Celanese
The chemistry inside innovation™

Zytel® FE3734 NC010

LONG CHAIN POLYAMIDE RESIN

Zytel® LCPA long chain polyamide resins provide an innovative and growing portfolio of flexible polymers with excellent thermal, chemical, and hydrolysis resistance. The diverse selection of Zytel® LCPA grades is targeted for a range of performance characteristics, balancing temperature resistance, flexibility and low permeation.

Zytel® FE3734 NC010 is an unreinforced, lubricated polyamide 612 resin suitable for injection moulding.

Product information

Resin Identification	PA612	ISO 1043
Part Marking Code	>PA612<	ISO 11469
ISO designation	ISO 16396-PA612,,M1G1NR,S10-020	

Rheological properties

	dry/cond.		
Viscosity number	95[1]/*	cm^3/g	ISO 307, 1628
Moulding shrinkage, parallel	1.3 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.4 / -	%	ISO 294-4, 2577
Mold Shrinkage, Flow, 3.2mm (0.125in)	1.1 / *	%	
Mold Shrinkage, Transverse, 3.2mm (0.125in)	1.1 / *	%	

[1]: Sulfuric acid 96%

Typical mechanical properties

	dry/cond.		
Tensile modulus	2400 / 1600	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	59 / 56	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	5 / 21	%	ISO 527-1/-2
Nominal strain at break	38 / 30	%	ISO 527-1/-2
Flexural modulus	2200 / -	MPa	ISO 178
Charpy impact strength, 23 °C	N / -	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30 °C	N / -	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23 °C	4.8 / 5.3	kJ/m^2	ISO 179/1eA
Hardness, Rockwell, R-scale	114 / -		ISO 2039-2
Poisson's ratio	0.38 / 0.42		

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	218 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	63 / *	°C	ISO 75-1/-2

Flammability

FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80	mm/min	ISO 3795 (FMVSS 302)

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.3 / *	%	Sim. to ISO 62
Water absorption, 2mm	3 / *	%	Sim. to ISO 62
Density	1070 / -	kg/m^3	ISO 1183

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Injection

Drying Recommended	yes	
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.15	%
Melt Temperature Optimum	260	°C
Min. melt temperature	230	°C
Max. melt temperature	290	°C
Mold Temperature Optimum	70	°C
Min. mould temperature	50	°C
Max. mould temperature	90	°C
Ejection temperature	182	°C

Extrusion

Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	3 - 4	h
Processing Moisture Content	≤0.06	%
Melt Temperature Range	235 - 250	°C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent

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

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- ✔ 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
- ✘ 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).