

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® 80G25HS is a 25% glass fiber reinforced, toughened, heat stabilised, black polyamide 66 resin for injection moulding.

Product information

Resin Identification Part Marking Code ISO designation	PA66-IGF25 >PA66-IGF25< ISO 16396-PA66	-I,GF25,M1CGHR,S14-070	ISO 1043 ISO 11469
Rheological properties	dry/cond.		
Moulding shrinkage, parallel	0.3/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.8/-	%	ISO 294-4, 2577
Typical mechanical properties	dry/cond.		
Tensile modulus	7000/4500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	120/90	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	4/8	%	ISO 527-1/-2
Flexural modulus	6000/-	MPa	ISO 178
Flexural strength	200/-	MPa	ISO 178
Flexural stress at 3.5%	190/-	MPa	ISO 178
Charpy impact strength, 23°C	80/80	kJ/m²	ISO 179/1eU
Charpy impact strength, -30 °C	80/80	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	22/24	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30 °C	14/13	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	20/23	kJ/m²	ISO 180/1A
Izod notched impact strength, -30 °C	13.0/12.0	kJ/m²	ISO 180/1A
Izod notched impact strength, -40 °C	13.0/12.0	kJ/m²	ISO 180/1A
Ball indentation hardness, H 961/30	200/140 ^[DS]	MPa	ISO 2039-1
Poisson's ratio	0.35/0.36		
[DS]: Derived from similar grade			
Thermal properties	dry/cond.		
Melting temperature, 10°C/min	262/*	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	75/20	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	240/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	258/*	°C	ISO 75-1/-2

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Thermal conductivity of melt	0.21	W/(mK)	ISO 22007-2	
Flammability Glow Wire Flammability Index, 0.4mm Glow Wire Flammability Index, 0.75mm Glow Wire Flammability Index, 1.0mm Glow Wire Flammability Index, 1.5mm FMVSS Class Burning rate, Thickness 1 mm	dry/cond. 700/- 700/- 700/- 700/- B <80	°C °C °C °C mm/min	IEC 60695-2-12 IEC 60695-2-12 IEC 60695-2-12 IEC 60695-2-12 ISO 3795 (FMVSS 302) ISO 3795 (FMVSS 302)	
Electrical properties Electric strength Comparative tracking index	dry/cond. 32/- */375	kV/mm	IEC 60243-1 IEC 60112	
Physical/Other properties Density	dry/cond. 1250/-	kg/m³	ISO 1183	
VDA Properties Weather stability delta I Weather stability delta a Weather stability delta b Weather stability delta E Weather stability grey scale	8 0.2 0.7 8 4		DIN 53236 DIN 53236 DIN 53236 DIN 53236 ISO 105-A02	
Injection Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Screw tangential speed Mold Temperature Optimum Min. mould temperature Max. mould temperature Hold pressure range Hold pressure time Ejection temperature	2 - 4 ≤0.2 295 280 310 ≤0.2 70 40 90 50 - 100 3	° C h % ° C ° C ° C m/s ° C ° C ° C		
Characteristics				
Processing Delivery form Additives	Injection Moulding Pellets Release agent			
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat			

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Automotive

OEM BMW

STANDARD GS93016-PA66-GF25

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
- ✗ Chromic Acid solution (40% by mass), 23°C

Bases

- X 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

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

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✓ Diesel fuel (pref. ISO 1817 Liquid F), >90°C

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
- ★ 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
- X 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).

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