Celanese
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Zytel® 73G30T BK261

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® 73G30T BK261 is a 30% glass fiber reinforced, toughened polyamide 6 resin for injection moulding.

Product information

Resin Identification	PA6-I-GF30	ISO 1043
Part Marking Code	>PA6-I-GF30<	ISO 11469
ISO designation	ISO 16396-PA6-I,GF30,M1CGR,S14-090	

Rheological properties

	dry/cond.		
Melt mass-flow rate	12 / *	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 / *	°C	
Melt mass-flow rate, Load	5 / *	kg	
Viscosity number	150 / *	cm^3/g	ISO 307, 1628
Moulding shrinkage, parallel	0.2 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.0 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	9000 / 5600	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	160 / 105	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 / 7	%	ISO 527-1/-2
Flexural modulus	7800 / 5000[PV]	MPa	ISO 178
Charpy impact strength, 23°C	95 / 95	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	90 / 85[DS]	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	18 / 25	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	10 / 10	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	17 / 22	kJ/m^2	ISO 180/1A
Izod notched impact strength, -30°C	11.0 / 11.0	kJ/m^2	ISO 180/1A
Izod impact strength, 23°C	75 / 75	kJ/m^2	ISO 180/1U
Poisson's ratio	0.34 / 0.35		

[PV]: Preliminary Value

[DS]: Derived from similar grade

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Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	221 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60 / 15	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	206 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel, -40-23°C	25 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	4 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel, 55-160°C	6 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	84 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	110 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, 55-160°C	110 / *	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. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	yes / *		UL 94
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	22	mm/min	ISO 3795 (FMVSS 302)

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2 / *	%	Sim. to ISO 62
Density	1340 / -	kg/m³	ISO 1183
Density of melt	1190	kg/m³	

VDA Properties

Odour	3.5	class	VDA 270

Injection

Drying Recommended	yes	
Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	270	°C
Min. melt temperature	260	°C
Max. melt temperature	280	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	50	°C
Max. mould temperature	100	°C
Hold pressure range	50 - 100	MPa
Hold pressure time	3	s/mm

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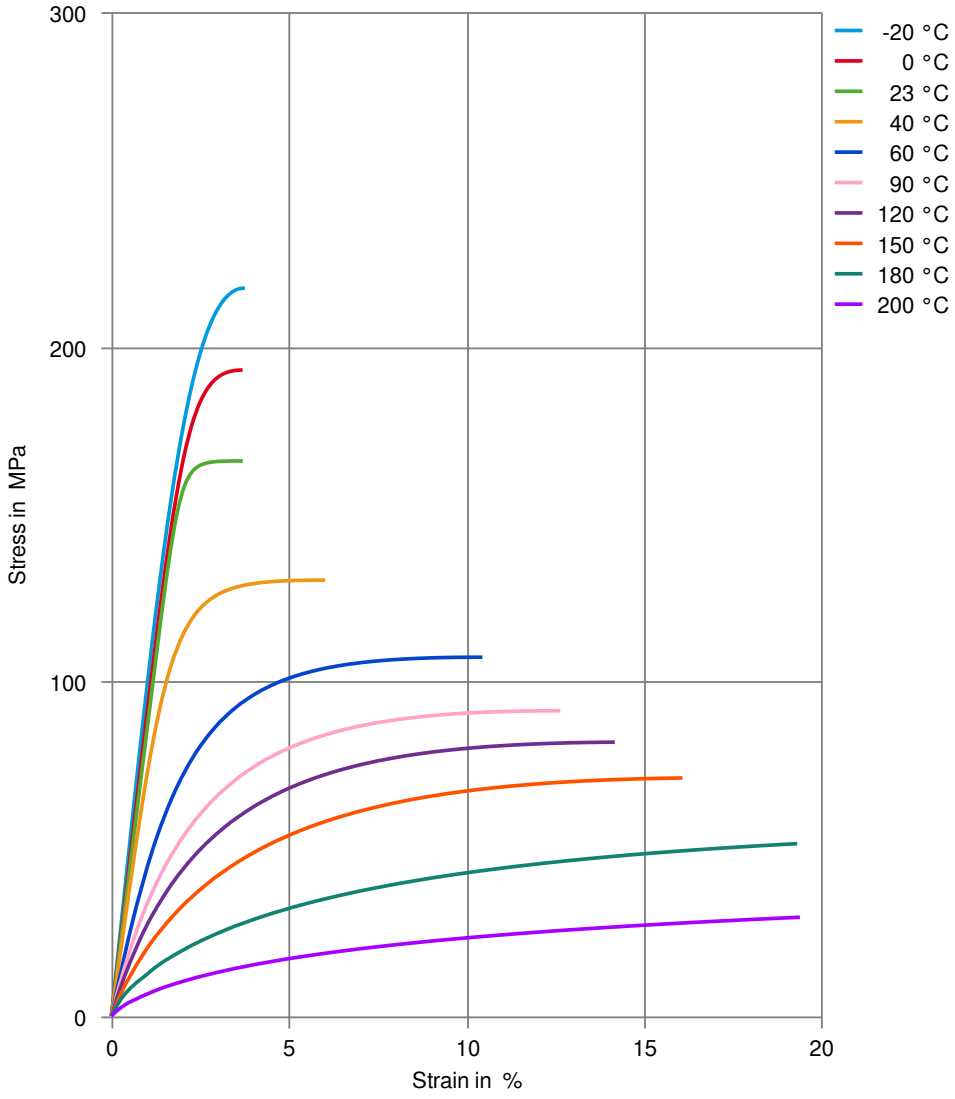
Characteristics

Processing	Injection Moulding

Stress-strain (dry)



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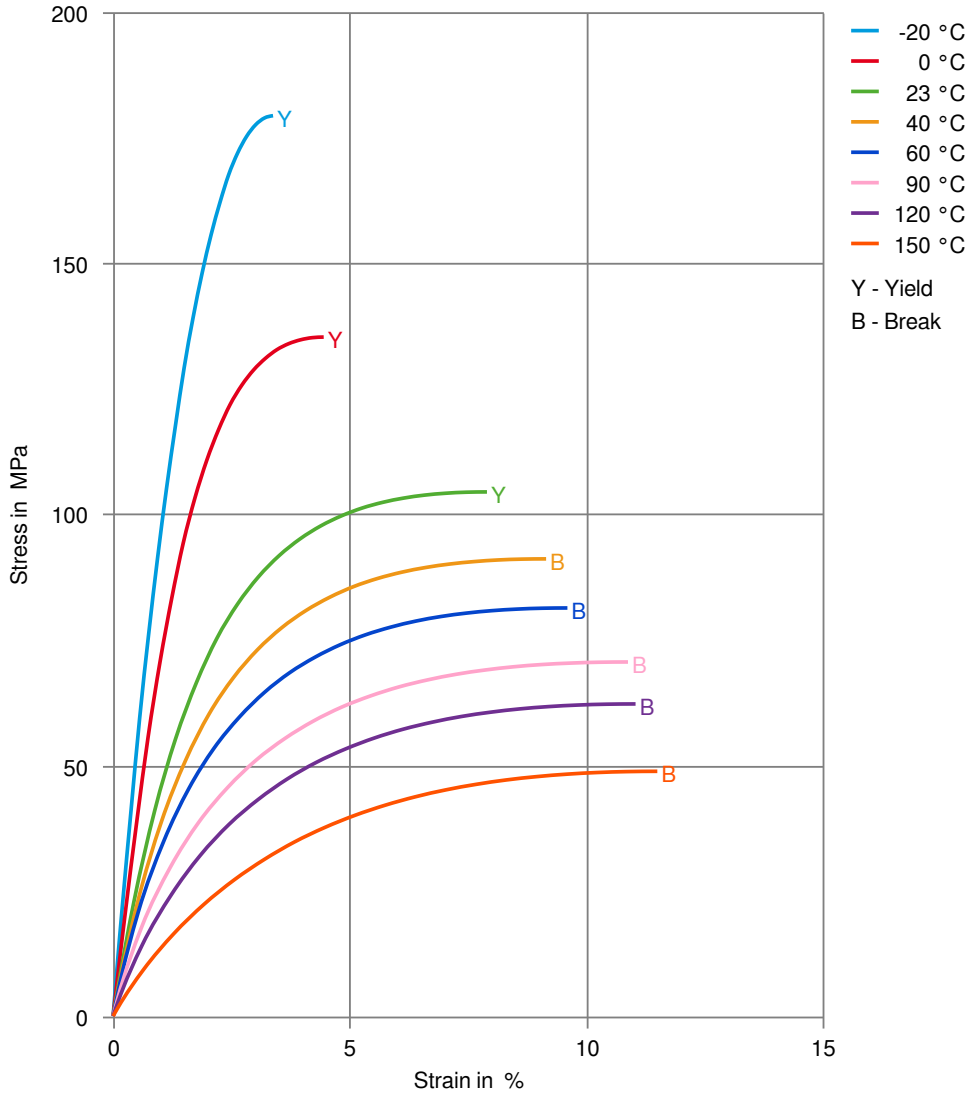
Stress-strain (cond.)



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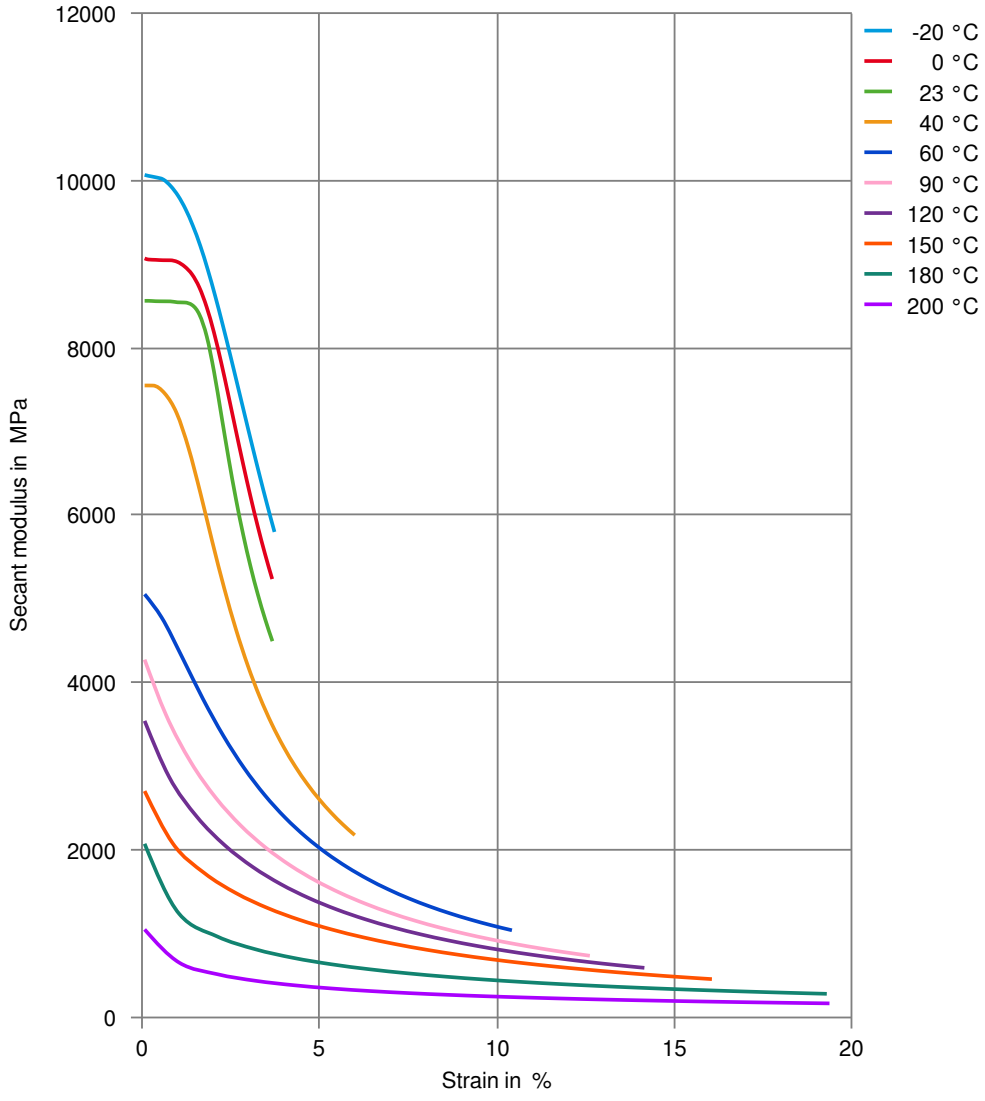
Secant modulus-strain (dry)



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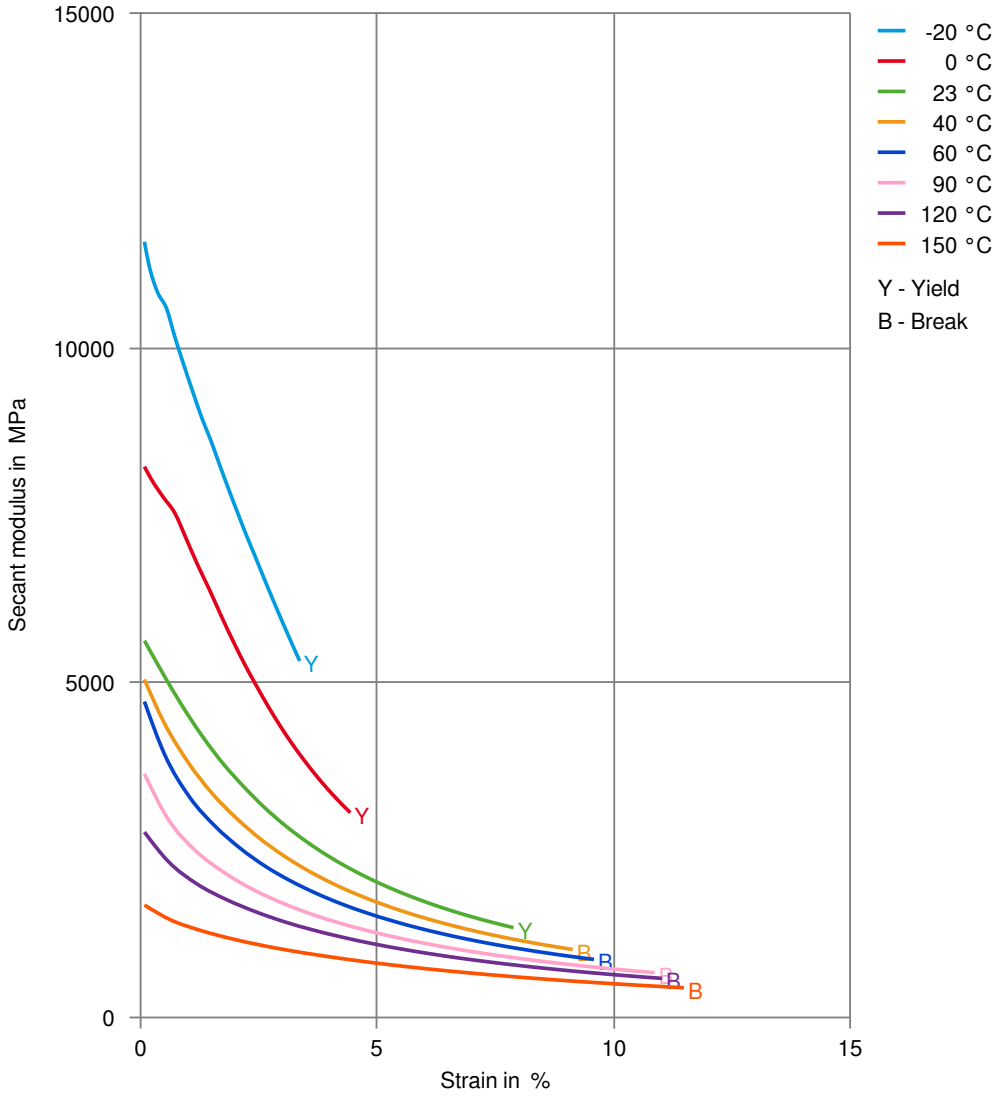
Secant modulus-strain (cond.)



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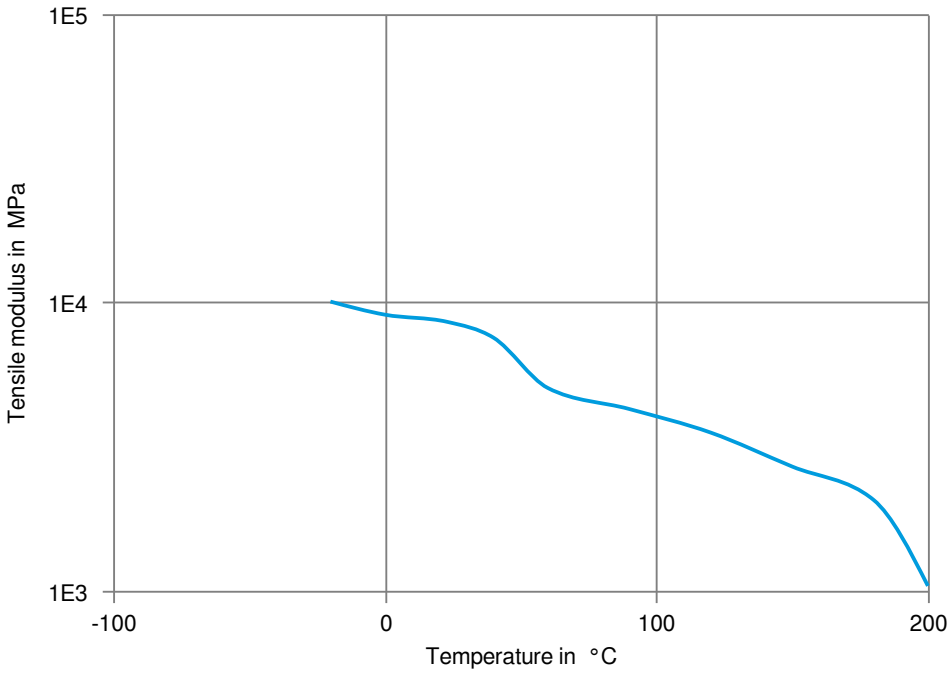
Tensile modulus-temperature (dry)



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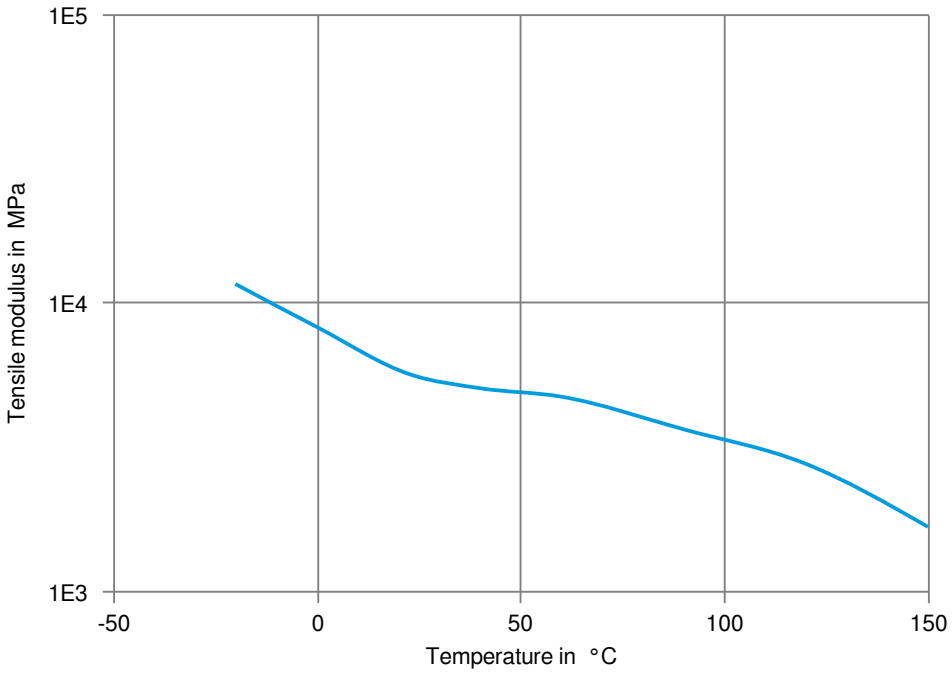
Tensile modulus-temperature (cond.)



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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

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
- ✔ 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

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- ✔ 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).