Celanese
The chemistry inside innovation™

Zytel® 73G45 BK263

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® 73G45 BK263 is a 45% glass fiber reinforced, black polyamide 6 resin for injection moulding.

Product information

Resin Identification	PA6-GF45	ISO 1043
Part Marking Code	>PA6-GF45<	ISO 11469
ISO designation	ISO 16396-PA6,GF45,M1CGR,S14-140	

Rheological properties

	dry/cond.		
Viscosity number	150 / *	cm^3/g	ISO 307, 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	14200 / 9000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	215 / 145	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3 / 5	%	ISO 527-1/-2
Tensile creep modulus, 1h	* / 9400	MPa	ISO 899-1
Tensile creep modulus, 1000h	* / 7300	MPa	ISO 899-1
Charpy impact strength, 23°C	100 / 100	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	19 / 24	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	17 / 22	kJ/m^2	ISO 180/1A
Poisson's ratio	0.33 / 0.34		

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
Temperature of deflection under load, 1.8 MPa	218 / *	°C	ISO 75-1/-2
Thermal conductivity of melt	0.26	W/(m K)	ISO 22007-2
Specific heat capacity of melt	2100	J/(kg K)	ISO 22007-4

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Flammability

FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	44[DS]	mm/min	ISO 3795 (FMVSS 302)

[DS]: Derived from similar grade

Electrical properties

	dry/cond.		
Comparative tracking index	500 / -		IEC 60112

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.7 / *	%	Sim. to ISO 62
Water absorption, 2mm	4.9 / *	%	Sim. to ISO 62
Density	1510 / -	kg/m³	ISO 1183
Density of melt	1330	kg/m³	

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	100	°C
Min. mould temperature	70	°C
Max. mould temperature	120	°C
Hold pressure range	50 - 100	MPa
Hold pressure time	3	s/mm
Ejection temperature	210	°C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent

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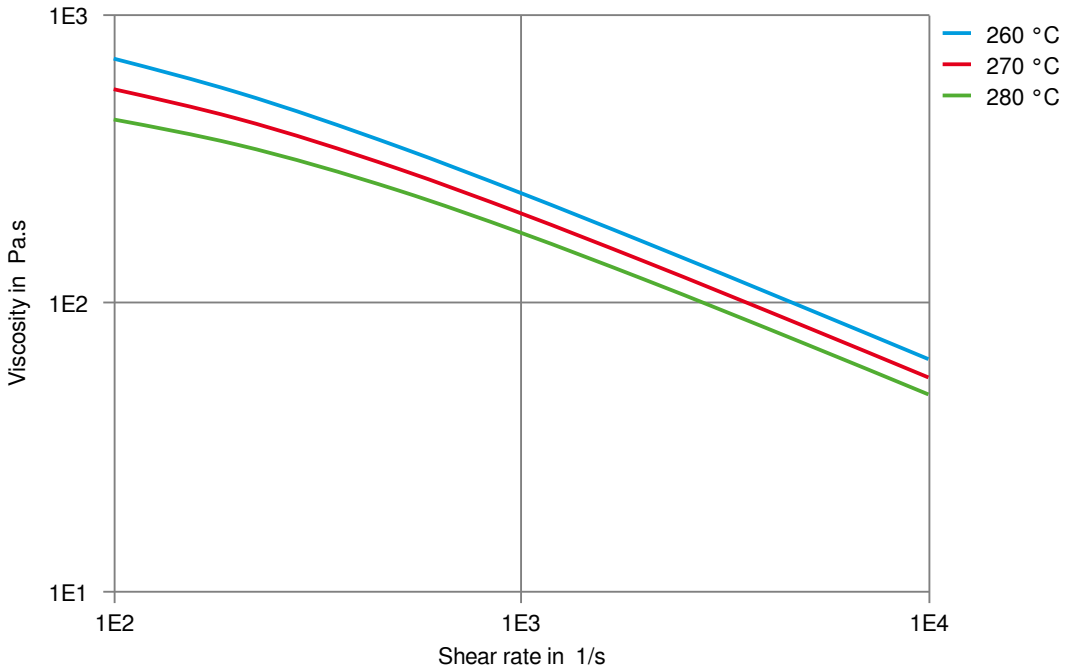
Viscosity-shear rate



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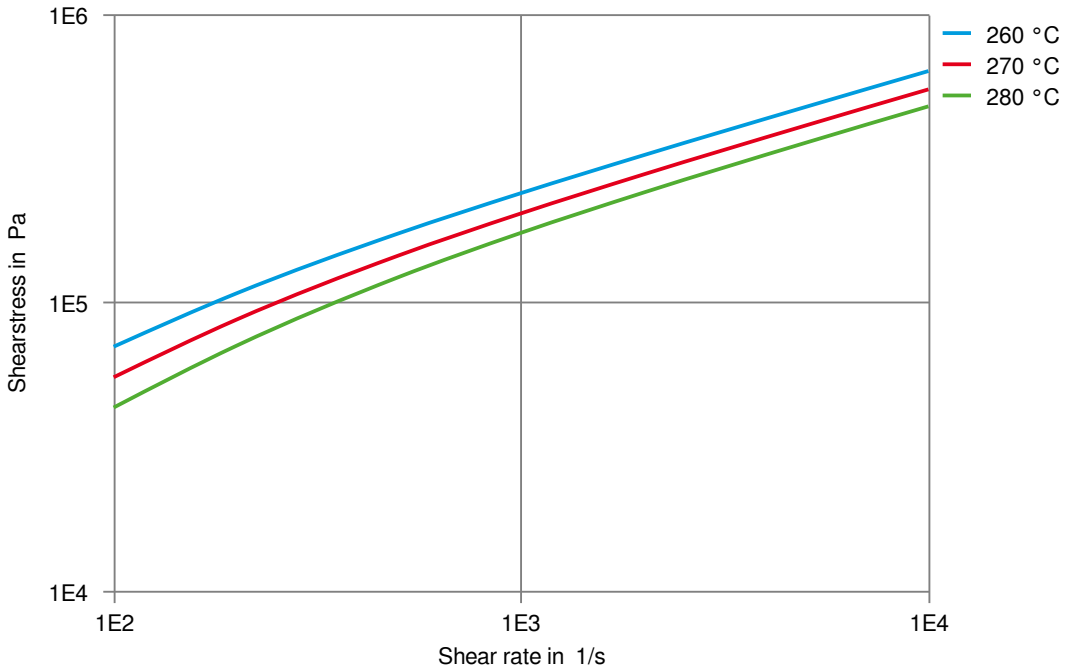
Shearstress-shear rate



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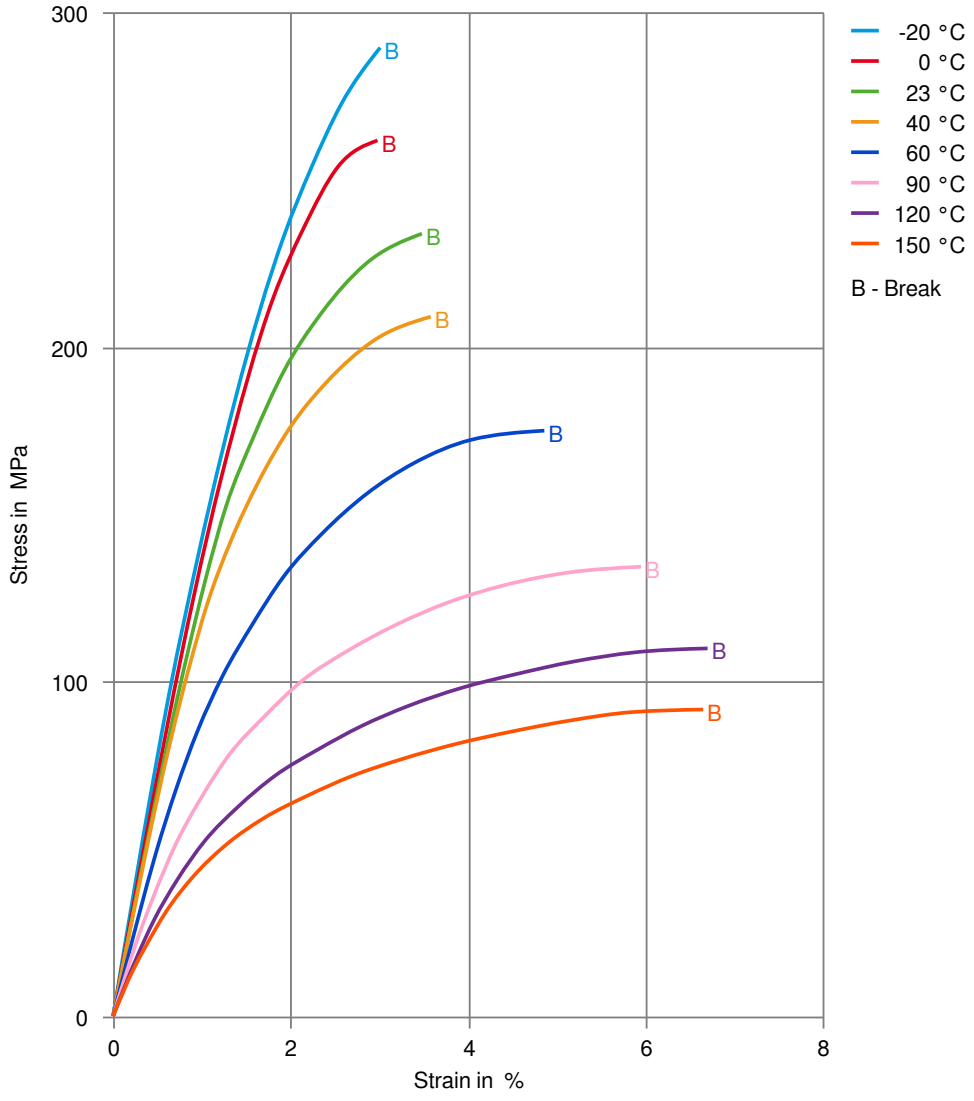
NYLON RESIN

Stress-strain (dry)
(measured on Zytel® 73G45L NC010)



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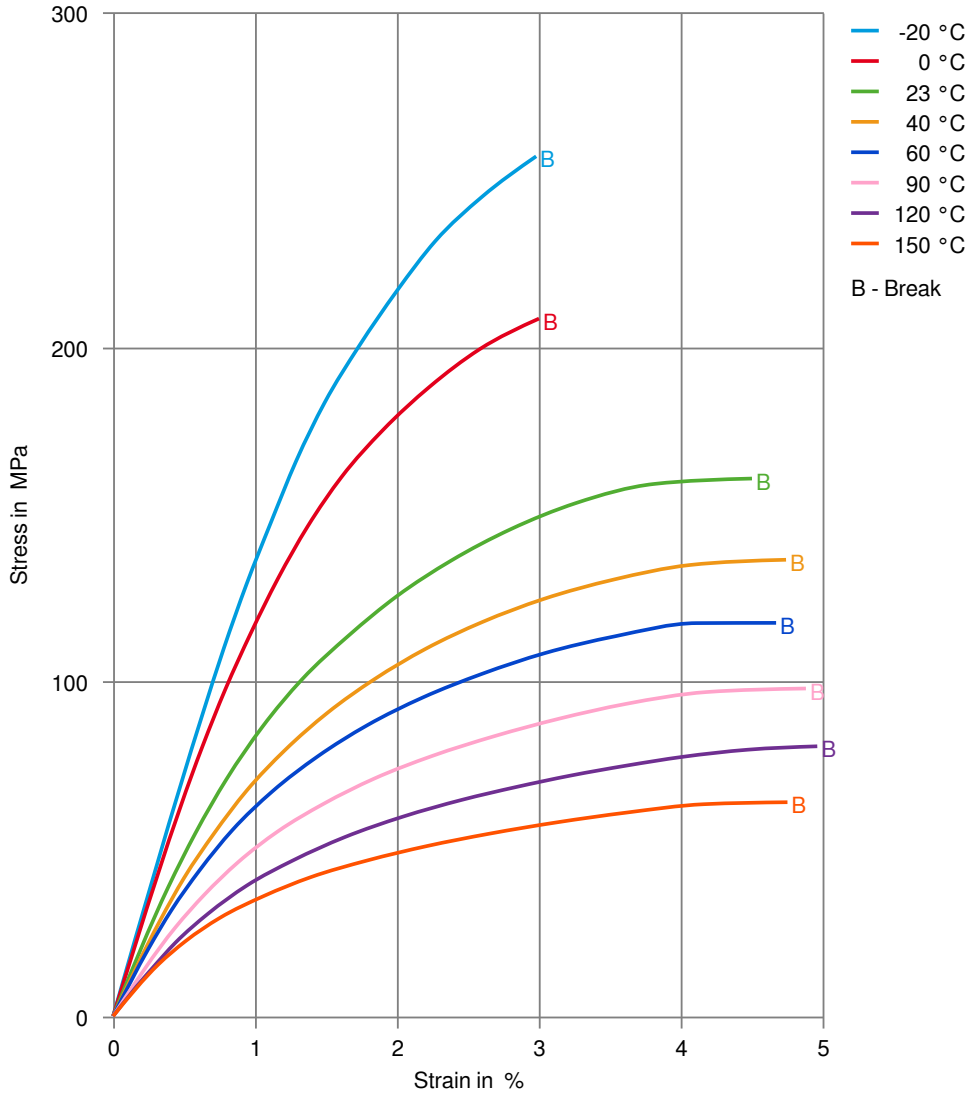
NYLON RESIN

Stress-strain (cond.)
(measured on Zytel® 73G45L NC010)



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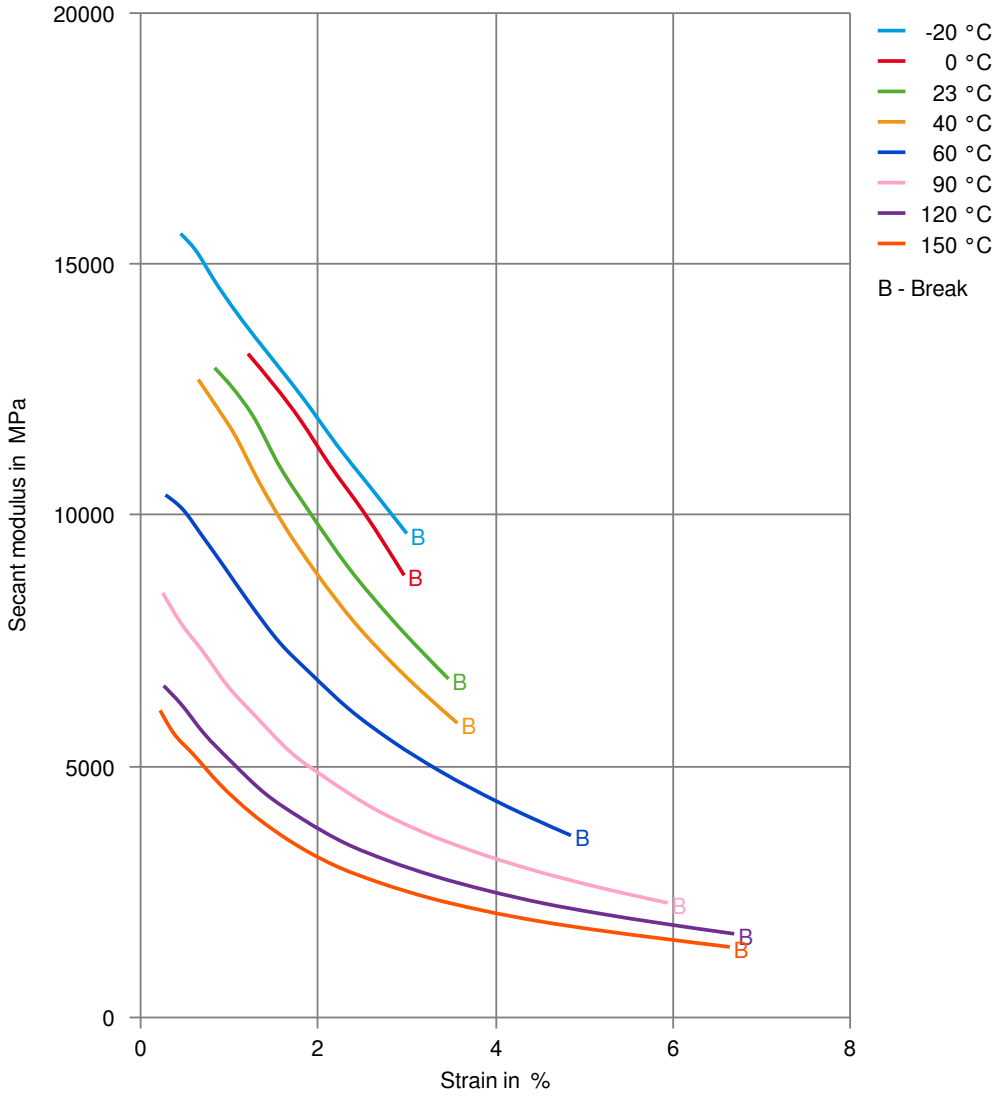
NYLON RESIN

Secant modulus-strain (dry)
(measured on Zytel® 73G45L NC010)



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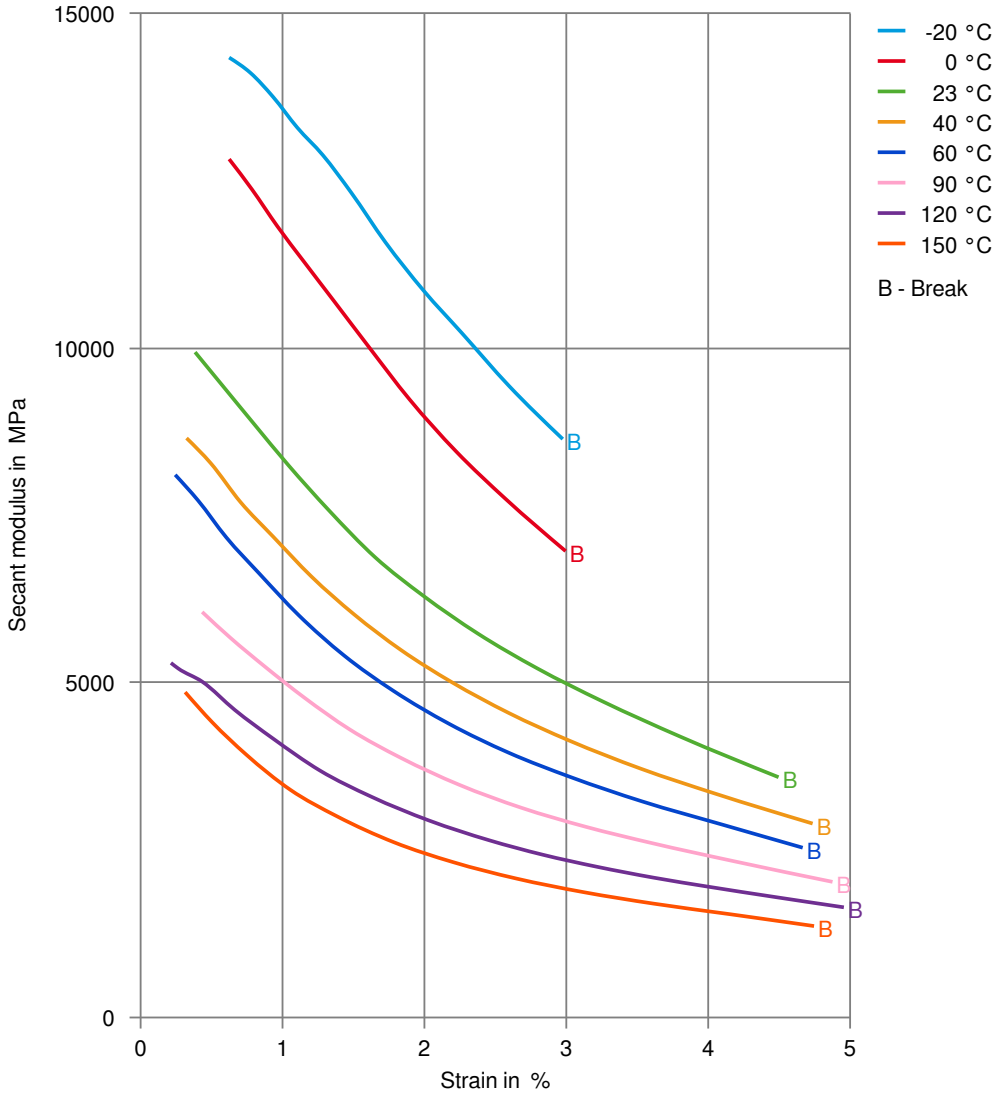
Secant modulus-strain (cond.)
(measured on Zytel® 73G45L NC010)



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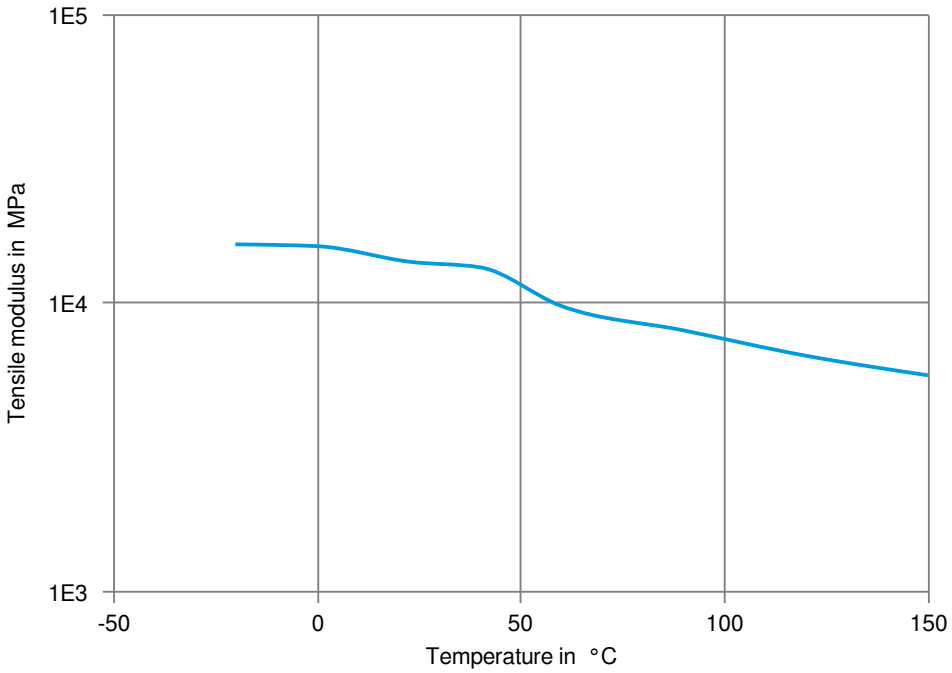
Tensile modulus-temperature (dry)
(measured on Zytel® 73G45L NC010)



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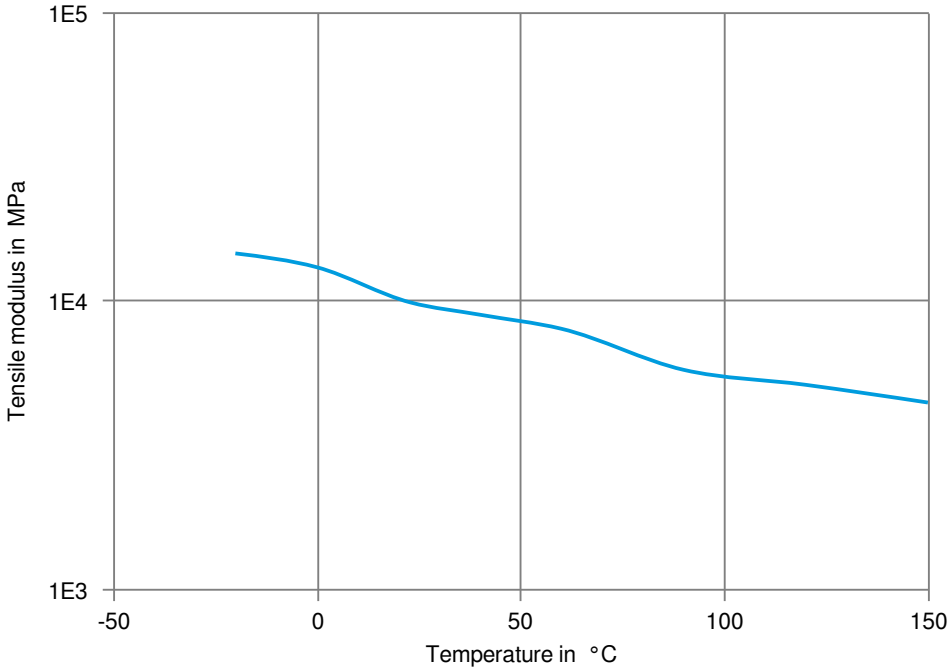
NYLON RESIN

Tensile modulus-temperature (cond.)
(measured on Zytel® 73G45L NC010)



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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).

Revised: 2025-04-30 Source: Celanese Materials Database