

Zytel® 70G35EF BK538

NYLON RESIN

DuPont Performance Polymers

Message:

35% Glass Reinforced, Heat Stabilized, Polyamide 66

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 35% filler by weight		
Additive		heat stabilizer		
		demoulding		
Features		Thermal Stability		
RoHS Compliance		Contact manufacturer		
Forms		Particle		
Processing Method		Injection molding		
Multi-Point Data		Creep Modulus vs. Time (ISO 11403-1)		
		Isochronous Stress vs. Strain (ISO 11403-1)		
		Isothermal Stress vs. Strain (ISO 11403-1)		
		Secant Modulus vs. Strain (ISO 11403-1)		
		Shear Stress vs. Shear Rate (ISO 11403-1)		
		Tensile Modulus vs. Temperature (ISO 11403-1)		
		Viscosity vs. Shear Rate (ISO 11403-2)		
Part Marking Code (ISO 11469)		>PA66+PA6-GF35		
Resin ID (ISO 1043)		PA66+PA6-GF35		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.40	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	1.0	--	%	ISO 294-4
Flow	0.40	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C, 2.00mm	5.5	--	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	1.7	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	11000	8500	MPa	ISO 527-2
Tensile Stress (Break)	200	140	MPa	ISO 527-2
Tensile Strain (Break)	2.8	4.6	%	ISO 527-2
Flexural Modulus	9500	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method

Charpy Notched Impact Strength				ISO 179/1eA
-40°C	9.0	--	kJ/m ²	ISO 179/1eA
-30°C	9.0	--	kJ/m ²	ISO 179/1eA
23°C	10	--	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)				ISO 180/1A
	10	--	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
1.8 MPa, not annealed	250	--	°C	ISO 75-2/A
8.0 MPa, not annealed	110	--	°C	ISO 75-2/C
Glass Transition Temperature ¹				
	80.0	20.0	°C	ISO 11357-2
Vicat Softening Temperature				
	255	--	°C	ISO 306/B50
Melting Temperature ²				
	260	--	°C	ISO 11357-3
Linear thermal expansion coefficient				
				ISO 11359-2
Flow	1.7E-5	--	cm/cm/°C	ISO 11359-2
Lateral	8.5E-5	--	cm/cm/°C	ISO 11359-2
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+14	1.0E+11	ohms · cm	IEC 60093
Dielectric Strength	36	31	kV/mm	IEC 60243-1
Comparative Tracking Index				
	575	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate ³ (1.00 mm)	< 100	--	mm/min	ISO 3795
Flame Rating				
				UL 94, IEC 60695-11-10, -20
0.70 mm	HB	--		UL 94, IEC 60695-11-10, -20
1.5 mm	HB	--		UL 94, IEC 60695-11-10, -20
Oxygen Index	24	--	%	ISO 4589-2
FMVSS Flammability	B	--		FMVSS 302
Specific Heat Capacity of Melt				
	2130	--	J/kg/°C	
Thermal Conductivity of Melt				
	0.24	--	W/m/K	
Melt Temperature, Optimum				
	295		°C	
Mold Temperature, Optimum				
	100		°C	
Drying Recommended				
	yes			
Hold Pressure Time				
	3.00		s/mm	

Maximum Screw Tangential Speed	200		mm/sec
Fill Analysis	Dry	Conditioned	Unit
Melt Density	1.24	--	g/cm ³
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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