

Zytel® FG7301 NC010

NYLON RESIN
DuPont Performance Polymers

Message:
Unreinforced Polyamide 6

General Information				
RoHS Compliance		Contact manufacturer		
Forms		Particle		
Processing Method		Film extrusion		
		Extrusion		
		Sheet extrusion molding		
		Coating		
		Profile extrusion molding		
		Injection molding		
Part Marking Code (ISO 11469)		>PA6		
Resin ID (ISO 1043)		PA6		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturated, 23°C, 2.00mm	9.5	--	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	3.0	--	%	ISO 62
Viscosity Number	150	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2900	1500	MPa	ISO 527-2
Tensile Stress (Yield)	80.0	--	MPa	ISO 527-2
Tensile Strain (Yield)	4.5	--	%	ISO 527-2
Nominal Tensile Strain at Break	25	--	%	ISO 527-2
Flexural Modulus	2300	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	--	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-40°C	No Break	--		ISO 179/1eU
-30°C	No Break	--		ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU
Notched Izod Impact				ISO 180/1A

-40°C	6.0	--	kJ/m ²	ISO 180/1A
23°C	6.0	--	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	--	No Break		ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	160	--	°C	ISO 75-2/B
1.8 MPa, not annealed	55.0	--	°C	ISO 75-2/A
Melting Temperature ¹	221	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow	7.0E-5	--	cm/cm/°C	ISO 11359-2
Lateral	1.0E-4	--	cm/cm/°C	ISO 11359-2
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+15	--	ohms · cm	IEC 60093
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate ² (1.00 mm)	< 100	--	mm/min	ISO 3795
FMVSS Flammability	B	--		FMVSS 302
Melt Temperature, Optimum	270		°C	
Mold Temperature, Optimum	70		°C	
Drying Recommended	yes			
Hold Pressure Time	4.00		s/mm	
Maximum Screw Tangential Speed	200		mm/sec	
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time - Desiccant Dryer	2.0 - 4.0		hr	
Suggested Max Moisture	0.20		%	
Processing (Melt) Temp	260 - 280		°C	
Mold Temperature	50 - 90		°C	
Holding Pressure	50.0 - 100		MPa	
NOTE				
1.	10°C/min			
2.	FMVSS 302			

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