

Common features of Zytel® nylon resin include mechanical and physical properties such as high mechanical strength, excellent balance of stiffness and toughness, good high temperature performance, good electrical and flammability properties, good abrasion and chemical resistance. In addition, Zytel® nylon resins are available in different modified and reinforced grades to create a wide range of products with tailored properties for specific processes and end-uses. Zytel® nylon resin, including most flame retardant grades, offer the ability to be coloured.

The good melt stability of Zytel® nylon resin normally enables the recycling of properly handled production waste. If recycling is not possible, we recommend, as the preferred option, incineration with energy recovery (-31kJ/g of base polymer) in appropriately equipped installations. For disposal, local regulations have to be observed.

Zytel® nylon resin typically is used in demanding applications in the automotive, furniture, domestic appliances, sporting goods and construction industry.

Zytel® 70G33HS1L NC010 is a 33% glass fiber reinforced, heat stabilized polyamide 66 resin for injection moulding.

Product information

Resin Identification Part Marking Code ISO designation	PA66-GF33 >PA66-GF33< ISO 16396-PA66	,GF33,M1GHNR,S14-1	ISO 1043 ISO 11469 10
Rheological properties	dry/cond.		
Viscosity number	153/*	cm ³ /g	ISO 307, 1628
Moulding shrinkage, parallel	0.3/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.1/-	%	ISO 294-4, 2577
Typical mechanical properties	dry/cond.		
Tensile modulus	11000/8000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	200/140	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5/5	%	ISO 527-1/-2
Flexural modulus	9500/6000	MPa	ISO 178
Flexural strength	290/200	MPa	ISO 178
Tensile creep modulus, 1h	*/8000	MPa	ISO 899-1
Tensile creep modulus, 1000h	*/5500	MPa	ISO 899-1
Charpy impact strength, 23°C	85/100	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	70/75	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	13/17	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	10/10	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40°C	10/10	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	12/15	kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	10.0/10.0	kJ/m²	ISO 180/1A
Izod notched impact strength, -40°C	10.0/10.0	kJ/m²	ISO 180/1A
Izod impact strength, 23°C	80/90	kJ/m²	ISO 180/1U
Izod impact strength, -30°C	70/70	kJ/m²	ISO 180/1U
Hardness, Rockwell, M-scale	101/-		ISO 2039-2
Ball indentation hardness, H 961/30	280/-	MPa	ISO 2039-1
Poisson's ratio	0.34/0.34		



NYLON RESIN

Thermal properties	dry/cond.		
Melting temperature, 10°C/min	262/*	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	80/20	°Č	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	252/*	°Č	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	261/*	°Č	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel, -40-23°C	24/*	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion	18/*	E-6/K	ISO 11359-1/-2
(CLTE), parallel	10,	20/10	
Coeff. of linear therm. expansion, parallel, 55-160°C	13/*	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	65/*	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE),	83/*	E-6/K	ISO 11359-1/-2
normal		_ 0,	
Coefficient of linear thermal expansion	140/*	E-6/K	ISO 11359-1/-2
(CLTE), normal, 55-160°C			
Thermal conductivity of melt	0.22	W/(mK)	ISO 22007-2
Specific heat capacity of melt	2210	J/(kg K)	ISO 22007-4
Specific heat capacity solid	1330	J/(kg K)	ISO 22007-4
RTI, electrical, 0.75mm	140	°Ċ	UL 746B
RTI, electrical, 1.5mm	140	°C	UL 746B
RTI, electrical, 3.0mm	140	°C	UL 746B
RTI, impact, 0.75mm	125	°C	UL 746B
RTI, impact, 1.5mm	125	°C	UL 746B
RTI, impact, 3.0mm	125	°C	UL 746B
RTI, strength, 0.75mm	140	°C	UL 746B
RTI, strength, 1.5mm	140/*	°C	UL 746B
RTI, strength, 3.0mm	140	°C	UL 746B
Flammability	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB/*	class	IEC 60695-11-10
Thickness tested	1.5/*	mm	IEC 60695-11-10
UL recognition	yes/*		UL 94
Burning Behav. at thickness h	, HB/*	class	IEC 60695-11-10
Thickness tested	0.75/*	mm	IEC 60695-11-10
UL recognition	yes/*		UL 94
Oxygen index	24/*	%	ISO 4589-1/-2
Glow Wire Flammability Index, 0.75mm	725/-	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	700/-	°C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	800/-	°C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	750/-	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	725/-	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3.0mm	825/-	°C	IEC 60695-2-13
FMVSS Class	SE/B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28	mm/min	ISO 3795 (FMVSS 302)



Electrical properties	dry/cond.		
Relative permittivity, 100Hz Relative permittivity, 1MHz Dissipation factor, 100Hz	4.2/- 4/- 100/-	E-4	IEC 62631-2-1 IEC 62631-2-1 IEC 62631-2-1
Dissipation factor, 1MHz	150/-	E-4	IEC 62631-2-1
Volume resistivity Surface resistivity	1E13/1E9 */1E15	Ohm.m Ohm	IEC 62631-3-1 IEC 62631-3-2
Electric strength	46/38	kV/mm	IEC 60243-1
Comparative tracking index	400/-		IEC 60112
Comparative tracking index, 3.0mm	1/-	PLC	UL 746A
Electric Strength, Short Time, 1mm	37/-	kV/mm	IEC 60243-1
Physical/Other properties	dry/cond.		
Humidity absorption, 2mm	1.8/*	%	Sim. to ISO 62
Water absorption, 2mm	5.7/*	%	Sim. to ISO 62
Water absorption, Immersion 24h	1.2/* 1390/-	% kg/m³	Sim. to ISO 62
Density	13907-	kg/m²	ISO 1183
VDA Properties	dry/cond.		
Emission of organic compounds	6	µgC/g	VDA 277
Odour	4.5	class	VDA 270
Fogging, F-value (refraction) Fogging, G-value (condensate)	95/* 0.3/*	% mg	ISO 6452 ISO 6452
r ogging, a value (concentrate)	0.07	ing	100 0 102
Injection			
Drying Recommended	yes		
Drying Temperature Drying Time, Dehumidified Dryer	80 °C		
Processing Moisture Content	2-4 h ≤0.2 %		
Melt Temperature Optimum	≤0.2 % 295 °C		
Min. melt temperature	285	°C	
Max. melt temperature	305		
Screw tangential speed	≤0.2		
Mold Temperature Optimum Min. mould temperature		°C °C	
Max. mould temperature	120		
Hold pressure range	50 - 100		
Hold pressure time	3	s/mm	
Ejection temperature	210	°C	
Characteristics			

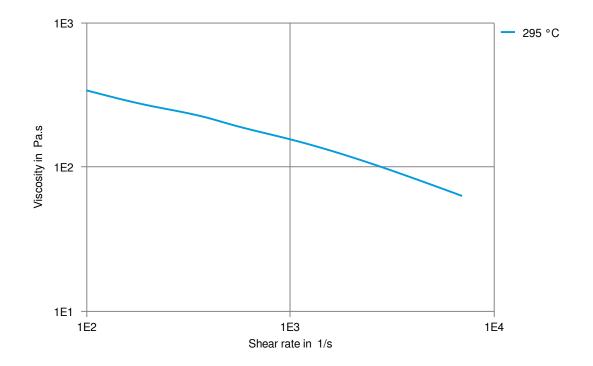
Characteristics

Additives

Release agent

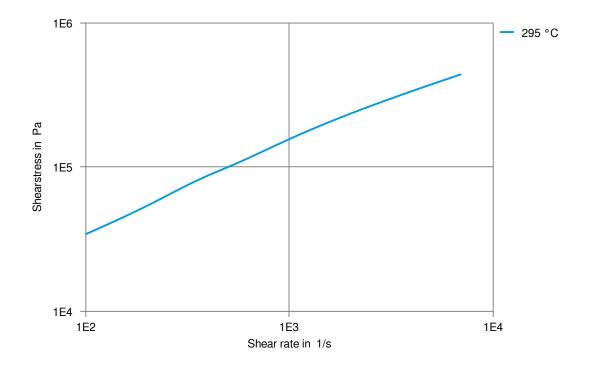


Viscosity-shear rate



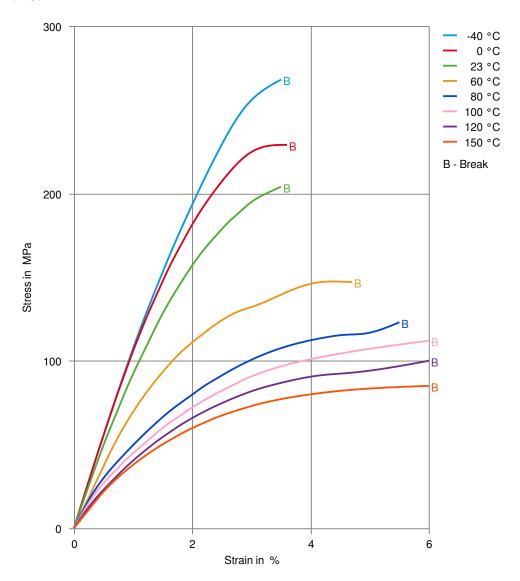


Shearstress-shear rate



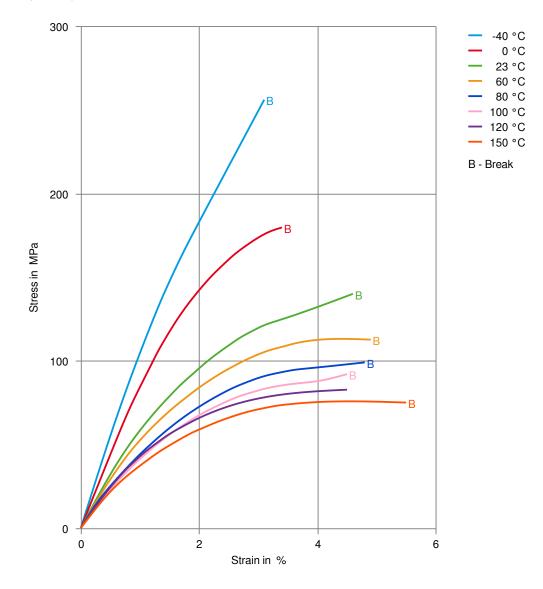


Stress-strain (dry)



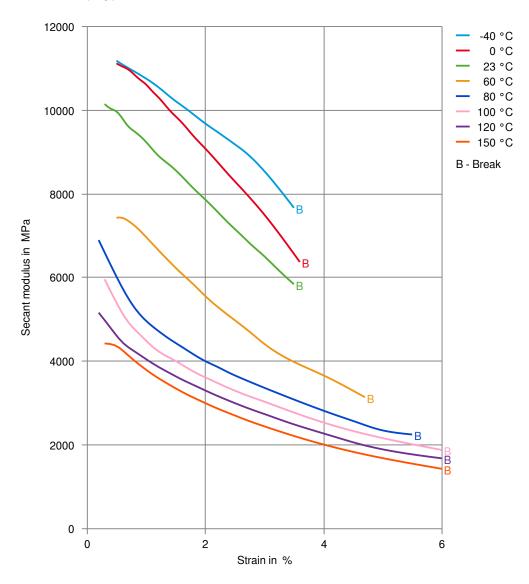


Stress-strain (cond.)



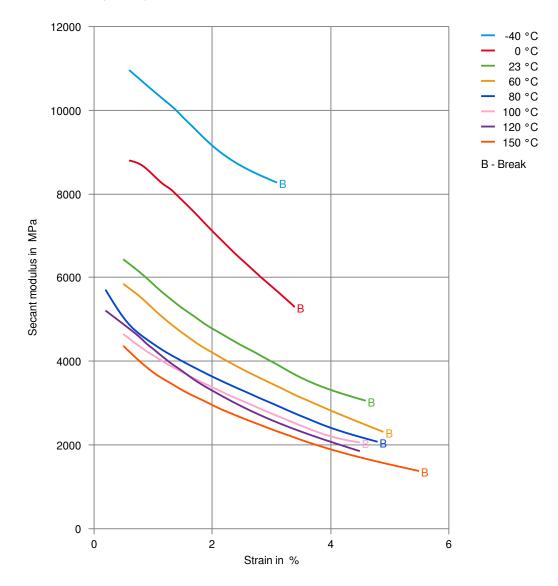


Secant modulus-strain (dry)



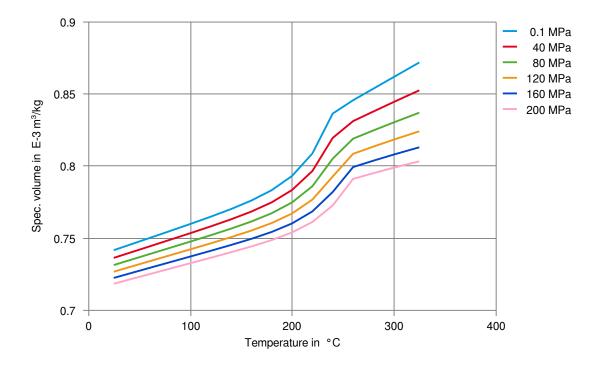


Secant modulus-strain (cond.)





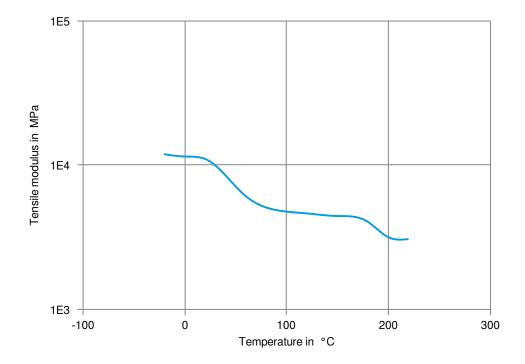
Specific volume-temperature (pvT)





NYLON RESIN

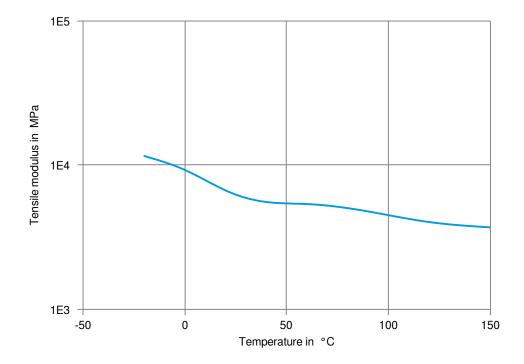
Tensile modulus-temperature (dry) (measured on Zytel® 70G33HS1L BK031)





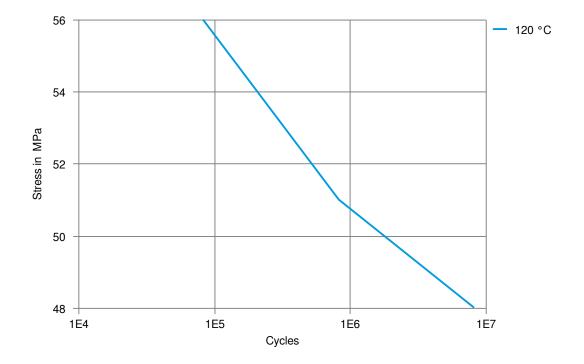
NYLON RESIN

Tensile modulus-temperature (cond.) (measured on Zytel® 70G33HS1L BK031)



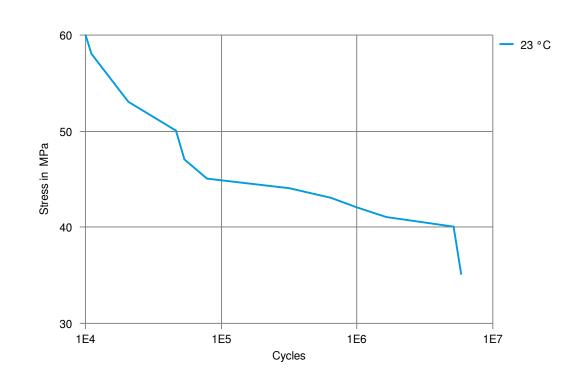


Tensile Fatigue, 10Hz, R=0.1 @ mm (dry)





Tensile Fatigue, 10Hz, R=0.1 @ mm (cond.)





Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass), 23°C
- ✓ Citric Acid solution (10% by mass), 23°C
- ✓ Lactic Acid (10% by mass), 23°C
- ★ Hydrochloric Acid (36% by mass), 23°C
- X Nitric Acid (40% by mass), 23°C
- X Sulfuric Acid (38% by mass), 23°C
- X Sulfuric Acid (5% by mass), 23°C
- X Chromic Acid solution (40% by mass), 23°C

Bases

- ✗ Sodium Hydroxide solution (35% by mass), 23°C
- Sodium Hydroxide solution (1% by mass), 23°C
- Ammonium Hydroxide solution (10% by mass), 23°C

Alcohols

- ✓ Isopropyl alcohol, 23°C
- ✓ Methanol, 23°C
- ✓ Ethanol, 23°C

Hydrocarbons

- ✓ n-Hexane, 23°C
- ✓ Toluene, 23°C
- ✓ iso-Octane, 23°C

Ketones

Acetone, 23°C

Ethers

✓ Diethyl ether, 23°C

Mineral oils

- ✓ SAE 10W40 multigrade motor oil, 23°C
- SAE 10W40 multigrade motor oil, 130°C
- ✓ SAE 80/90 hypoid-gear oil, 130°C
- ✓ Insulating Oil, 23°C
- ✓ Motor oil OS206 304 Ref.Eng.Oil, ISP, 135°C
- ✓ Automatic hypoid-gear oil Shell Donax TX, 135°C
- ✓ Hydraulic oil Pentosin CHF 202, 125°C

Standard Fuels

- ISO 1817 Liquid 1 E5, 60°C
- ✓ ISO 1817 Liquid 2 M15E4, 60°C
- ✓ ISO 1817 Liquid 3 M3E7, 60°C
- ISO 1817 Liquid 4 M15, 60°C
- ✓ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✓ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C
- ✓ Diesel fuel (pref. ISO 1817 Liquid F), 23°C
- ✓ Diesel fuel (pref. ISO 1817 Liquid F), 90°C
- Diesel fuel (pref. ISO 1817 Liquid F), >90°C
- Diesel EN 590, 100°C

Printed: 2024-04-11



Salt solutions

- ✓ Sodium Chloride solution (10% by mass), 23°C
- ✗ Sodium Hypochlorite solution (10% by mass), 23°C
- ✓ Sodium Carbonate solution (20% by mass), 23°C
- ✓ Sodium Carbonate solution (2% by mass), 23°C
- X Zinc Chloride solution (50% by mass), 23°C

Other

- ✓ Ethyl Acetate, 23°C
- X Hydrogen peroxide, 23°C
- DOT No. 4 Brake fluid, 130°C
- ✓ Ethylene Glycol (50% by mass) in water, 108°C
- 1% nonylphenoxy-polyethyleneoxy ethanol in water, 23°C
- ✓ 50% Oleic acid + 50% Olive Oil, 23°C
- ✓ Water, 23°C
- ✓ Water, 90°C
- ➤ Phenol solution (5% by mass), 23°C

Symbols used:

✓ possibly resistant

Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).

X not recommended - see explanation

Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).

Page: 16 of 16

Revised: 2022-12-21 Source: Celanese Materials Database

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may cause significant variations in data values. Properties of moulded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Other than those product expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials the lowest that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust we handling of such material to adequately trained personnel only. Please call the telephone numbers listed for addi

© 2024 Celanese or its affiliates. All rights reserved. Celanese®, registered C-ball design and all other trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Celanese or its affiliates. Fortron is a registered trademark of Fortron Industries LLC. KEPITAL is a registered trademark of Korea Engineering Plastics Company, Ltd.