DuPont™ Zytel® 73G45 BK263

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® 73G45 BK263 is a 45% glass fiber reinforced, black polyamide 6 resin for injection molding.

General information	Value	Unit	Test Standard	
Resin Identification	PA6-GF45	-	ISO 1043	
Part Marking Code	PA6-GF45	-	ISO 11469	
Rheological properties	**dry / cond**	**Unit**	**Test Standard**	
Molding shrinkage, parallel	0.1 / -	%	ISO 294-4, 2577	
Molding shrinkage, normal	0.6 / -	%	ISO 294-4, 2577	
Mechanical properties	**dry / cond**	**Unit**	**Test Standard**	
Tensile Modulus	2.06E6 / 1.31E6	psi	ISO 527-1/-2	
Stress at break	31200 / 21000	psi	ISO 527-1/-2	
Strain at break	3 / 5	%	ISO 527-1/-2	
Tensile creep modulus			ISO 899-1	
1h	* / 1.36E6	psi		
1000h	* / 1.06E6	psi		
Charpy impact strength, 73°F	47.6 / 47.6	ftlb/in²	ISO 179/1eU	
Charpy notched impact strength, 73°F	9.04 / 11.4	ftlb/in²	ISO 179/1eA	
Izod notched impact strength, 73°F	8.09 / 10.5	ftlb/in²	ISO 180/1A	
Thermal properties	**dry / cond**	**Unit**	**Test Standard**	
Melting temperature, 18°F/min	430 / *	°F	ISO 11357-1/-3	
Temp. of deflection under load, 260 psi	424 / *	°F	ISO 75-1/-2	
Thermal conductivity of melt	0.26	W/(m K)	-	
Spec. heat capacity of melt	2100	J/(kg K)	-	
Flammability	**Value**	**Unit**	**Test Standard**	
FMVSS Class	B	-	ISO 3795 (FMVSS 302)	
Burning rate, Thickness 1 mm	1.73	in/min	ISO 3795 (FMVSS 302)	DS
DS: Derived from similar grade				
Electrical properties	**dry / cond**	**Unit**	**Test Standard**	
Comparative tracking index	500 / -	-	IEC 60112	
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	1.51 / -	g/cm³	ISO 1183	
Density of melt	83	lb/ft³	-	
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	518	°F	-	
Min. melt temperature	500	°F	-	
Max. melt temperature	536	°F	-	

To find out more, visit DuPont Performance Polymers or contact nearest DuPont location.

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Max. screw tangential speed	0.2 / *	m/s	-
Mold Temperature Optimum	212	°F	-
Min. mold temperature	158	°F	-
Max. mold temperature	248	°F	-
Hold pressure range	7250 - 14500	psi	-
Hold pressure time	0.0762	s/mil	-
Ejection temperature	410	°F	-

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

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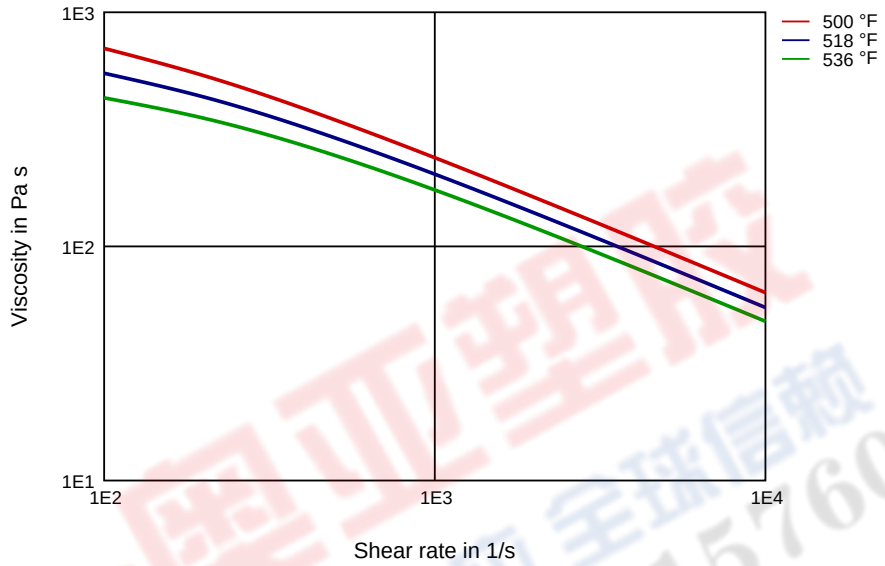
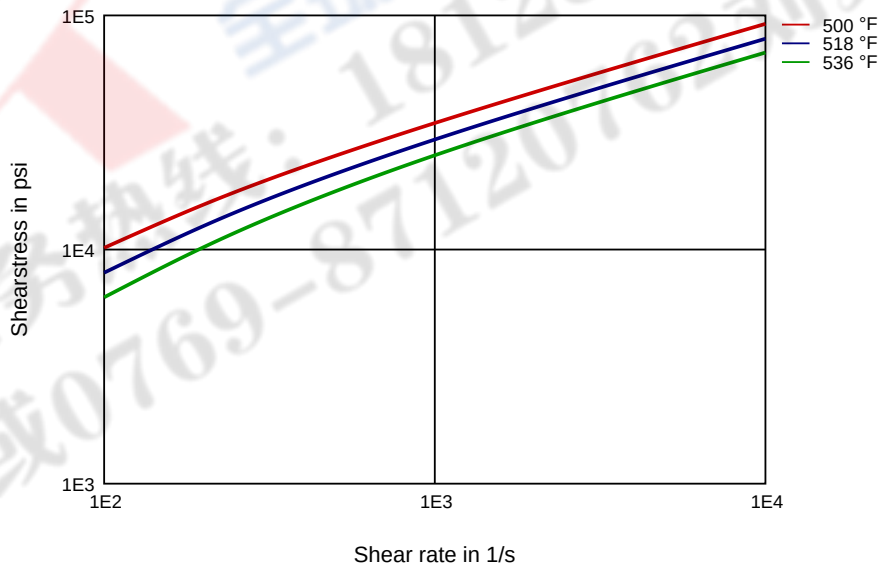
Diagrams

Viscosity-shear rate



Shearstress-shear rate



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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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