

DuPont™ Zytel® FR50 NC010A

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® FR50 NC010A is a 25% glass fiber reinforced, flame retardant polyamide 66 resin for injection molding.

General information	Value	Unit	Test Standard
Resin Identification	PA66-GF25FR(17)	-	-
Part Marking Code	>PA66-GF25FR(17) <	-	ISO 11469
Rheological properties	dry / cond	Unit	Test Standard
Moulding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577
Mechanical properties	dry / cond	Unit	Test Standard
Tensile Modulus	10640 / 7500	MPa	ISO 527-1/-2
Stress at break	170 / -	MPa	ISO 527-1/-2
Strain at break	2.5 / -	%	ISO 527-1/-2
Flexural Modulus	9450 / -	MPa	ISO 178
Charpy impact strength, 23°C	40 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength			ISO 179/1eA
23°C	11.3 / -	kJ/m ²	
-40°C	10.8 / -	kJ/m ²	
Thermal properties	dry / cond	Unit	Test Standard
Melting temperature, 10°C/min	261 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	80 / -	°C	ISO 11357-1/-2 DS
Temp. of deflection under load			ISO 75-1/-2
1.8 MPa	246 / *	°C	
0.45 MPa	256 / *	°C	
Coeff. of linear therm. expansion, parallel	19 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100 / *	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.22	W/(m K)	-
Spec. heat capacity of melt	1660	J/(kg K)	-
RTI, electrical			UL 746B
0.75 mm	130 / *	°C	
1.5mm	130 / *	°C	
3mm	130	°C	
RTI, impact			UL 746B
0.75 mm	105	°C	
1.5mm	115 / *	°C	
3mm	115	°C	
RTI, strength			UL 746B
0.75 mm	105	°C	
1.5mm	115 / *	°C	
3mm	120	°C	

DS: Derived from similar grade

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

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Flammability	dry / cond	Unit	Test Standard
Burning Behav. at 1.5mm nom. thckn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	UL / *	-	-
Burning Behav. at thickness h	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.35 / *	mm	IEC 60695-11-10
Burning Behav. 5V at thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.5 / *	mm	IEC 60695-11-20
UL recognition	UL / *	-	-
Glow Wire Flammability Index			IEC 60695-2-1/2
0.75mm	960 / -	°C	
1.5mm	960 / -	°C	
3mm	960 / -	°C	
Glow Wire Ignition Temperature			IEC 60695-2-1/3
0.75mm	900 / -	°C	
1.5mm	900 / -	°C	
3mm	930 / -	°C	
Flammability, 3.0mm	V-0 / *	-	IEC 60695-11-10
Electrical properties	dry / cond	Unit	Test Standard
Relative permittivity, 1MHz	3.8 / -	-	IEC 60250
Dissipation factor			IEC 60250
100Hz	180 / -	E-4	
1MHz	180 / -	E-4	
Volume resistivity	>1E13 / -	Ohm*m	IEC 60093
Electric strength	38 / -	kV/mm	IEC 60243-1
Comparative tracking index			
Comparative tracking index	285 / -	-	IEC 60112
CTI, 23°C	2 / -	PLC	UL 746A
Other properties	dry / cond	Unit	Test Standard
Humidity absorption, 2mm	0.7 / *	%	Sim. to ISO 62
Density	1600 / -	kg/m ³	ISO 1183
Density of melt	1400	kg/m ³	-
VDA Properties	Value	Unit	Test Standard
Emission of organic compounds	4.7	µgC/g	VDA 277
Odour	4.5	class	VDA 270

Characteristics			
Processing	• Injection Moulding		
Delivery form	• Pellets		
Additives	• Release agent		
Regional Availability	• North America	• Asia Pacific	• Near East/Africa
	• Europe	• South and Central America	• Global

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 = 270°C

Melt temperature range = 260-280°C

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Mould temperature optimum = 70°C
Mould temperature range = 50-90°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
Hold pressure time : 2.5 s/mm
Maximum hold-up time : 10 min

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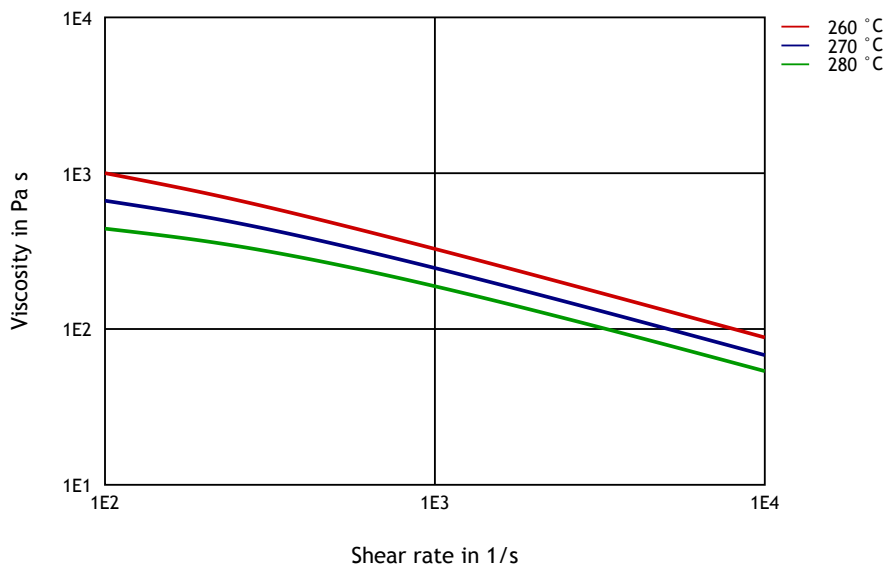


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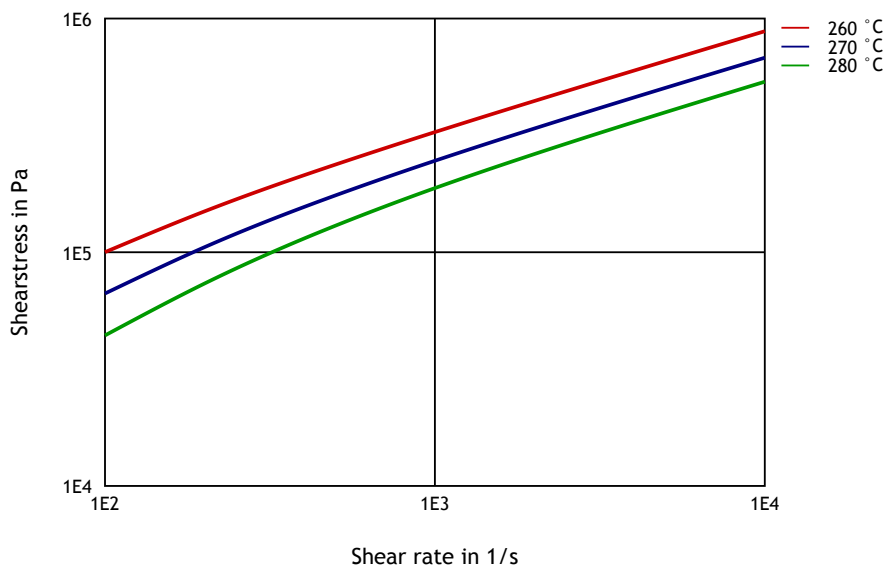
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Diagrams

Viscosity-shear rate



Shearstress-shear rate



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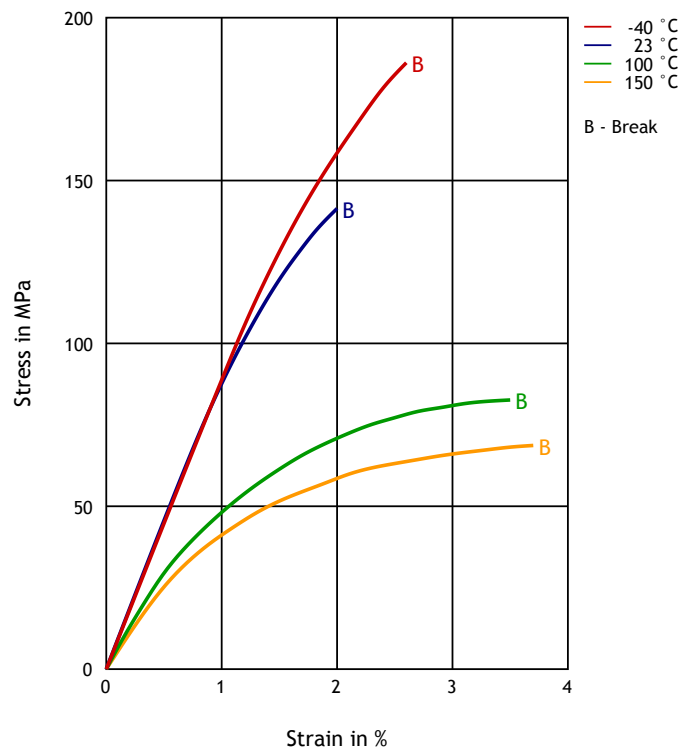
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Stress-strain (dry)



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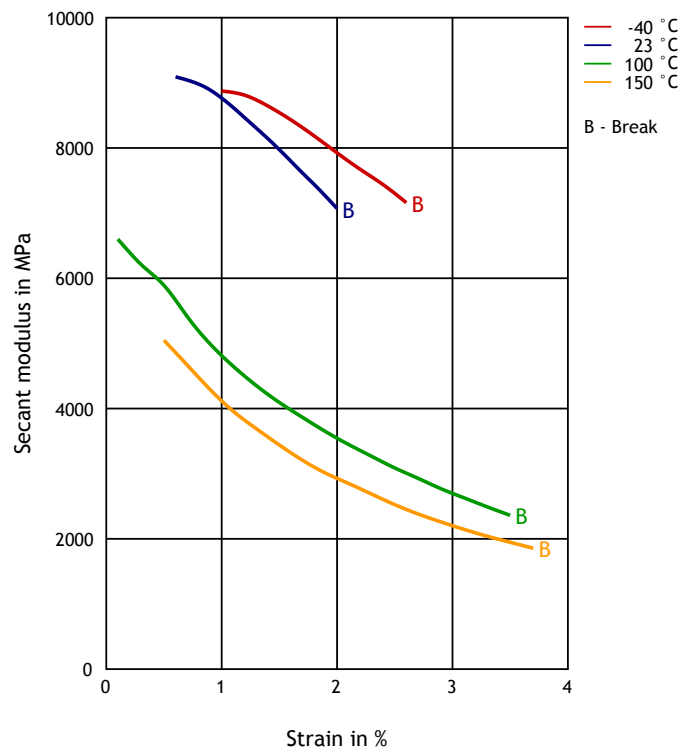
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Secant modulus-strain (dry)



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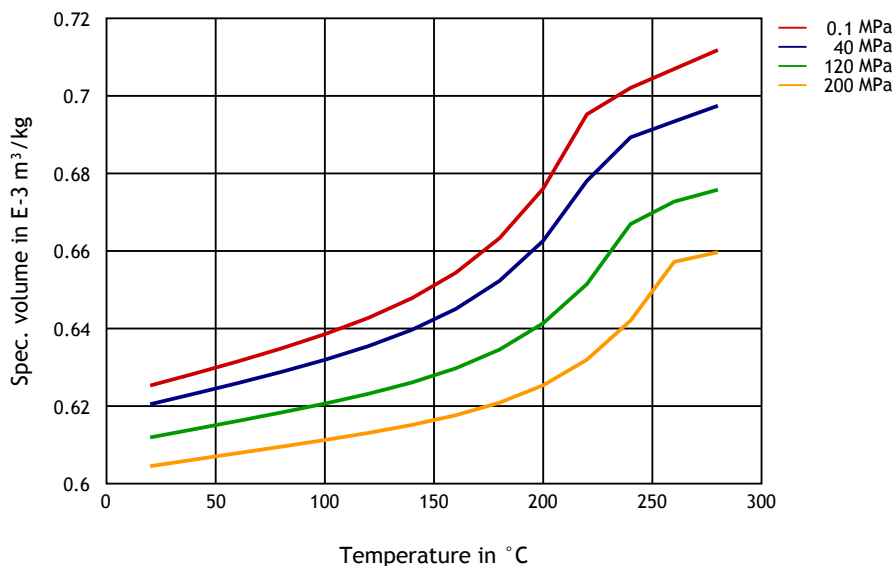
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Specific volume-temperature (pvT)



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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 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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