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Celanese
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Zytel® 70G25EF NC010

NYLON RESIN

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, we recommend, 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® 70G25EF NC010 is a 25% glass reinforced polyamide 66 developed for electrical and electronics applications.

Product information

Resin Identification	PA66-GF25		ISO 1043
Part Marking Code	>PA66-GF25<		ISO 11469

Rheological properties

	dry/cond.		
Moulding shrinkage, parallel	0.3 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.1 / -	%	ISO 294-4, 2577
Melt viscosity , @ 1000 sec-1, 280 °C	150 / *	Pa.s	ISO 11443

Typical mechanical properties

	dry/cond.		
Tensile modulus	8500 / 6000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	170 / 110	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3 / 5	%	ISO 527-1/-2
Flexural modulus	7000 / 5000	MPa	ISO 178
Flexural strength	260 / 190	MPa	ISO 178
Charpy impact strength, 23 °C	60 / 80	kJ/m²	ISO 179/1eU
Charpy impact strength, -30 °C	55 / 55	kJ/m²	ISO 179/1eU
Charpy impact strength, -40 °C	55 / 55	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23 °C	10 / 12	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30 °C	9 / 8	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40 °C	9 / 8	kJ/m²	ISO 179/1eA
Poisson's ratio	0.34 / 0.35		

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	260 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10 °C/min	80 / 25	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	241 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel, -40-23 °C	28 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	30 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel, 55-160 °C	19 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23 °C	73 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	90 / *	E-6/K	ISO 11359-1/-2

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Coeff. of linear therm. expansion, normal, 55-160 °C	146 / *	E-6/K	ISO 11359-1/-2
TGA curve	available		ISO 11359-1/-2

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *[DS]	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Oxygen index	22 / *	%	ISO 4589-1/-2
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	23	mm/min	ISO 3795 (FMVSS 302)

[DS]: Derived from similar grade

Electrical properties

	dry/cond.		
Volume resistivity	>1E13 / 1E11[DS]	Ohm.m	IEC 62631-3-1
Comparative tracking index	500 / -		IEC 60112

[DS]: Derived from similar grade

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.4 / *	%	Sim. to ISO 62
Density	1320 / -	kg/m³	ISO 1183

Injection

Drying Recommended	yes	
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	295	°C
Min. melt temperature	285	°C
Max. melt temperature	305	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	100	°C
Min. mould temperature	70	°C
Max. mould temperature	120	°C
Hold pressure range	50 - 100	MPa
Hold pressure time	3	s/mm
Ejection temperature	210	°C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent, Low halide content
Special characteristics	Heat stabilised or stable to heat

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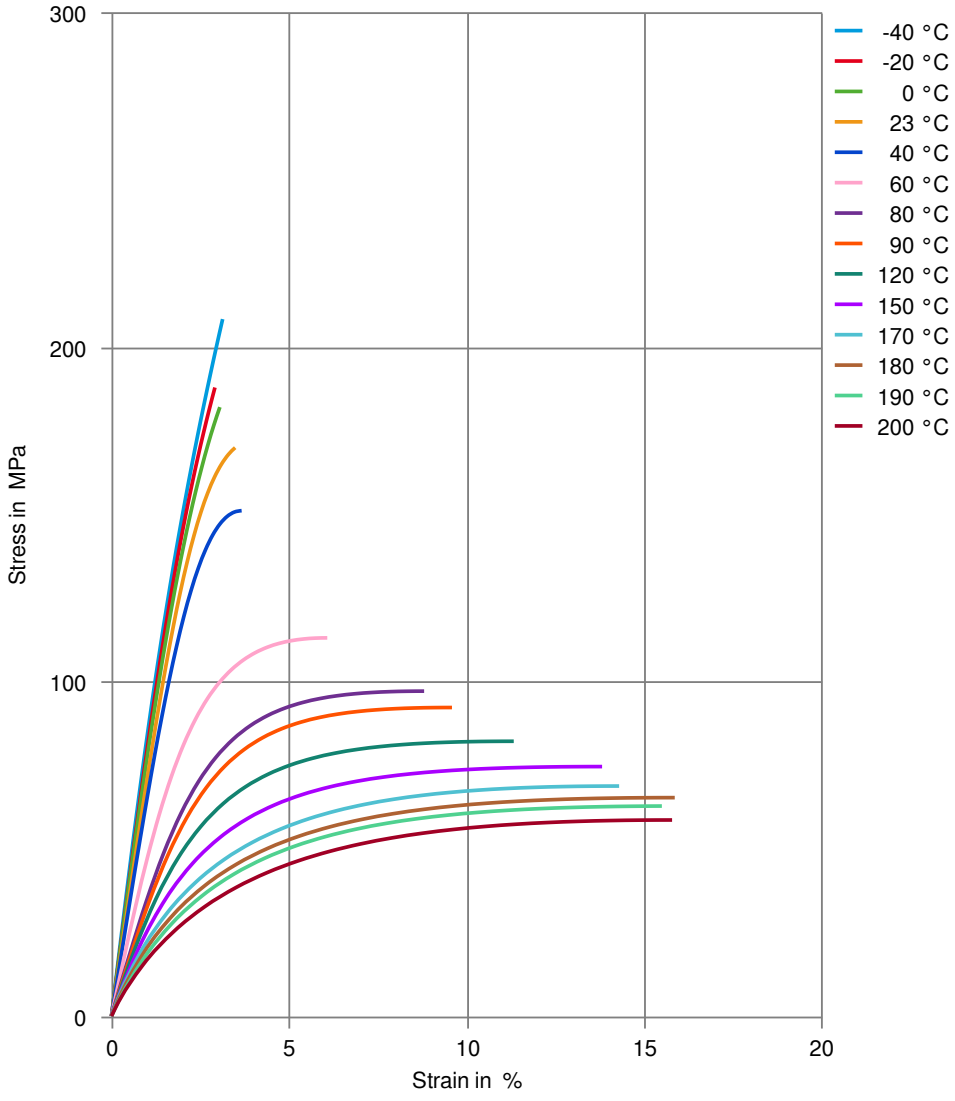
Stress-strain (dry)



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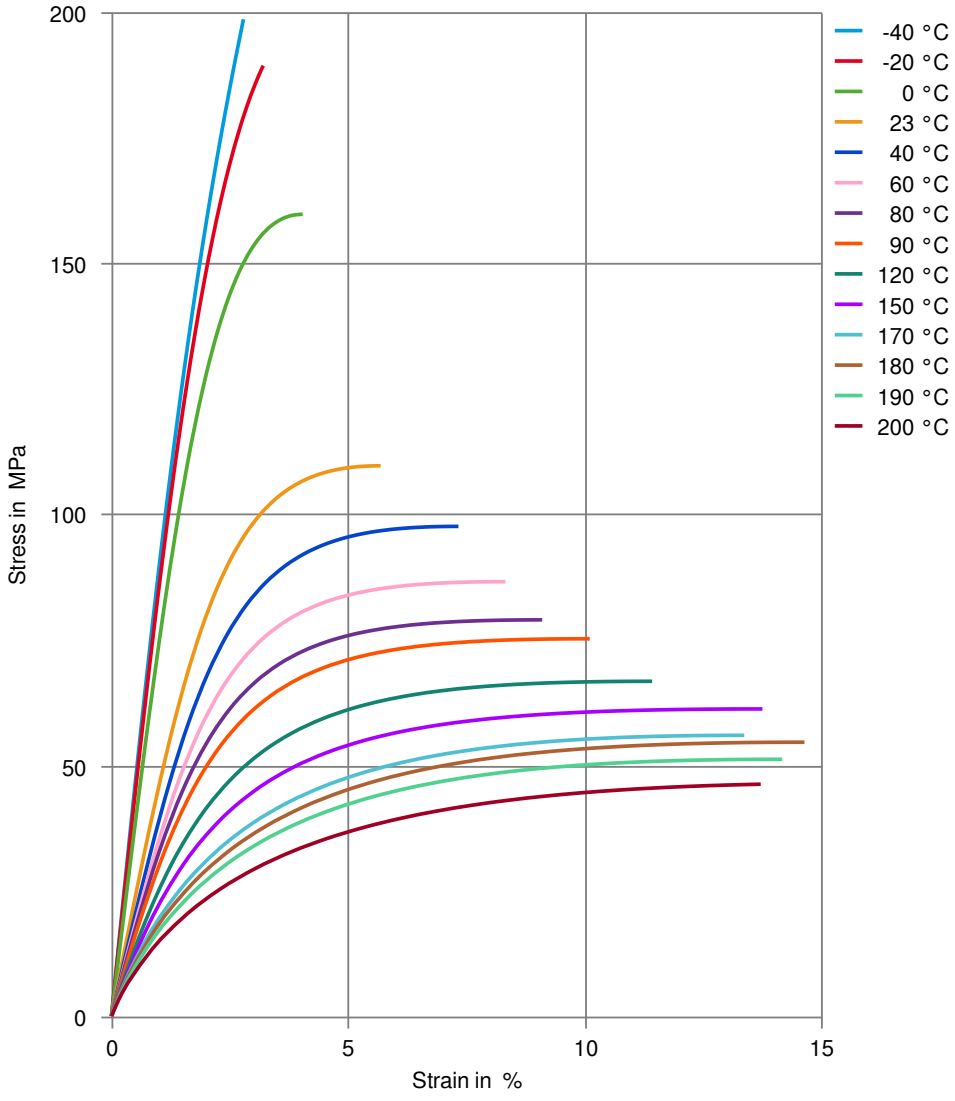
NYLON RESIN

Stress-strain (cond.)



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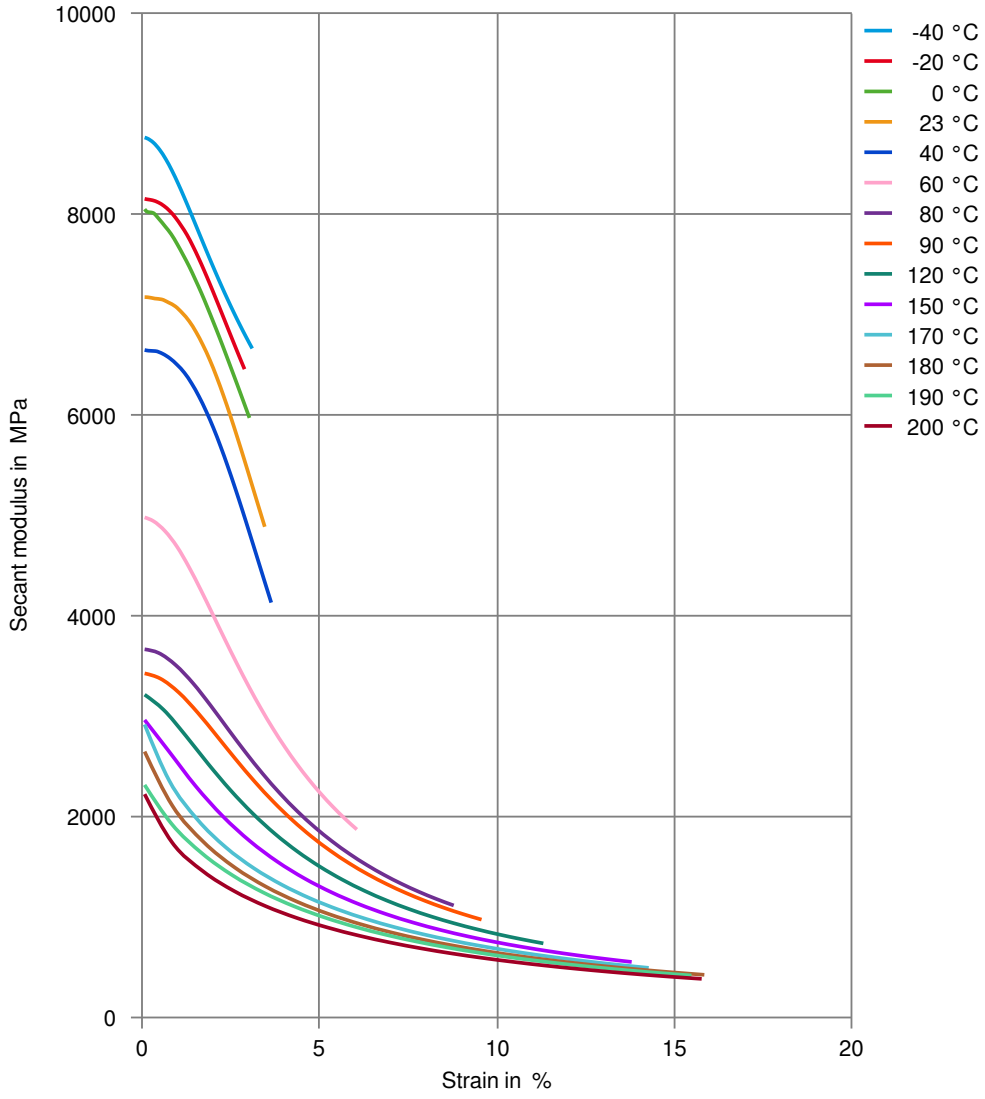
Secant modulus-strain (dry)



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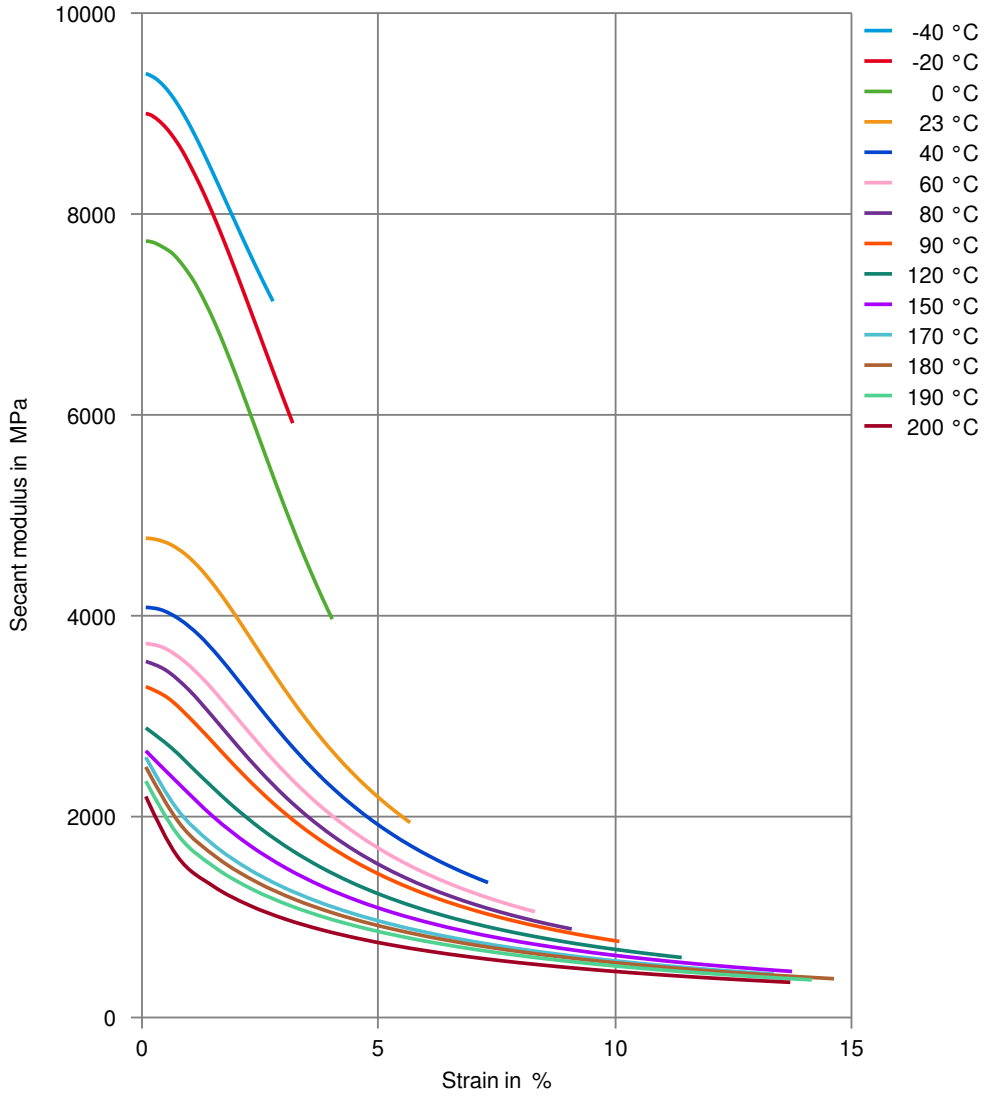
NYLON RESIN

Secant modulus-strain (cond.)



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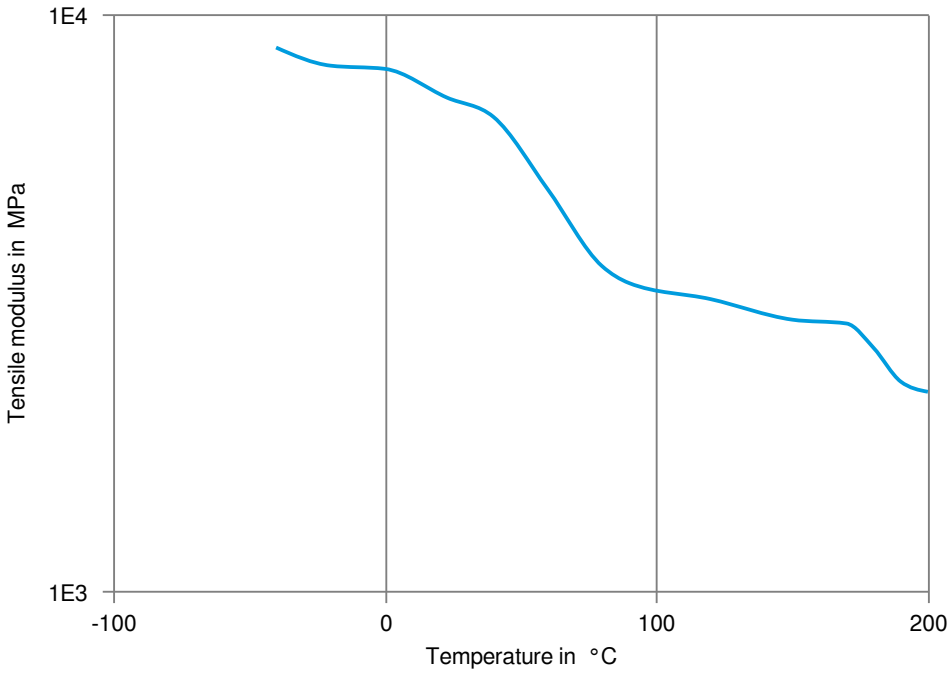
Tensile modulus-temperature (dry)



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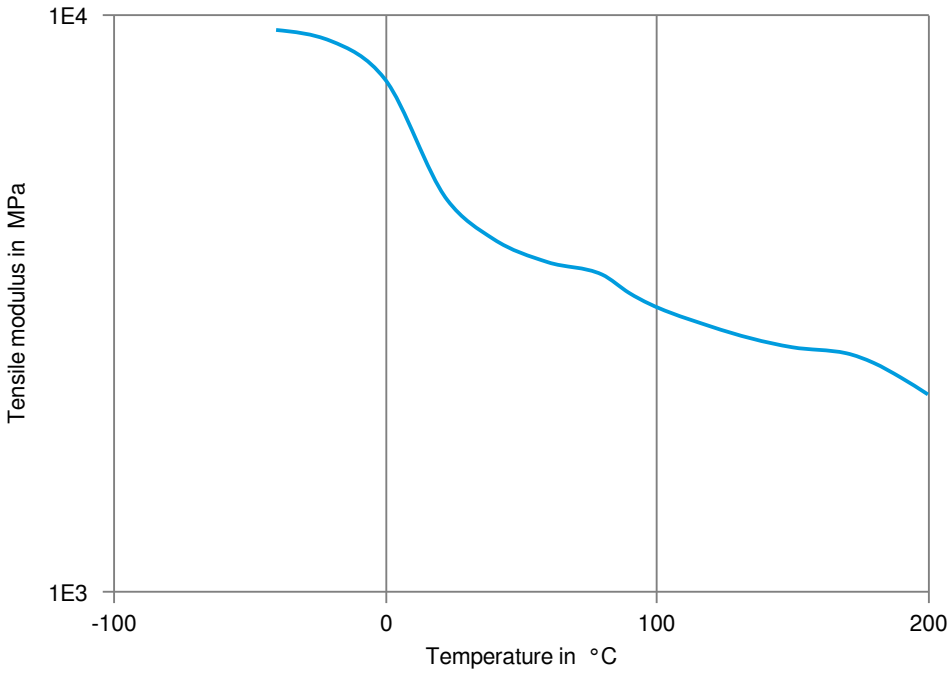
NYLON RESIN

Tensile modulus-temperature (cond.)



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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
- ✔ Hydraulic oil Pentosin CHF 202, 125°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
- ✘ Diesel EN 590, 100°C

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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
- ✔ DOT No. 4 Brake fluid, 120°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).