Zytel® 70K20HSL BK284

NYLON RESIN

DuPont Performance Polymers

Message:

20% Kevlar® Fiber Reinforced, Heat Stabilized, Polyamide 66

General Information	
Filler / Reinforcement	Kevlar Fiber, 20% filler by weight
Additive	heat stabilizer Lubricant demoulding
Features	Thermal Stability
RoHS Compliance	Contact manufacturer
Forms	Particle
Processing Method	Injection molding
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1) Secant Modulus vs. Strain (ISO 11403-1)
Part Marking Code (ISO 11469)	>PA66-RF20
Resin ID (ISO 1043)	PA66-RF20

Physical	Dry	Conditioned	Unit	Test Method
Density	1.19	--	g/cm³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	1.4	--	%	ISO 294-4
Flow	0.90	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C, 2.00mm	6.8	--	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	2.7	--	%	ISO 62

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5300	3500	MPa	ISO 527-2
Tensile Stress (Break)	110	85.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0	7.2	%	ISO 527-2

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	9.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	50	65	kJ/m²	ISO 179/1eU

Thermal	Dry	Conditioned	Unit	Test Method

Heat Deflection Temperature				
0.45 MPa, not annealed	255	--	°C	ISO 75-2/B
1.8 MPa, not annealed	222	--	°C	ISO 75-2/A
Glass Transition Temperature [1]	80.0	--	°C	ISO 11357-2
Vicat Softening Temperature	240	--	°C	ISO 306/B50
Melting Temperature [2]	263	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow	4.7E-5	--	cm/cm/°C	ISO 11359-2
Lateral	7.5E-5	--	cm/cm/°C	ISO 11359-2
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	--	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	1.0E+11	--	ohms·cm	IEC 60093
Dielectric Strength	23	--	kV/mm	IEC 60243-1
Dissipation Factor				IEC 60250
100 Hz	0.014	--		IEC 60250
1 MHz	0.014	--		IEC 60250
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate [3] (1.00 mm)	< 100	--	mm/min	ISO 3795
FMVSS Flammability	B	--		FMVSS 302
Melt Temperature, Optimum	295		°C	
Mold Temperature, Optimum	100		°C	
Back Pressure	As low as possible			
Drying Recommended	yes			
Hold Pressure Time	3.00		s/mm	
Maximum Screw Tangential Speed	200		mm/sec	
Fill Analysis	Dry	Conditioned	Unit	
Ejection Temperature	210	--	°C	
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time - Desiccant Dryer	2.0 - 4.0		hr	
Suggested Max Moisture	0.20		%	
Processing (Melt) Temp	285 - 305		°C	
Mold Temperature	70 - 120		°C	
Holding Pressure	50.0 - 100		MPa	
NOTE				
1.	10°C/min			
2.	10°C/min			

3.	FMVSS 302

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