



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® 73G50HSLA BK416 is a 50% glass fiber reinforced, heat stabilised, lubricated, polyamide 6 resin for injection moulding. It has an excellent surface appearance and gloss.

Product information

Product information				
Resin Identification	PA6-GF50	ISO 1043 ISO 11469		
Part Marking Code		>PA6-GF50<		
ISO designation	ISO 16396-PA6,0	GF50,M1CGHR,S09-160		
Rheological properties	dry/cond.			
Moulding shrinkage, parallel	0.1/-	%	ISO 294-4, 2577	
Moulding shrinkage, normal	0.7/-	%	ISO 294-4, 2577	
Typical mechanical properties	dry/cond.			
Tensile modulus	16000/12000	MPa	ISO 527-1/-2	
Tensile stress at break, 5mm/min	230/150	MPa	ISO 527-1/-2	
Tensile strain at break, 5mm/min	2.2/4	%	ISO 527-1/-2	
Flexural modulus	15000/10000	MPa	ISO 178	
Flexural strength	400/240	MPa	ISO 178	
Flexural stress at 3.5%	-/225	MPa	ISO 178	
Tensile creep modulus, 1h	*/9500	MPa	ISO 899-1	
Tensile creep modulus, 1000h	*/7500	MPa	ISO 899-1	
Charpy impact strength, 23°C	100/100	kJ/m²	ISO 179/1eU	
Charpy impact strength, -30°C	100/90	kJ/m ²	ISO 179/1eU	
Charpy notched impact strength, 23°C	21/22	kJ/m ²	ISO 179/1eA	
Charpy notched impact strength, -30°C	19/18	kJ/m²	ISO 179/1eA	
Poisson's ratio	0.33/0.33			
Thermal properties	dry/cond.			
Melting temperature, 10°C/min	219/*	°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	212/*	°C	ISO 75-1/-2	
Temperature of deflection under load, 0.45 MPa	219/*	°C	ISO 75-1/-2	
Vicat softening temperature, 50°C/h 50N	215/*	°C	ISO 306	
Coefficient of linear thermal expansion (CLTE), parallel	15/*	E-6/K	ISO 11359-1/-2	

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Coefficient of linear thermal expansion (CLTE), normal	100/*	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.26	W/(m K)	ISO 22007-2
Specific heat capacity of melt	2050	J/(kg K)	ISO 22007-4
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
FMVSS Class	В		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	31	mm/min	ISO 3795 (FMVSS 302)
Electrical properties	dry/cond.		
Surface resistivity	*/5E12	Ohm	IEC 62631-3-2
Comparative tracking index	380/-		IEC 60112
Physical/Other properties	dry/cond.		
Humidity absorption, 2mm	1.6/*	%	Sim. to ISO 62
Water absorption, 2mm	4.5/*	%	Sim. to ISO 62
Density	1580/-	kg/m³	ISO 1183
Density of melt	1240	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	162	°C

Characteristics

Processing Injection Moulding

Delivery form Pellets

Additives Release agent

Special characteristics Heat stabilised or stable to heat

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Automotive

OEM STANDARD ADDITIONAL INFORMATION

General Motors GMW3029P-PA6-GF50H Black

Renault-Nissan AS25, No Spec, Special Part Approval, See

Your CE Account Manager.

Stellantis MS.50150 / PA6.GF50.14100F.15l.HS 01994_15_00059,

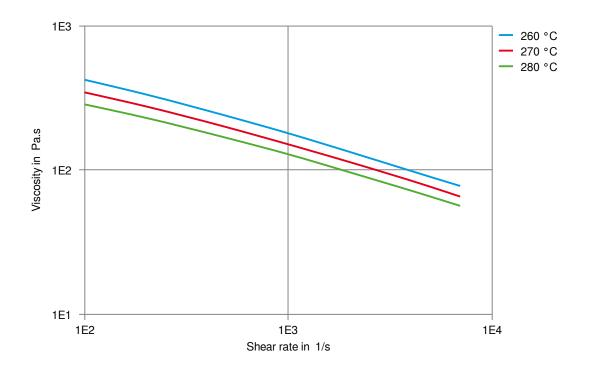
61/U4/AD1/O2/AB1*/E2/212M-214E/13/C1B

 VW Group
 TL 524 40-A PA6-GF50

 VW Group
 VW 50125 PA6-010

 VW Group
 VW 50134 PA6-10-A

Viscosity-shear rate

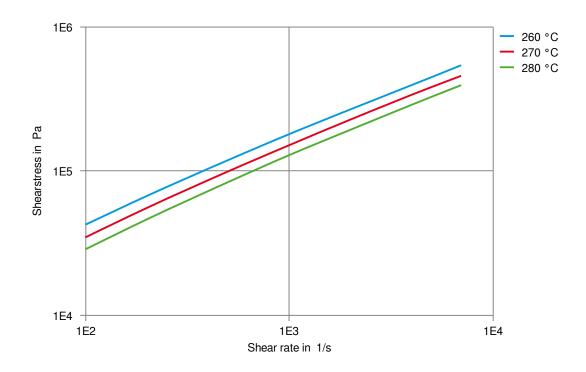


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Shearstress-shear rate

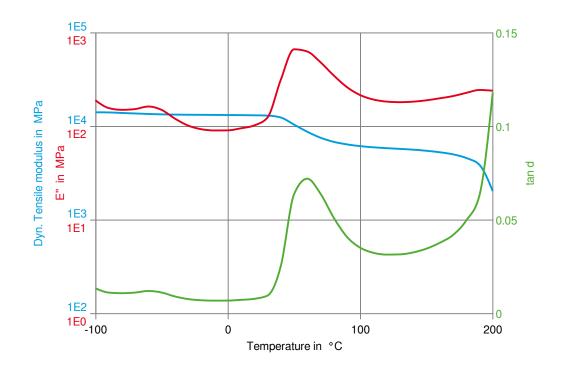


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Dynamic Tensile modulus-temperature (dry)

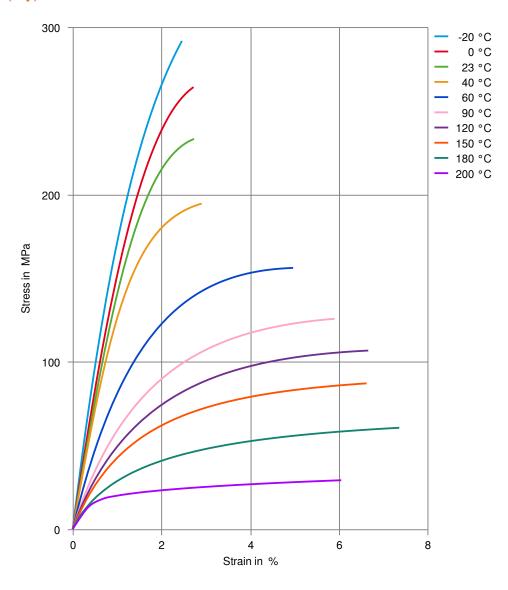


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Stress-strain (dry)

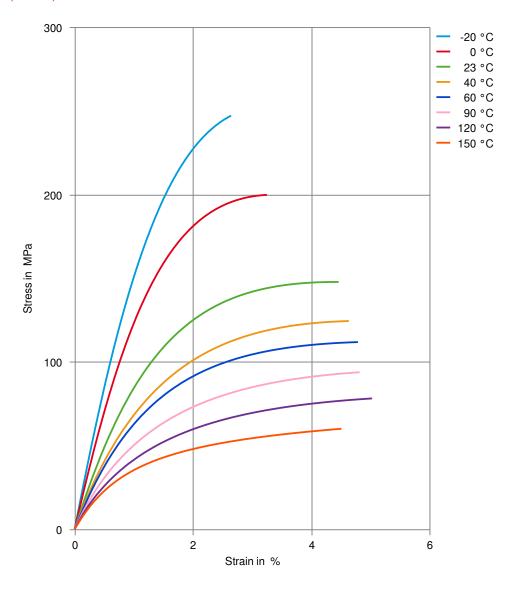


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Stress-strain (cond.)

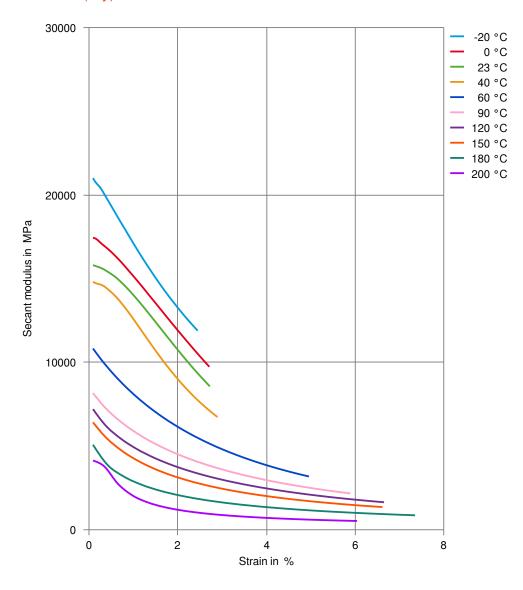


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Secant modulus-strain (dry)

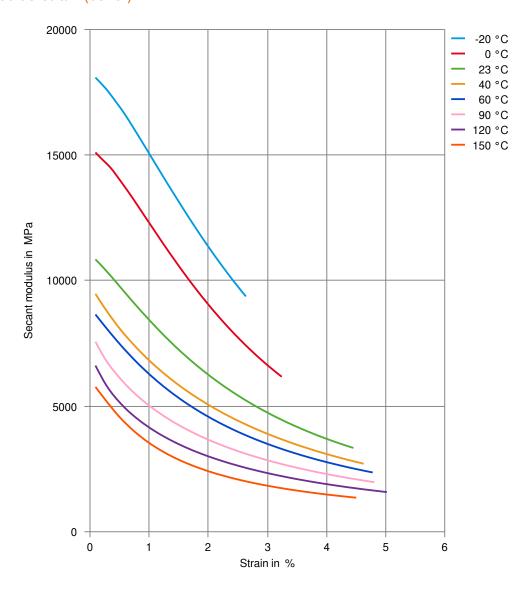


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Secant modulus-strain (cond.)

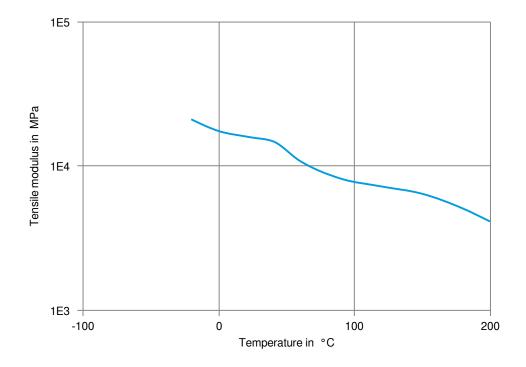


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Tensile modulus-temperature (dry)

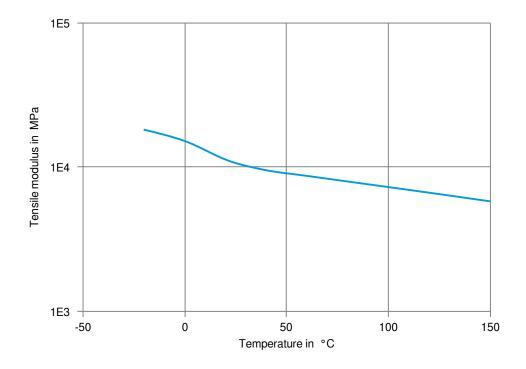


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Tensile modulus-temperature (cond.)



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Zytel® 73G50HSLA BK416

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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
- X Hydrochloric Acid (36% by mass), 23°C
- X Nitric Acid (40% by mass), 23°C
- X Sulfuric Acid (38% by mass), 23°C
- X Sulfuric Acid (5% by mass), 23°C
- X Chromic Acid solution (40% by mass), 23°C

Bases

- X 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
- X ISO 1817 Liquid 3 M3E7, 60°C
- X 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
- X Zinc Chloride solution (50% by mass), 23°C

Other

- ✓ Ethyl Acetate, 23°C
- X 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
- X 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).

x 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).

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Revised: 2025-05-23 Source: Celanese Materials Database

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users

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