

# DuPont™ Zytel® 80G43HS1L BK104

## NYLON RESIN

### Product Information

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, DuPont recommends, 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® 80G43HS1L BK104 is a 43% glass fiber reinforced, heat stabilized, black polyamide 66 resin with superior impact resistance.**

Product information	Value	Unit	Test Standard
Resin Identification	PA66-IGF43	-	ISO 1043
Part Marking Code	PA66-IGF43	-	ISO 11469
Rheological properties	dry / cond	Unit	Test Standard
Molding shrinkage, parallel	0.2 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / -	%	ISO 294-4, 2577
Mechanical properties	dry / cond	Unit	Test Standard
Tensile Modulus	1.7E6 / -	psi	ISO 527-1/-2
Stress at break	24500 / -	psi	ISO 527-1/-2
Strain at break	3.3 / -	%	ISO 527-1/-2
Flexural Modulus	1.49E6 / -	psi	ISO 178
Charpy impact strength, 73°F	42.8 / -	ftlb/in <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength			ISO 179/1eA
73°F	10.9 / -	ftlb/in <sup>2</sup>	
-40°F	7.14 / -	ftlb/in <sup>2</sup>	
Izod notched impact strength			ISO 180/1A
73°F	10.9 / -	ftlb/in <sup>2</sup>	
-40°F	6.66 / -	ftlb/in <sup>2</sup>	
Izod impact strength, 73°F	37.1 / -	ftlb/in <sup>2</sup>	ISO 180/1U
Thermal properties	dry / cond	Unit	Test Standard
Melting temperature, 18°F/min	504 / *	°F	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
260 psi	482 / *	°F	
65 psi	502 / *	°F	
Vicat softening temperature, 90°F/h, 11 lbf	419 / *	°F	ISO 306
Thermal conductivity of melt	0.25	W/(m K)	-
Spec. heat capacity of melt	2050	J/(kg K)	-
Flammability	dry / cond	Unit	Test Standard
Burning Behav. at 60mil nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	0.0591 / *	in	IEC 60695-11-10
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.0295 / *	in	IEC 60695-11-10
Oxygen index	27 / *	%	ISO 4589-1/-2
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80	in/min	ISO 3795 (FMVSS 302)
Other properties	dry / cond	Unit	Test Standard
Humidity absorption, 80mil	1.5 / *	%	Sim. to ISO 62
Water absorption, 80mil	4.9 / *	%	Sim. to ISO 62
Density	1.43 / -	g/cm <sup>3</sup>	ISO 1183
Density of melt	79.3	lb/ft <sup>3</sup>	-

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Injection	dry / cond	Unit	Test Standard
Drying Recommended	yes		-
Drying Temperature	≥176	°F	-
Drying Time, Dehumidified Dryer	2 - 4	h	-
Processing Moisture Content	≤0.2	%	-
Melt Temperature Optimum	563	°F	-
Min. melt temperature	545	°F	-
Max. melt temperature	581	°F	-
Max. screw tangential speed	0.2 / *	m/s	-
Mold Temperature Optimum	176	°F	-
Min. mold temperature	122	°F	-
Max. mold temperature	212	°F	-
Hold pressure range	7250 - 14500	psi	-
Hold pressure time	0.0762	s/mil	-
Ejection temperature	383	°F	-

Characteristics			
Processing	• Injection Molding		
Delivery form	• Pellets		
Additives	• Lubricants	• Release agent	
Special characteristics	• Heat stabilized or stable to heat		
Regional Availability	• North America • Europe	• Asia Pacific • South and Central America	• Near East/Africa • Global

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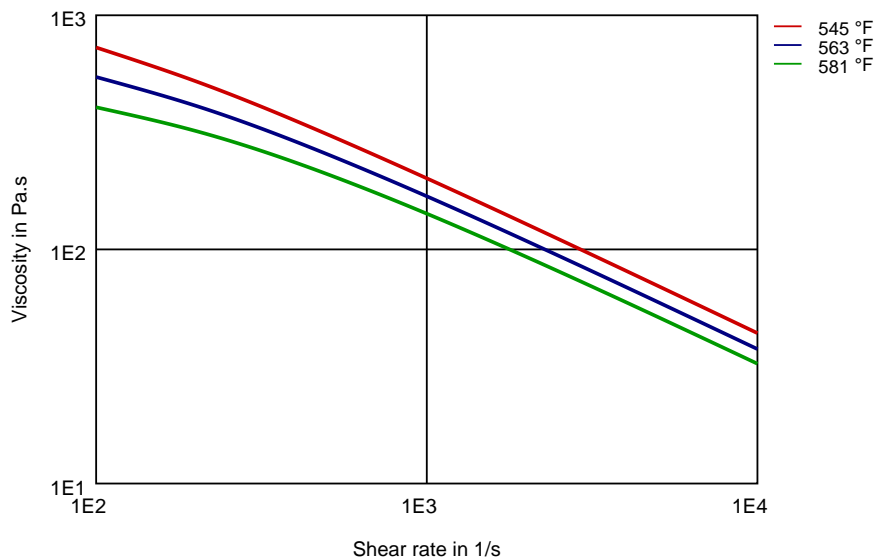


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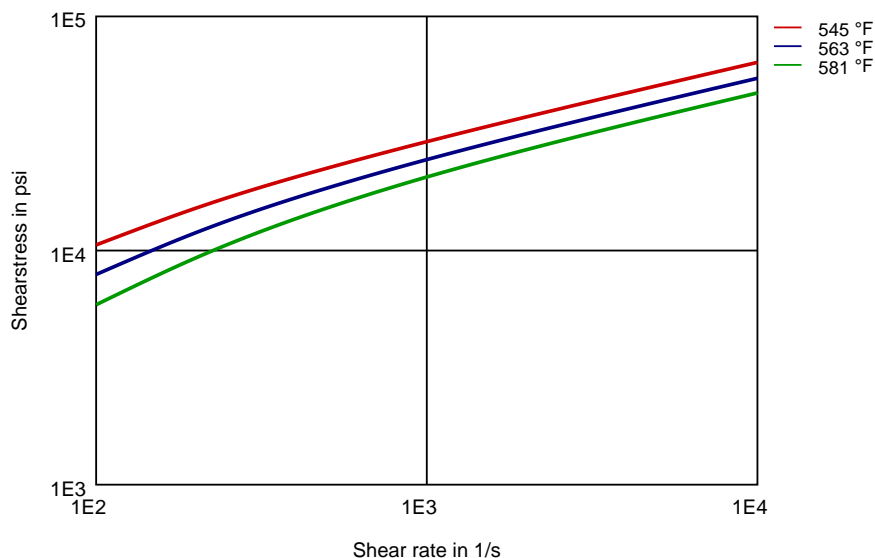
## NYLON RESIN

### Diagrams

#### Viscosity-shear rate



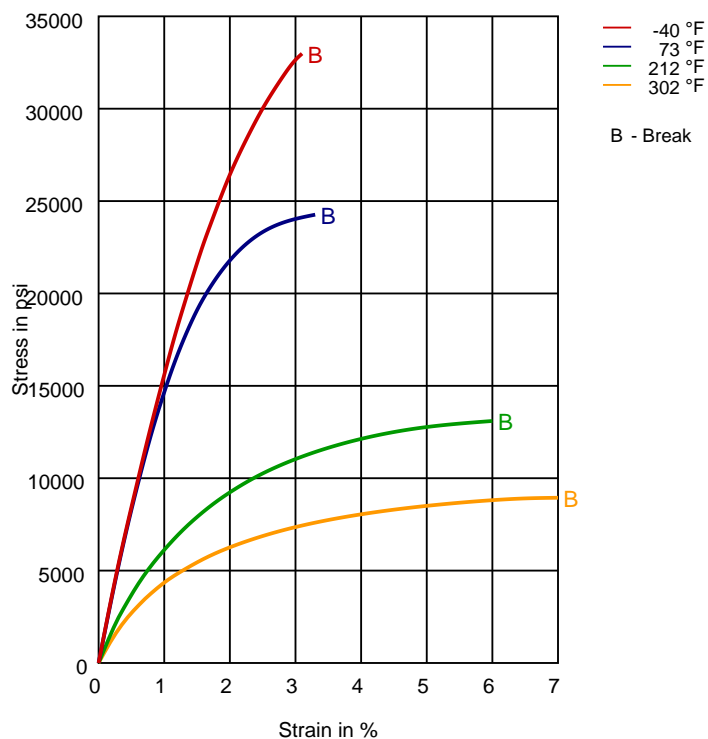
#### Shearstress-shear rate



# DuPont™ Zytel® 80G43HS1L BK104

## NYLON RESIN

Stress-strain (dry)



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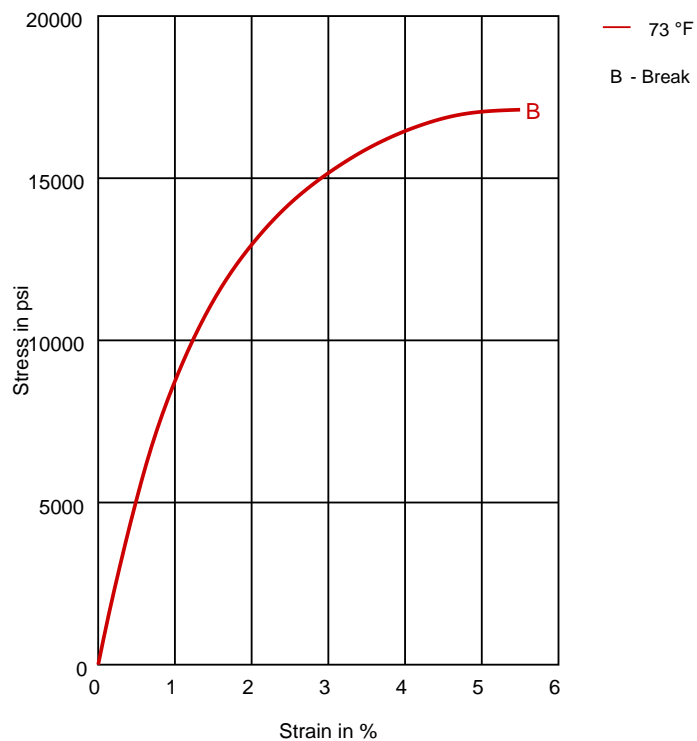


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# DuPont™ Zytel® 80G43HS1L BK104

## NYLON RESIN

Stress-strain (cond.)



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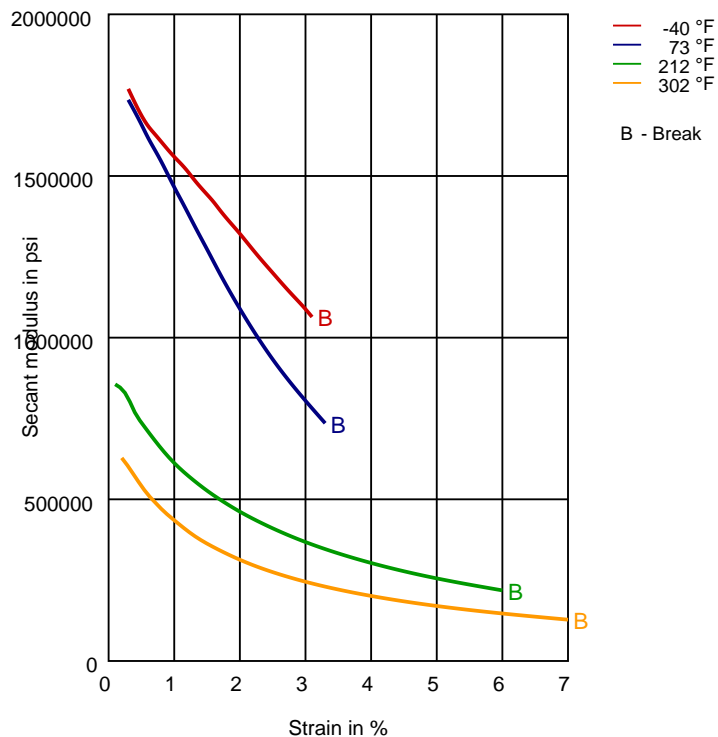
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# DuPont™ Zytel® 80G43HS1L BK104 NYLON RESIN

Secant modulus-strain (dry)



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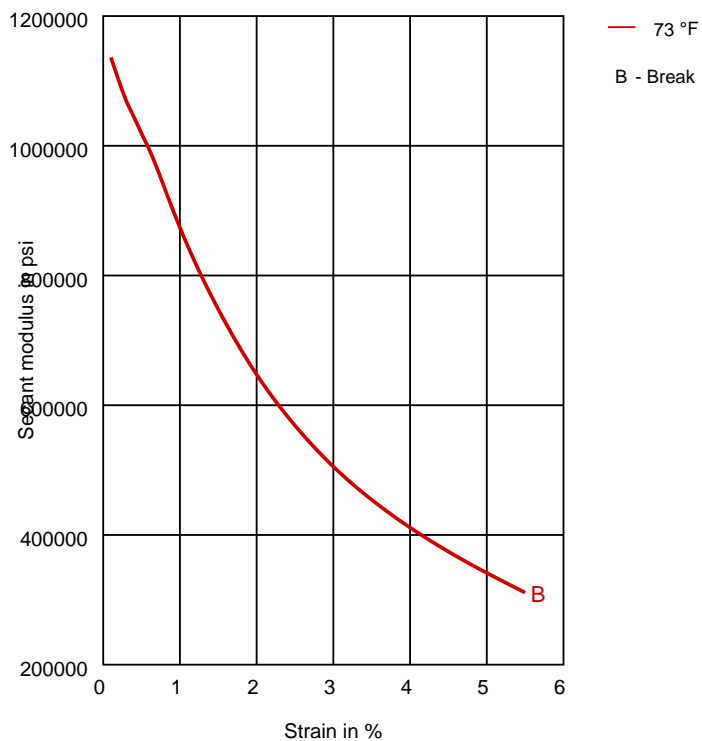
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## NYLON RESIN

Secant modulus-strain (cond.)



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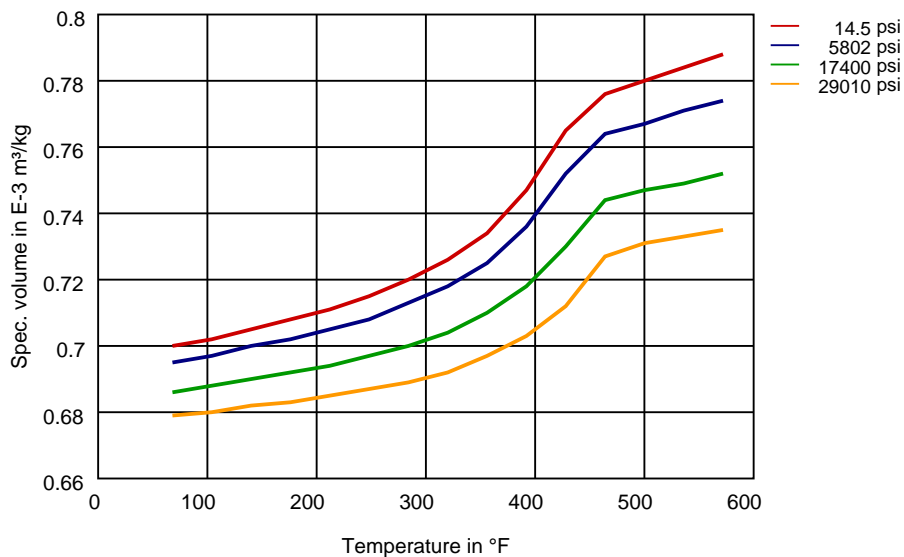
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# DuPont™ Zytel® 80G43HS1L BK104

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Specific volume-temperature (pvT)



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### 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)
- ✗ Nitric Acid (40% by mass) (23 °C)
- ✗ Sulfuric Acid (38% by mass) (23 °C)
- ✗ Sulfuric Acid (5% by mass) (23 °C)
- ✗ 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)

#### 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)

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- ✓ 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)

### 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)
- ✗ 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)
- ✗ 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).

✗ 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).

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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