Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

ISO 1043: PA6-HI

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® ST7301 BK356 is a Super Tough, heat stabilised, lubricated polyamide 6 resin for injection molding and extrusion. It offers outstanding impact resistance over a wide temperature and humidity range and high productivity.

Product information

Resin Identification	PA6-HI	ISO 1043
Part Marking Code	>PA6-HI<	ISO 11469
ISO designation	ISO 16396-PA6-I,,M1CG1HR,S14-020	

Rheological properties

	dry/cond.		
Melt mass-flow rate	6.5 / *	g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 / *	°C	
Melt mass-flow rate, Load	2.16 / *	kg	
Moulding shrinkage, parallel	1.3 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.3 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	1800 / 550	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	48 / 30	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	4 / 33	%	ISO 527-1/-2
Nominal strain at break	45 / >50	%	ISO 527-1/-2
Tensile strain at break, 50mm/min	>50 / >50	%	ISO 527-1/-2
Flexural modulus	1800 / 550	MPa	ISO 178
Charpy notched impact strength, 23°C	77 / 120	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	17 / 18	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40°C	16 / 14	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	57 / 95	kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	16.0 / 15.0	kJ/m²	ISO 180/1A
Izod notched impact strength, -40°C	13.0 / 12.0	kJ/m²	ISO 180/1A
Poisson's ratio	0.41 / 0.47		

Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

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	45 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	88 / *	°C	ISO 75-1/-2
TGA curve	available		ISO 11359-1/-2

Flammability

FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80	mm/min	ISO 3795 (FMVSS 302)

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2.7 / *	%	Sim. to ISO 62
Density	1060 / -	kg/m³	ISO 1183

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	≤0.3	m/s
Mold Temperature Optimum	70	°C
Min. mould temperature	50	°C
Max. mould temperature	90	°C
Hold pressure range	50 - 100	MPa
Hold pressure time	4	s/mm
Ejection temperature	140	°C

Extrusion

Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.06	%
Melt Temperature Optimum	240	°C
Melt Temperature Range	235 - 250	°C

Characteristics

Processing	Injection Moulding, Film Extrusion, Extrusion, Sheet Extrusion, Other Extrusion, Coatable, Casting
Special characteristics	High impact or impact modified

Celanese
The chemistry inside innovation™

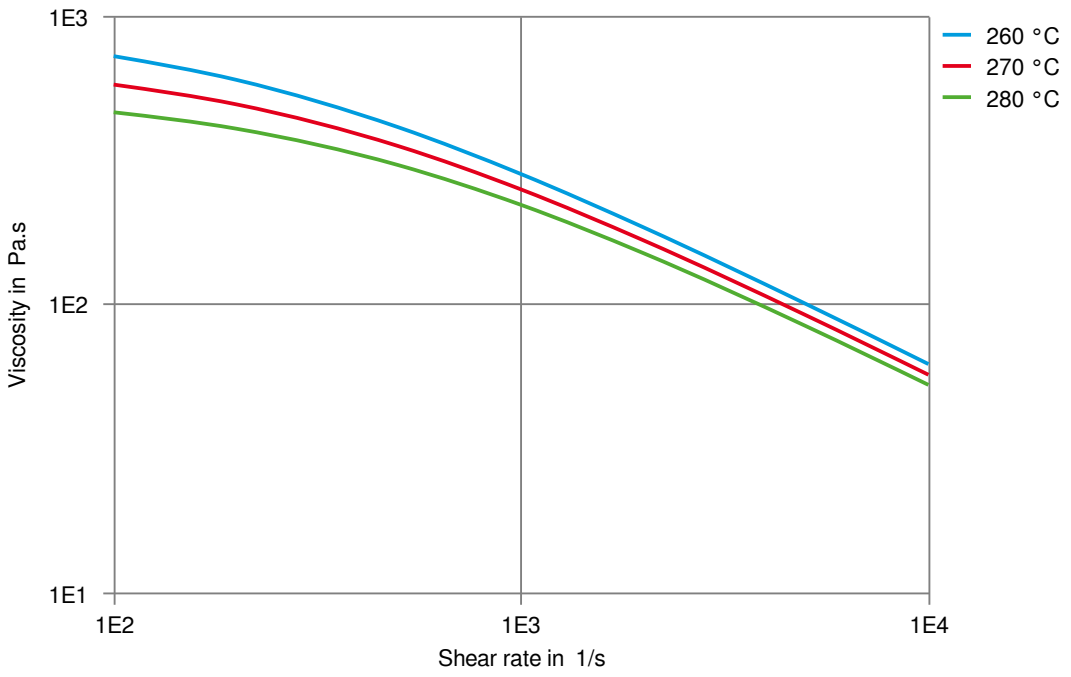
Zytel® ST7301 BK356

NYLON RESIN

Automotive

OEM	STANDARD
Mercedes-Benz	DBL5404.15 PA6-HI
Mercedes-Benz	DBL5410.01 PA6-I

Viscosity-shear rate (measured on Zytel® ST7301 NC010)

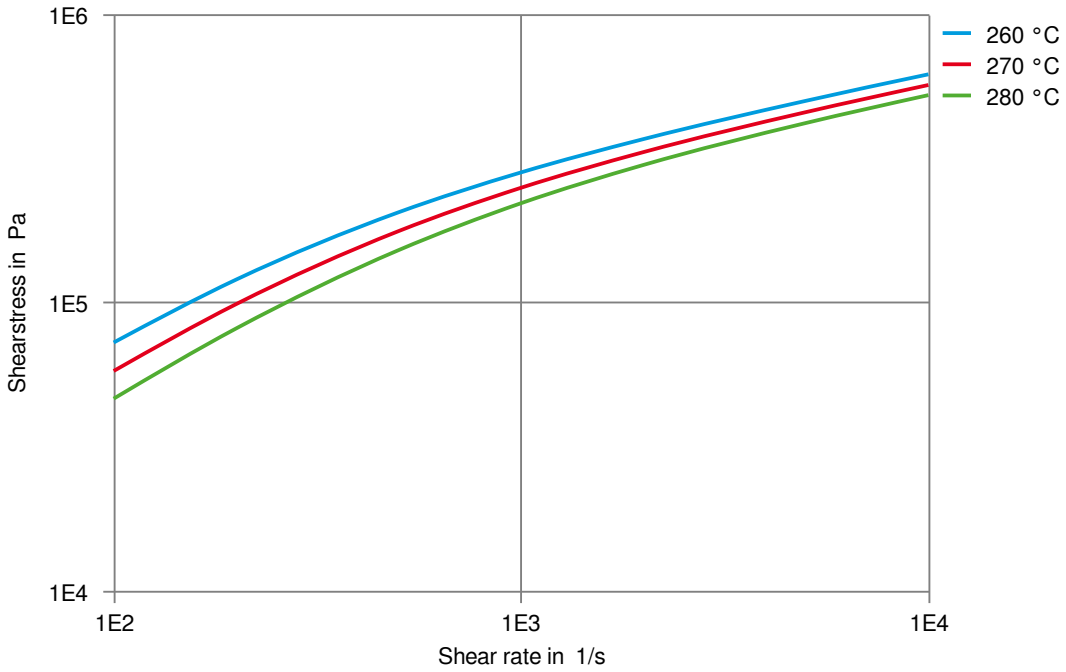


Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

Shearstress-shear rate
(measured on Zytel® ST7301 NC010)

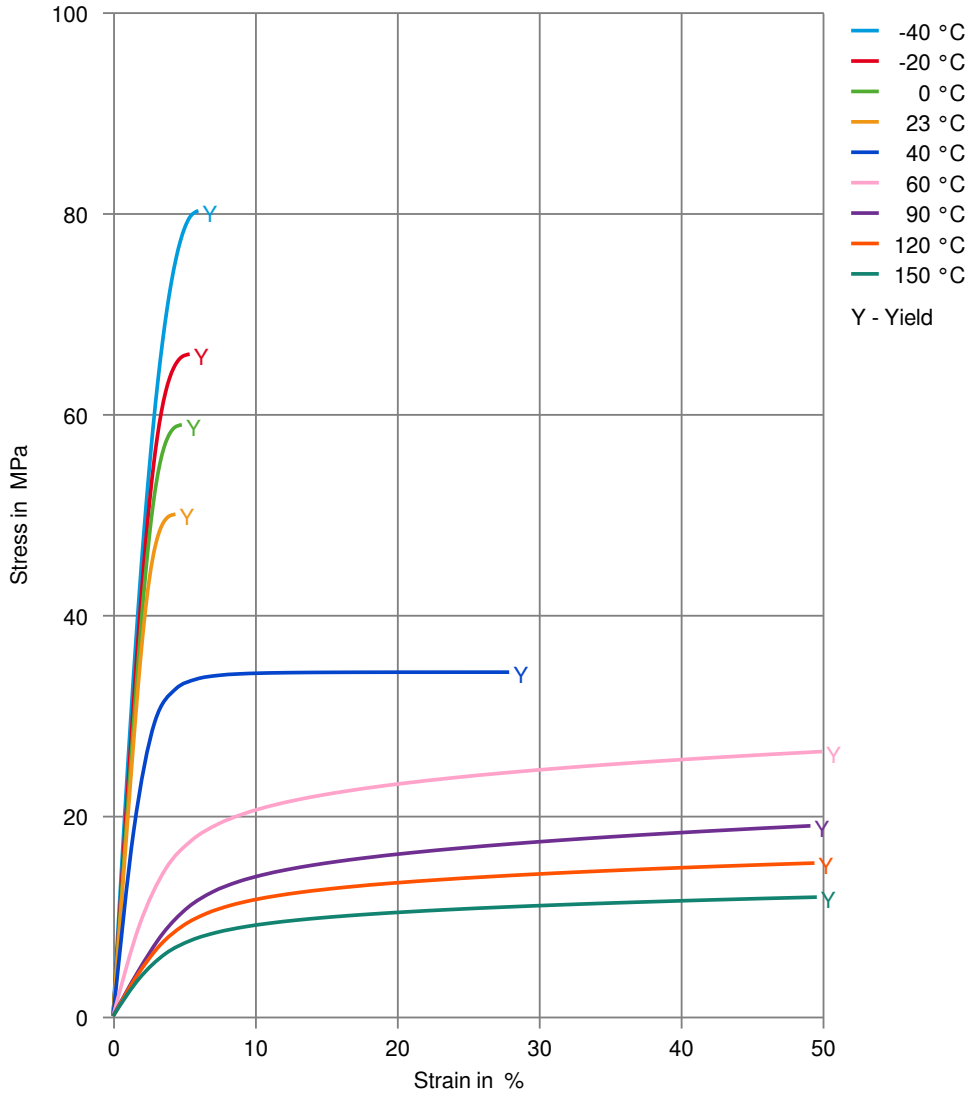


Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

Stress-strain (dry)

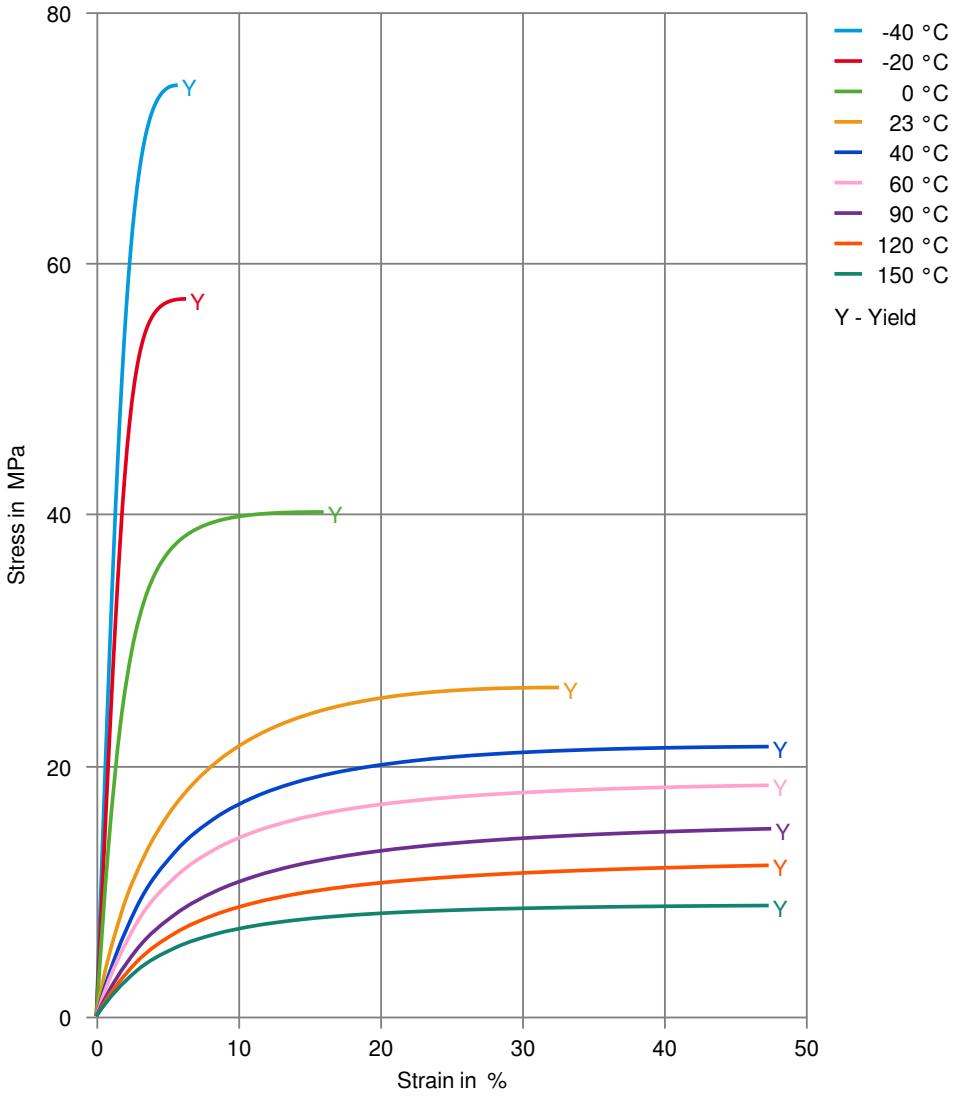


Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

Stress-strain (cond.)

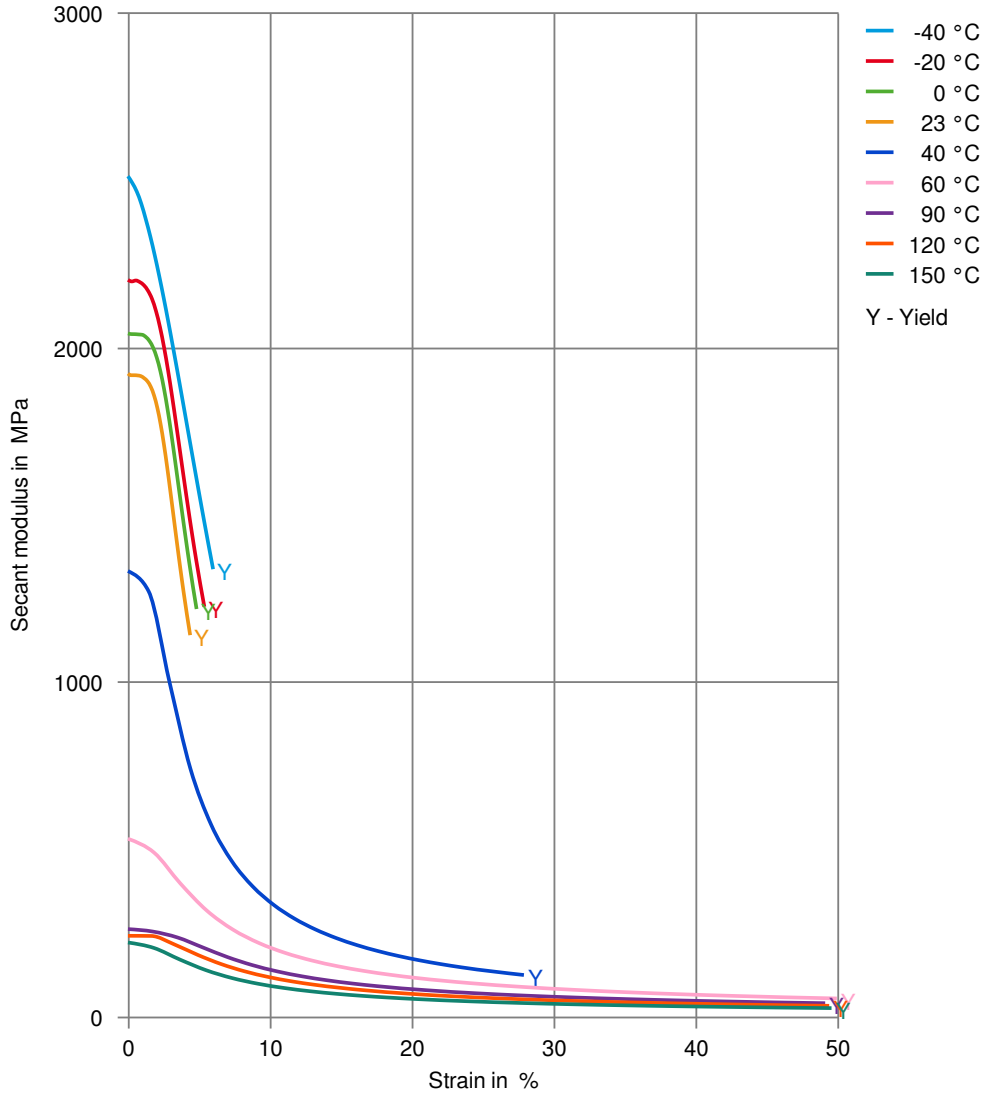


Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

Secant modulus-strain (dry)

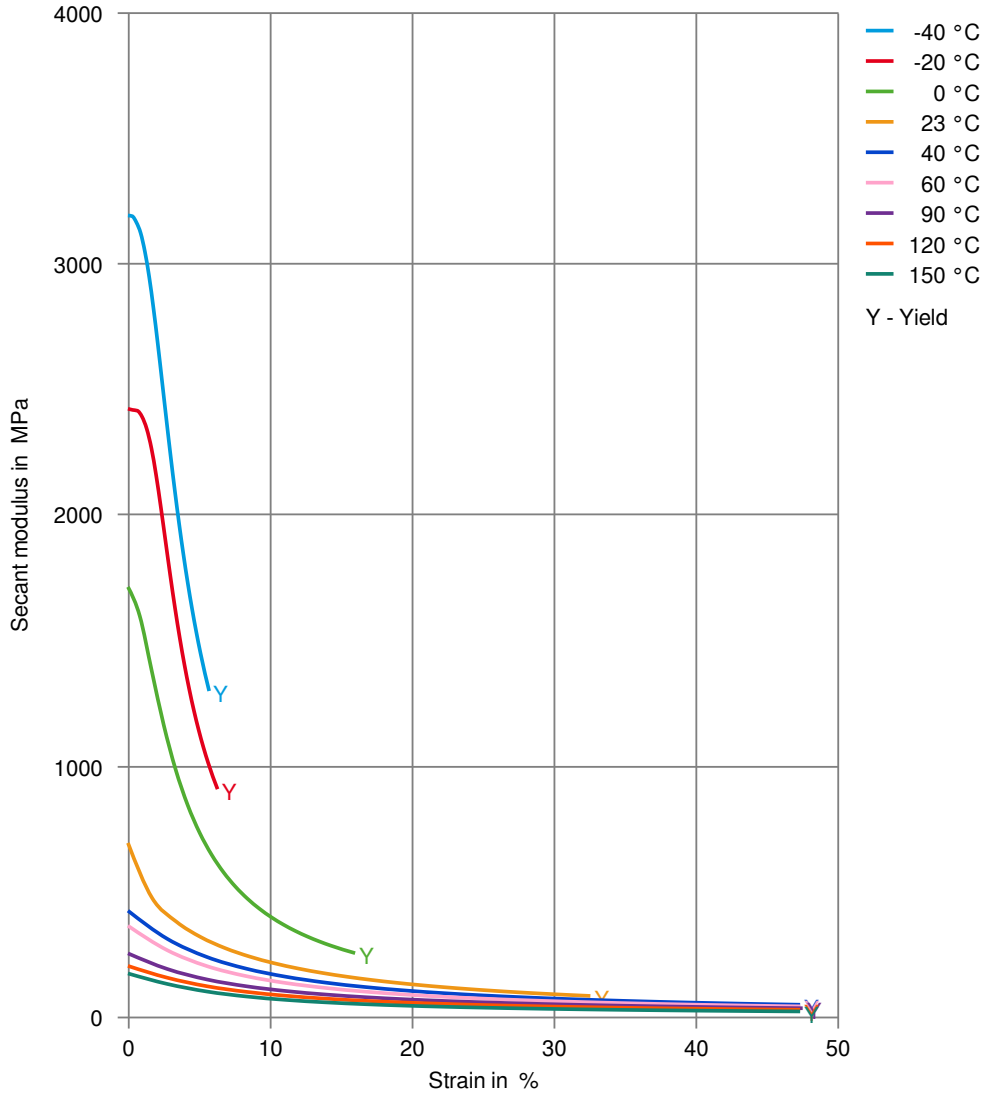


Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

Secant modulus-strain (cond.)

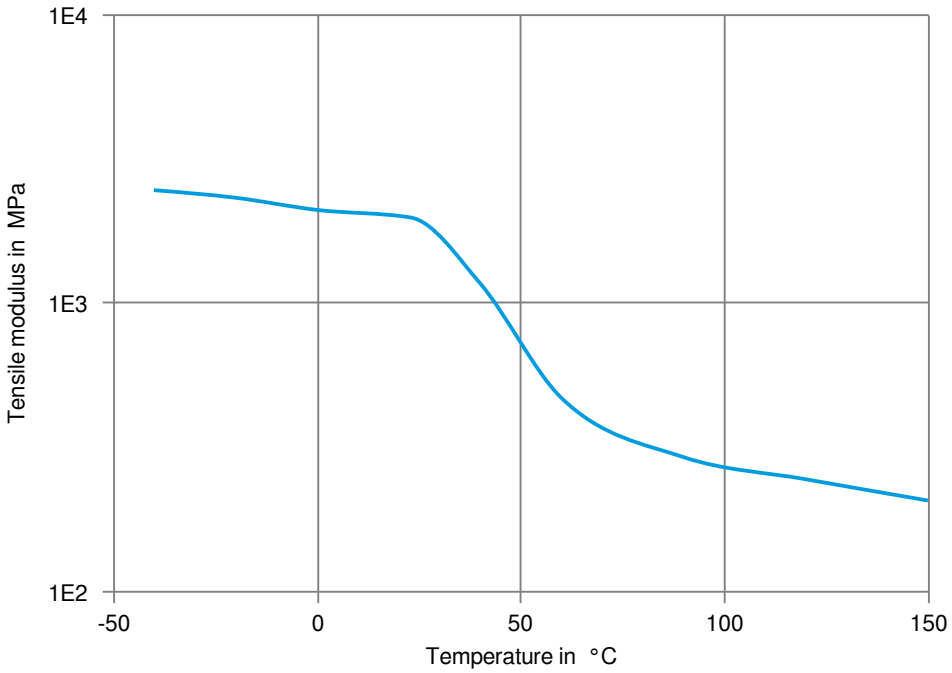


Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

Tensile modulus-temperature (dry)

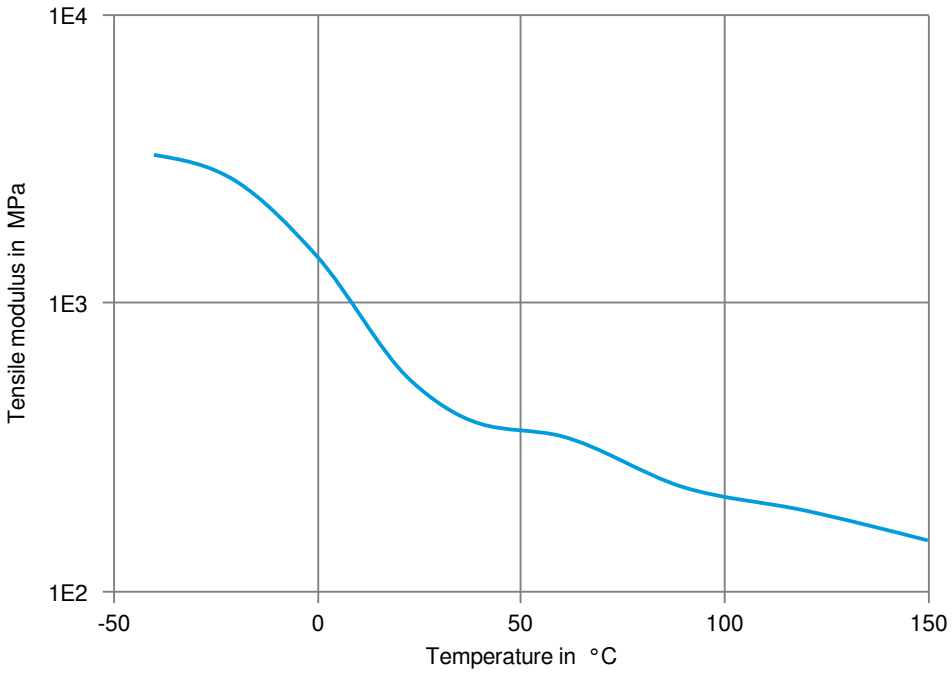


Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

Tensile modulus-temperature (cond.)



Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

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

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

Celanese
The chemistry inside innovation™

Zytel® ST7301 BK356

NYLON RESIN

- ✔ 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: 2025-04-23 Source: Celanese Materials Database