

Zytel® PLUS PLS93G35DH1 BK549

NYLON RESIN
DuPont Performance Polymers

Message:
35% Glass Reinforced, Heat Stabilized, Polyamide 6

General Information				
Filler / Reinforcement		Glass Fiber,35% Filler by Weight		
Additive		Heat Stabilizer		
		Mold Release		
Features		Heat Stabilized		
Forms		Pellets		
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)		
		Specific Volume vs Temperature (ISO 11403-2)		
		Tensile Modulus vs. Temperature (ISO 11403-1)		
		Tensile Modulus vs. Temperature, Dynamic (ISO 11403-1)		
		Viscosity vs. Shear Rate (ISO 11403-2)		
Part Marking Code (ISO 11469)		>PA6-GF35<		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.40	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.70	--	%	
Flow	0.20	--	%	
Water Absorption (23°C, 24 hr, 2.00 mm)	2.0	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	12000	6500	MPa	ISO 527-2
Tensile Stress (Break)	200	120	MPa	ISO 527-2
Tensile Strain (Break)	3.5	7.0	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	13	--	kJ/m ²	
23°C	15	--	kJ/m ²	

Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	80	80	kJ/m ²	
23°C	100	90	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	220	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	212	--	°C	ISO 75-2/A
Melting Temperature ¹	224	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	7.0E-6	--	cm/cm/°C	
Transverse	1.0E-4	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	--	6.0E+13	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	7.0E+13	ohms·cm	IEC 60093
Comparative Tracking Index	550	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification (1.50 mm)	HB	--		IEC 60695-11-10, -20
Fill Analysis	Dry	Conditioned	Unit	
Melt Density	1.24	--	g/cm ³	
Specific Heat Capacity of Melt	2100	--	J/kg/°C	
Thermal Conductivity of Melt	0.28	--	W/m/K	
NOTE				
1.	10°C/min			

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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