

DuPont™ Zytel® 70G25HSL NC010

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® 70G25HSL is a 25% glass fibre reinforced, heat stabilised polyamide 66 resin for injection moulding.

General information	Value	Unit	Test Standard
Resin Identification	PA66-GF25	-	-
Part Marking Code	>PA66-GF25<	-	ISO 11469
Rheological properties	dry / cond	Unit	Test Standard
Viscosity number	140 / *	cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 / *	%	ISO 294-4, 2577
Mechanical properties	dry / cond	Unit	Test Standard
Tensile Modulus	8600 / 6100	MPa	ISO 527-1/-2
Stress at break	188 / 115	MPa	ISO 527-1/-2
Strain at break	3.1 / 5	%	ISO 527-1/-2
Tensile creep modulus			ISO 899-1
1h	* / 5000	MPa	
1000h	* / 4100	MPa	
Charpy impact strength			ISO 179/1eU
23°C	65 / 85	kJ/m ²	
-30°C	53 / 47	kJ/m ²	
Charpy notched impact strength			ISO 179/1eA
23°C	10 / 12	kJ/m ²	
-30°C	10 / 11	kJ/m ²	
Izod notched impact strength			ISO 180/1A
23°C	10 / 11	kJ/m ²	
-30°C	8 / 8	kJ/m ²	
Ball indentation hardness, H 961/30	260 / -	MPa	ISO 2039-1
Hardness, Rockwell, M-scale	103 / 87	-	ISO 2039-2
Hardness, Rockwell, R-scale	123 / 116	-	ISO 2039-2
Thermal properties	dry / cond	Unit	Test Standard
Melting temperature, 10°C/min	263 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	80 / -	°C	ISO 11357-1/-2
Temp. of deflection under load			ISO 75-1/-2
1.8 MPa	245 / *	°C	
0.45 MPa	263 / *	°C	
Vicat softening temperature, 50°C/h, 50N	255 / *	°C	ISO 306
Coeff. of linear therm. expansion, parallel	33 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	112 / *	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.21	W/(m K)	-
Spec. heat capacity of melt	2090	J/(kg K)	-
RTI, electrical			UL 746B
0.75 mm	140 / *	°C	
1.5mm	140 / *	°C	
3mm	140	°C	

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RTI, impact			UL 746B
0.75 mm	125	°C	
1.5mm	125 / *	°C	
3mm	125	°C	
RTI, strength			UL 746B
0.75 mm	140	°C	
1.5mm	140 / *	°C	
3mm	140	°C	
Flammability	dry / cond	Unit	Test Standard
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	UL / *	-	-
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.71 / *	mm	IEC 60695-11-10
Flammability, 3.0mm	HB / *	-	IEC 60695-11-10
Burning rate, Thickness 1 mm	18 ^[1]	mm/min	ISO 3795 (FMVSS 302)
1: SE/B			
Electrical properties	dry / cond	Unit	Test Standard
Relative permittivity, 1MHz	4.1 / 4.5	-	IEC 60250
Dissipation factor, 1MHz	150 / 730	E-4	IEC 60250
Volume resistivity	>1E13 / 1E9	Ohm*m	IEC 60093
Surface resistivity	* / 1E13	Ohm	IEC 60093
Comparative tracking index	400 / -	-	IEC 60112
Other properties	dry / cond	Unit	Test Standard
Humidity absorption, 2mm	2 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.4 / *	%	Sim. to ISO 62
Density	1330 / -	kg/m ³	ISO 1183

Characteristics			
Processing	• Injection Moulding		
Delivery form	• Pellets		
Additives	• Lubricants	• Release agent	
Special characteristics	• Heat stabilised or stable to heat		
Regional Availability	• Europe	• Near East/Africa	

Processing Texts

Injection molding

PREPROCESSING

Drying recommended = Yes, if moisture content of resin exceeds recommended level

Drying temperature = 80 °C

Drying time, dehumidified dryer = 2-4 h

Processing moisture content = <0.2 %

PROCESSING

Melt temperature optimum = 295 °C

Melt temperature range = 285-305 °C

Mould temperature optimum = 100 °C

Mould temperature range = 70-120 °C

Maximum Screw tangential Speed : 0.15 m/s

Flow front speed : 150 mm/s

Hold pressure optimum : 85 MPa

Hold pressure range : 50-100 MPa

Back pressure : low

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Hold pressure time : 2.5 s/mm
Maximum hold-up time : 15 min

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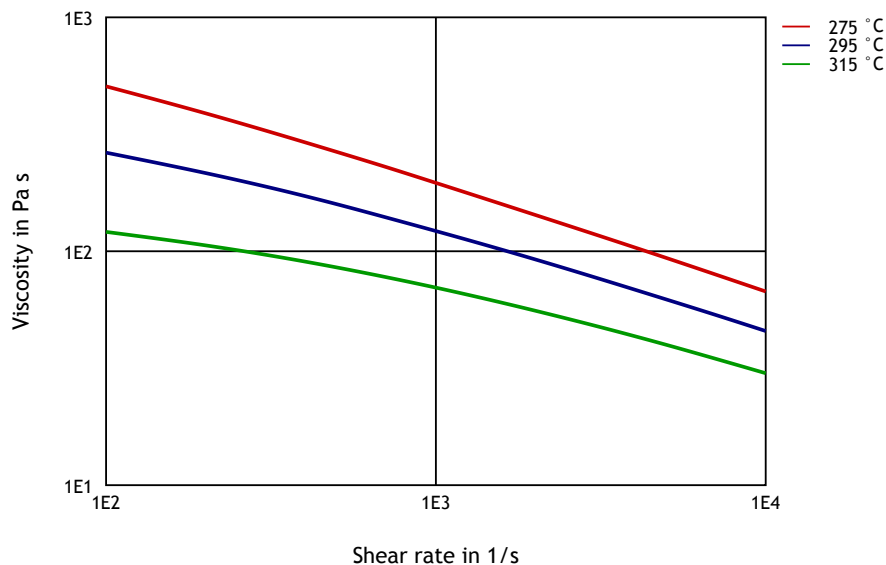


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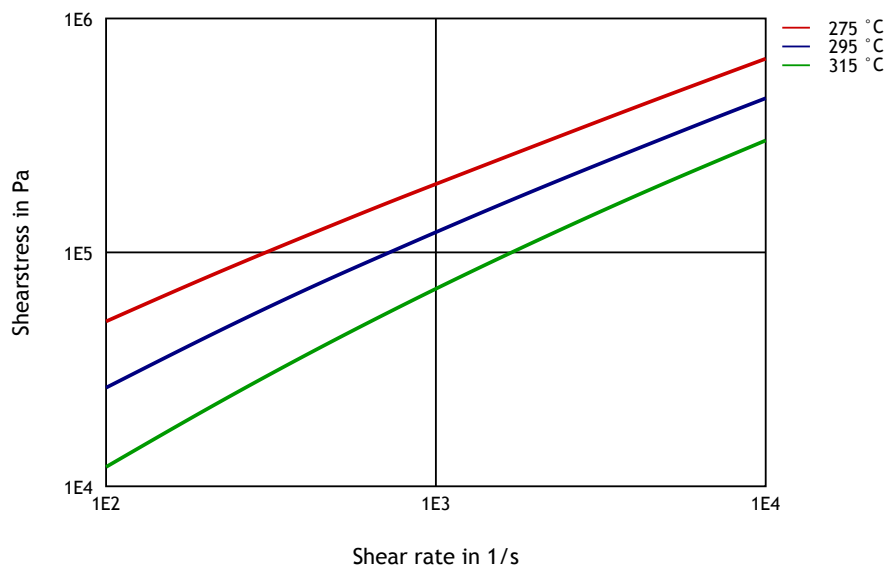
NYLON RESIN

Diagrams

Viscosity-shear rate



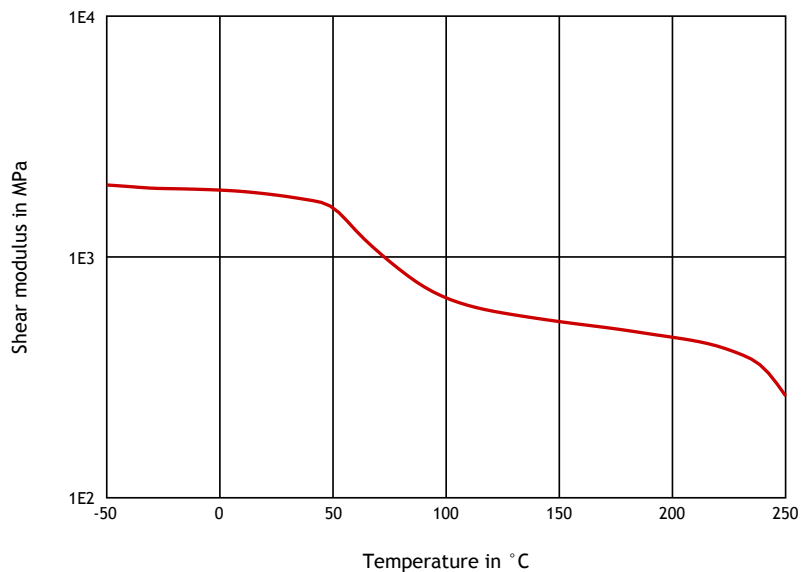
Shearstress-shear rate



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Dynamic Shear modulus-temperature (dry)



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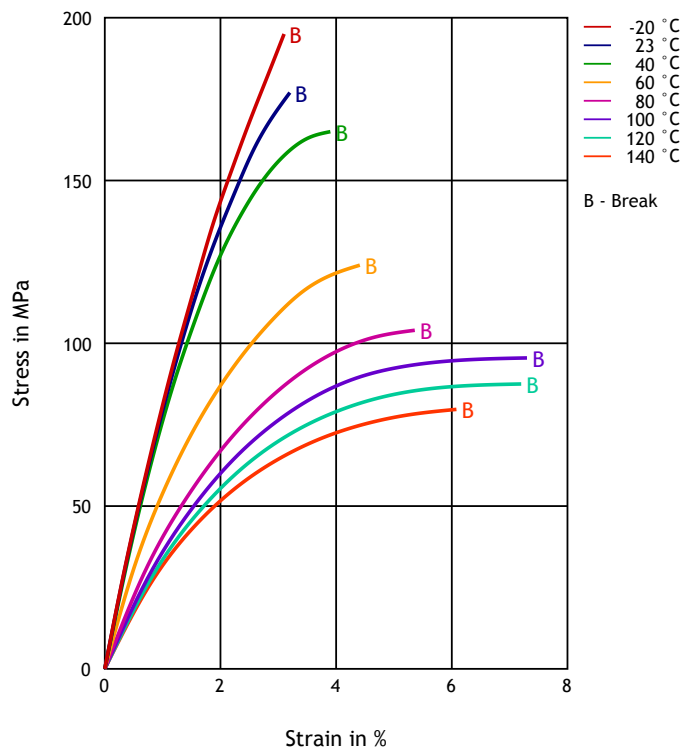
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Stress-strain (dry)



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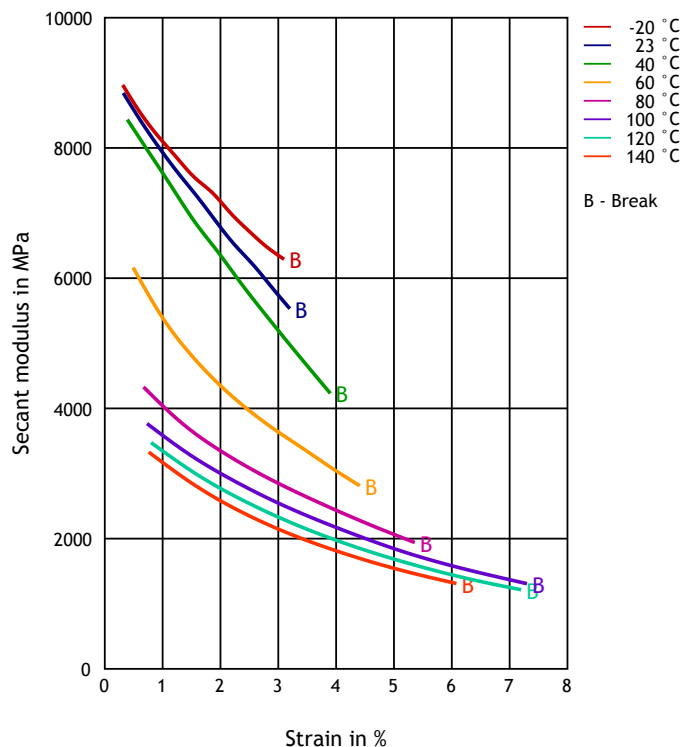


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Secant modulus-strain (dry)



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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)
- ✓ Motor oil OS206 304 Ref.Eng.Oil, ISP (135°C)
- ✓ Automatic hypoid-gear oil Shell Donax TX (135°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)

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- ✓ 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)

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 4.0mm (Hytrel® measured at 2 mm), IEC Electrical properties measured at 2.0mm, all ASTM properties measured at 3.2mm, and test temperatures are 23°C unless otherwise stated.

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