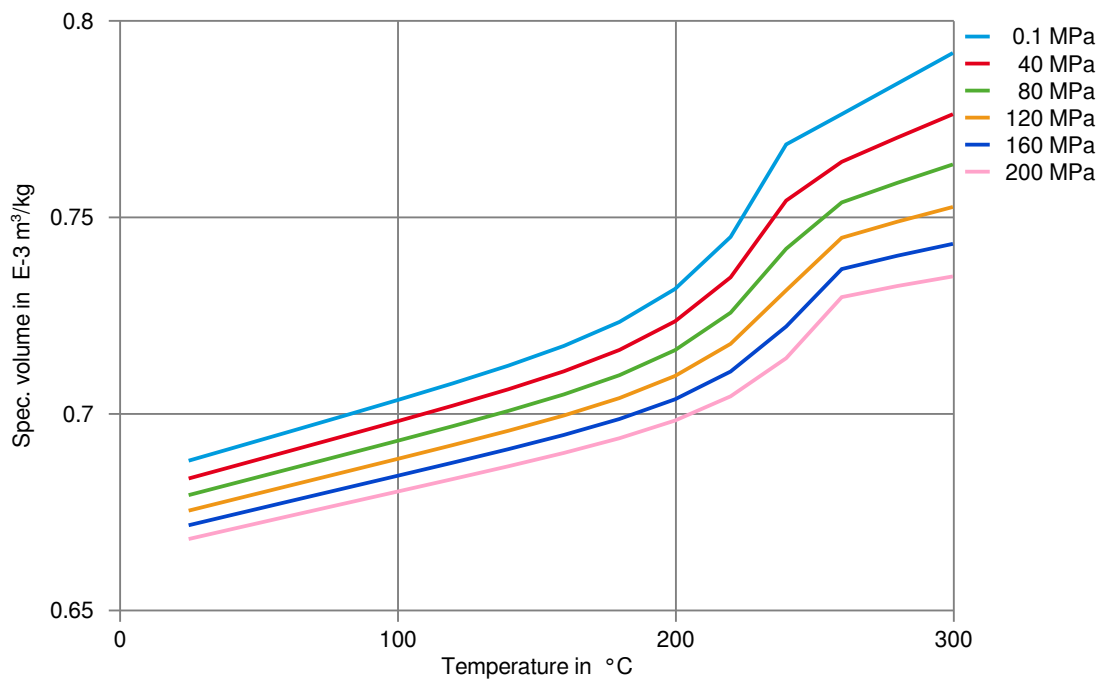
Creep modulus-time 150°C (dry)



Zytel® 73G35HSL BK262

NYLON RESIN

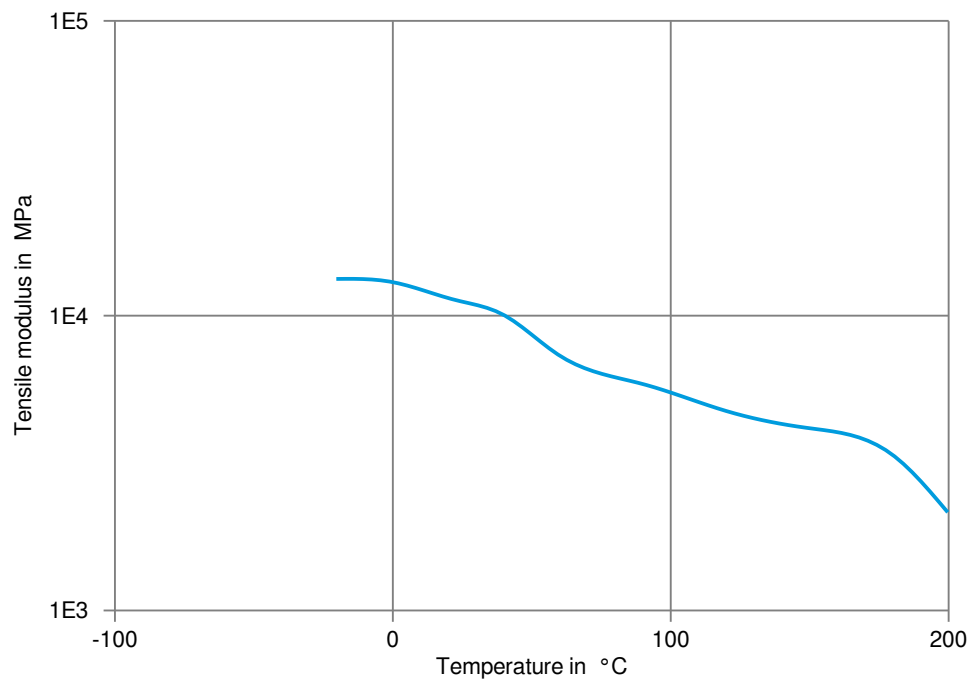
Specific volume-temperature (pvT)



Zytel® 73G35HSL BK262

NYLON RESIN

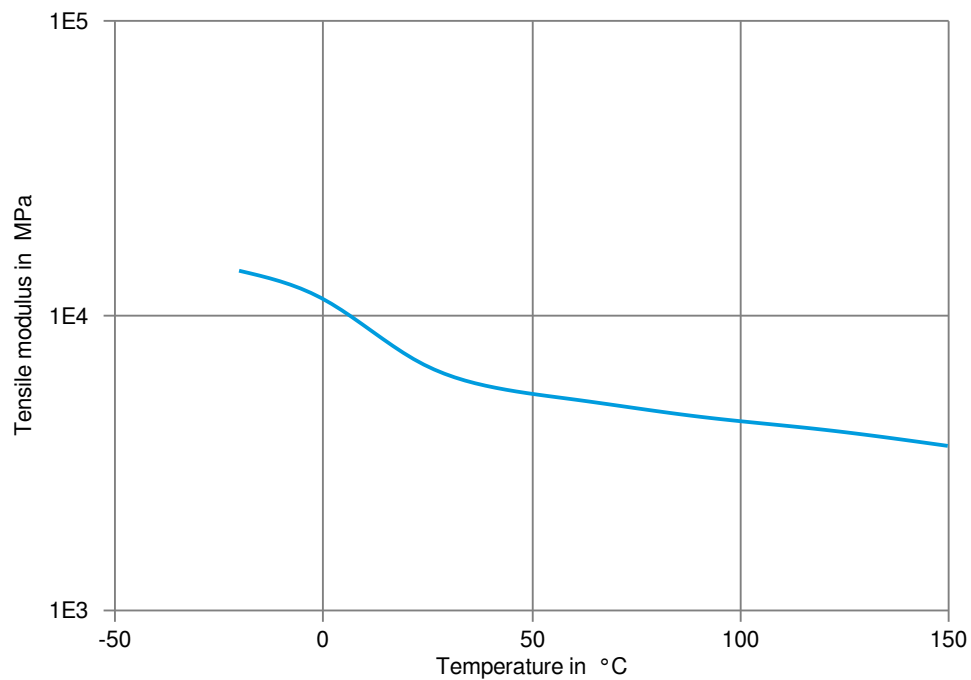
Tensile modulus-temperature (dry)



Zytel® 73G35HSL BK262

NYLON RESIN

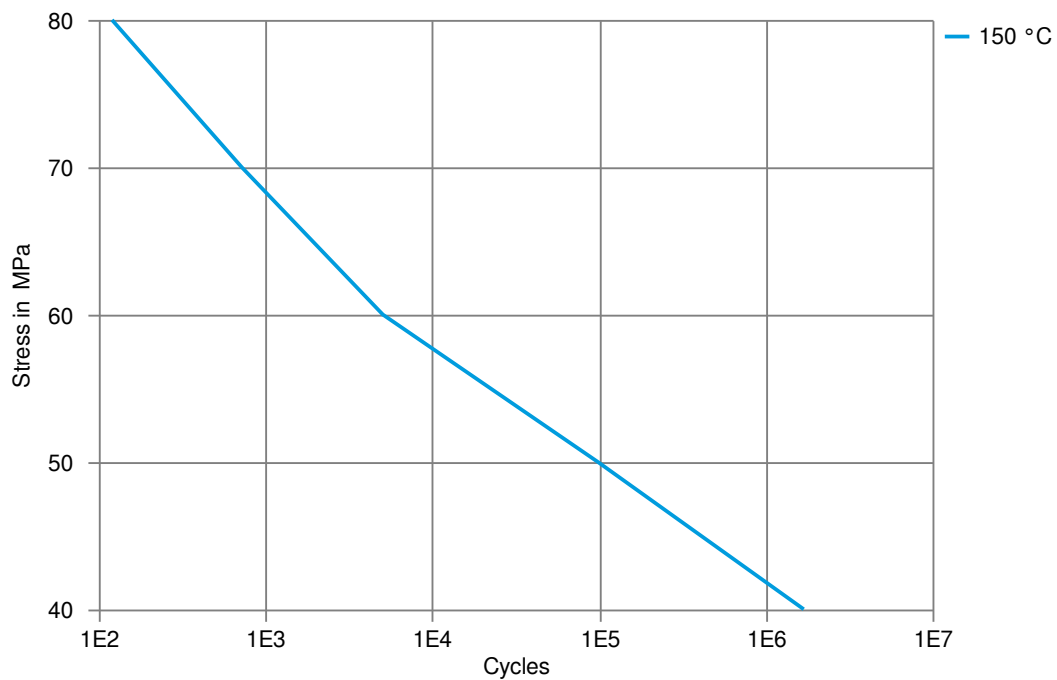
Tensile modulus-temperature (cond.)



Zytel® 73G35HSL BK262

NYLON RESIN

Tensile Fatigue, 10Hz, R=0.1 @ 4mm (cond.)



Zytel® 73G35HSL BK262

NYLON RESIN

Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass), 23°C
- ✓ Citric Acid solution (10% by mass), 23°C
- ✓ Lactic Acid (10% by mass), 23°C
- ✗ Hydrochloric Acid (36% by mass), 23°C
- ✗ Nitric Acid (40% by mass), 23°C
- ✗ Sulfuric Acid (38% by mass), 23°C
- ✗ Sulfuric Acid (5% by mass), 23°C
- ✗ Chromic Acid solution (40% by mass), 23°C

Bases

- ✗ Sodium Hydroxide solution (35% by mass), 23°C
- ✓ Sodium Hydroxide solution (1% by mass), 23°C
- ✓ Ammonium Hydroxide solution (10% by mass), 23°C

Alcohols

- ✓ Isopropyl alcohol, 23°C
- ✓ Methanol, 23°C
- ✓ Ethanol, 23°C

Hydrocarbons

- ✓ n-Hexane, 23°C
- ✓ Toluene, 23°C
- ✓ iso-Octane, 23°C

Ketones

- ✓ Acetone, 23°C

Ethers

- ✓ Diethyl ether, 23°C

Mineral oils

- ✓ SAE 10W40 multigrade motor oil, 23°C
- ✓ SAE 10W40 multigrade motor oil, 130°C
- ✓ SAE 80/90 hypoid-gear oil, 130°C
- ✓ Insulating Oil, 23°C
- ✓ Motor oil OS206 304 Ref.Eng.Oil, ISP, 135°C
- ✓ Automatic hypoid-gear oil Shell Donax TX, 135°C
- ✓ Hydraulic oil Pentosin CHF 202, 125°C

Standard Fuels

- ✓ ISO 1817 Liquid 1 - E5, 60°C
- ✓ ISO 1817 Liquid 2 - M15E4, 60°C
- ✗ ISO 1817 Liquid 3 - M3E7, 60°C
- ✗ ISO 1817 Liquid 4 - M15, 60°C
- ✓ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✓ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C

Zytel® 73G35HSL BK262

NYLON RESIN

- ✓ Diesel fuel (pref. ISO 1817 Liquid F), 23°C
- ✗ Diesel fuel (pref. ISO 1817 Liquid F), 90°C
- ✗ Diesel fuel (pref. ISO 1817 Liquid F), >90°C

Salt solutions

- ✓ Sodium Chloride solution (10% by mass), 23°C
- ✗ Sodium Hypochlorite solution (10% by mass), 23°C
- ✓ Sodium Carbonate solution (20% by mass), 23°C
- ✓ Sodium Carbonate solution (2% by mass), 23°C
- ✗ Zinc Chloride solution (50% by mass), 23°C

Other

- ✓ Ethyl Acetate, 23°C
- ✗ Hydrogen peroxide, 23°C
- ✓ DOT No. 4 Brake fluid, 130°C
- ✗ Ethylene Glycol (50% by mass) in water, 108°C
- ✓ 1% nonylphenoxy-polyethyleneoxy ethanol in water, 23°C
- ✓ 50% Oleic acid + 50% Olive Oil, 23°C
- ✓ Water, 23°C
- ✗ Water, 90°C
- ✗ Phenol solution (5% by mass), 23°C

Symbols used:

- ✓ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).
- ✗ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).