

Zytel® 73G30TGI BK267

NYLON RESIN
DuPont Performance Polymers

Message:
30% Glass Reinforced, Toughened, Polyamide 6

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight			
RoHS Compliance	Contact manufacturer			
Forms	Particle			
Processing Method	Injection molding			
Multi-Point Data	Shear Modulus vs. Temperature, Dynamic (ISO 11403-1)			
Part Marking Code (ISO 11469)	>PA6-GF30			
Resin ID (ISO 1043)	PA6-GF30			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.35	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 294-4
Transverse flow	1.0	--	%	ISO 294-4
Flow	0.20	--	%	ISO 294-4
Water Absorption ²				ISO 62
Saturated, 23°C, 2.00mm	6.2	--	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	1.8	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ³	9500	6000	MPa	ISO 527-2
Tensile Stress ⁴ (Break)	160	90.0	MPa	ISO 527-2
Tensile Strain ⁵ (Break)	3.3	5.0	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength ⁶				ISO 179/1eA
-30°C	10	24	kJ/m ²	ISO 179/1eA
23°C	14	18	kJ/m ²	ISO 179/1eA
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	210	--	°C	ISO 75-2/B
1.8 MPa, not annealed	206	--	°C	ISO 75-2/A
Vicat Softening Temperature	210	--	°C	ISO 306/B50
Melting Temperature ⁷	220	--	°C	ISO 11357-3
Linear thermal expansion coefficient ⁸				ISO 11359-2

Flow	3.0E-5	--	cm/cm/°C	ISO 11359-2
Lateral	1.2E-4	--	cm/cm/°C	ISO 11359-2
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate ⁹ (1.00 mm)	< 100	--	mm/min	ISO 3795
Flammability Classification ¹⁰ (1.5 mm)	HB	--		IEC 60695-11-10, -20
FMVSS Flammability	B	--		FMVSS 302
Specific Heat Capacity of Melt ¹¹	2200	--	J/kg/°C	
Thermal Conductivity of Melt ¹²	0.23	--	W/m/K	
Melt Temperature, Optimum	270		°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 ¹³	1.31	--	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	260 - 280		°C	
Mold Temperature	70 - 120		°C	
Holding Pressure	50.0 - 100		MPa	
NOTE				
1.	from 73G300T, Assessed			
2.	from 73G300T, Assessed			
3.	from 73G300T, Assessed			
4.	from 73G30T, Derived from Similar Grade, Calculated			
5.	from 73G300T, Assessed			
6.	from 73G30T, Derived from Similar Grade			
7.	10°C/min			
8.	from 73G300T, Assessed			
9.	FMVSS 302			
10.	from 73G300T, Assessed			
11.	from 73G300T, Assessed			
12.	from 73G300T, Assessed			

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