Celanese
The chemistry inside innovation™

Zytel® 80G33HS1L BK104

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® 80G33HS1L BK104 is a 33% glass fiber reinforced heat stabilised polyamide 66 resin with outstanding impact resistance developed using our Super Tough technology.

Product information

Resin Identification	PA66-IGF33	ISO 1043
Part Marking Code	>PA66-IGF33<	ISO 11469
ISO designation	ISO 16396-PA66-I,GF33,M1CGHR,S14-090	

Rheological properties

	dry/cond.		
Moulding shrinkage, parallel	0.3 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.7 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	8800 / 6500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	148 / 112	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.6 / 6.6	%	ISO 527-1/-2
Flexural modulus	7600 / -	MPa	ISO 178
Flexural strength	210 / -	MPa	ISO 178
Charpy impact strength, 23°C	97 / 96	kJ/m²	ISO 179/1eU
Charpy impact strength, -40°C	109 / 97	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	20 / 27	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	18 / 17	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40°C	18 / -	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	21 / 26	kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	17.0 / 16.0	kJ/m²	ISO 180/1A
Izod notched impact strength, -40°C	15.0 / -	kJ/m²	ISO 180/1A
Izod impact strength, -30°C	87 / -	kJ/m²	ISO 180/1U
Ball indentation hardness, H 961/30	220 / -	MPa	ISO 2039-1
Poisson's ratio	0.34 / 0.35		

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	262 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	75 / 20	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	245 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	261 / *	°C	ISO 75-1/-2

Celanese
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NYLON RESIN

Coeff. of linear therm. expansion, parallel, -40-23°C	25 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	24 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel, 55-160°C	9 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	96 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	100 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, 55-160°C	120 / *	E-6/K	ISO 11359-1/-2
RTI, electrical, 0.75mm	130	°C	UL 746B
RTI, electrical, 1.5mm	130	°C	UL 746B
RTI, electrical, 3.0mm	130	°C	UL 746B
RTI, impact, 0.75mm	65	°C	UL 746B
RTI, impact, 1.5mm	105	°C	UL 746B
RTI, impact, 3.0mm	105	°C	UL 746B
RTI, strength, 0.75mm	85	°C	UL 746B
RTI, strength, 1.5mm	95 / *	°C	UL 746B
RTI, strength, 3.0mm	105	°C	UL 746B

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	yes[1] / *		UL 94
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.75 / *	mm	IEC 60695-11-10
UL recognition	yes / *		UL 94
Glow Wire Flammability Index, 1.0mm	650 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 2.0mm	700 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	900 / -	°C	IEC 60695-2-12
Glow Wire Ignition Temperature, 1.0mm	700 / -	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 2.0mm	700 / -	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3.0mm	750 / -	°C	IEC 60695-2-13
FMVSS Class	SE		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm		mm/min	ISO 3795 (FMVSS 302)

[1]: UL yellow card with (f1)

Electrical properties

	dry/cond.		
Comparative tracking index	- / 400		IEC 60112

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.5 / *	%	Sim. to ISO 62
Water absorption, 2mm	4.5 / *	%	Sim. to ISO 62
Water absorption, Immersion 24h	0.91 / *	%	Sim. to ISO 62
Density	1330 / -	kg/m³	ISO 1183

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VDA Properties

	dry/cond.		
Weather stability grey scale	1		ISO 105-A02
Emission of organic compounds	25.3	µgC/g	VDA 277
Odour	3	class	VDA 270
Fogging, G-value (condensate)	0.8 / *	mg	ISO 6452

Injection

Drying Recommended	yes	
Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	300	°C
Min. melt temperature	290	°C
Max. melt temperature	305	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	95	°C
Min. mould temperature	65	°C
Max. mould temperature	120	°C
Hold pressure range	50 - 100	MPa
Hold pressure time	3	s/mm
Ejection temperature	220	°C

Characteristics

Processing	Injection Moulding
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Ford	WSS-M4D703-B1	
General Motors	GMW17263P-PA66-GF35	Black
Stellantis - Chrysler	MS.50017 / CPN-2735	Black
VW Group	VW 50133 PA66-7-A	

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Zytel® 80G33HS1L BK104

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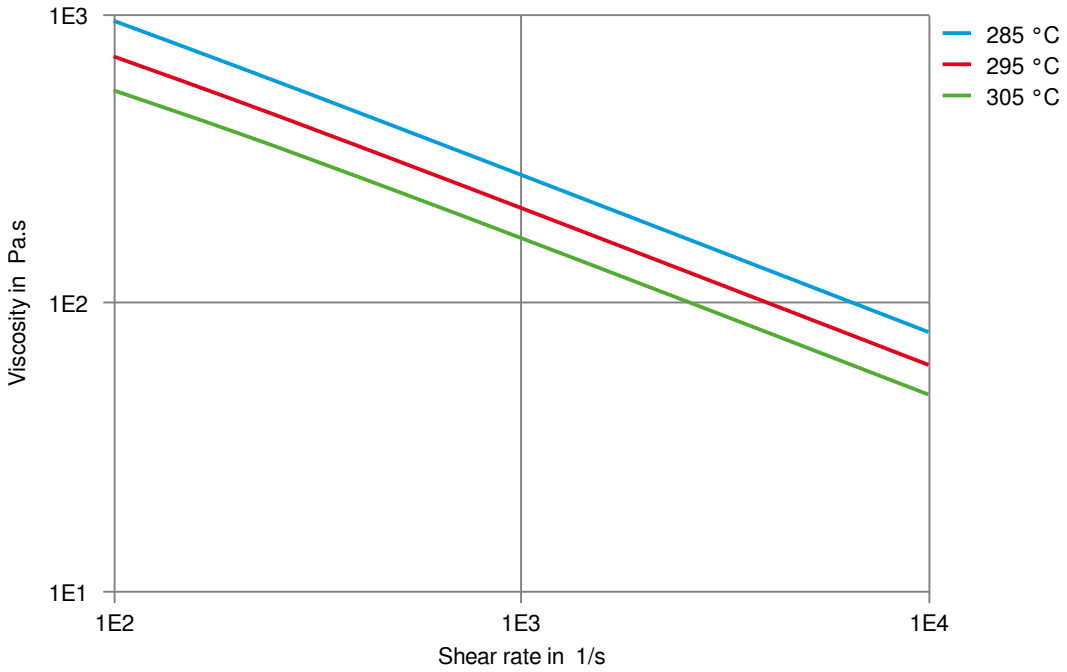
Viscosity-shear rate
(measured on Zytel® 80G33HS1L NC010)



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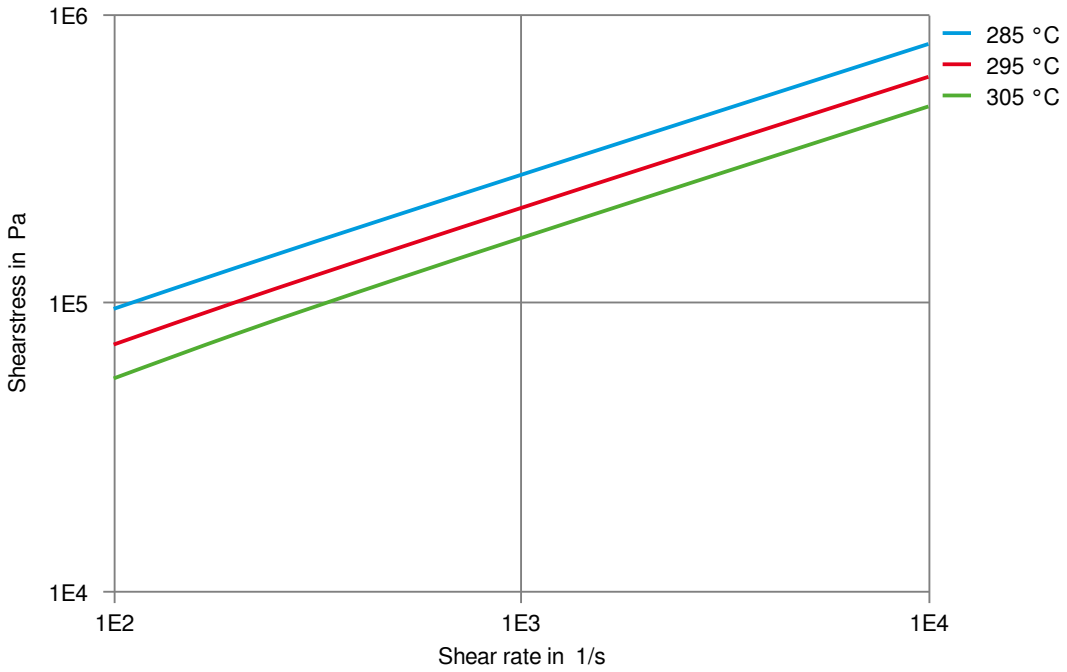
NYLON RESIN

Shearstress-shear rate
(measured on Zytel® 80G33HS1L NC010)



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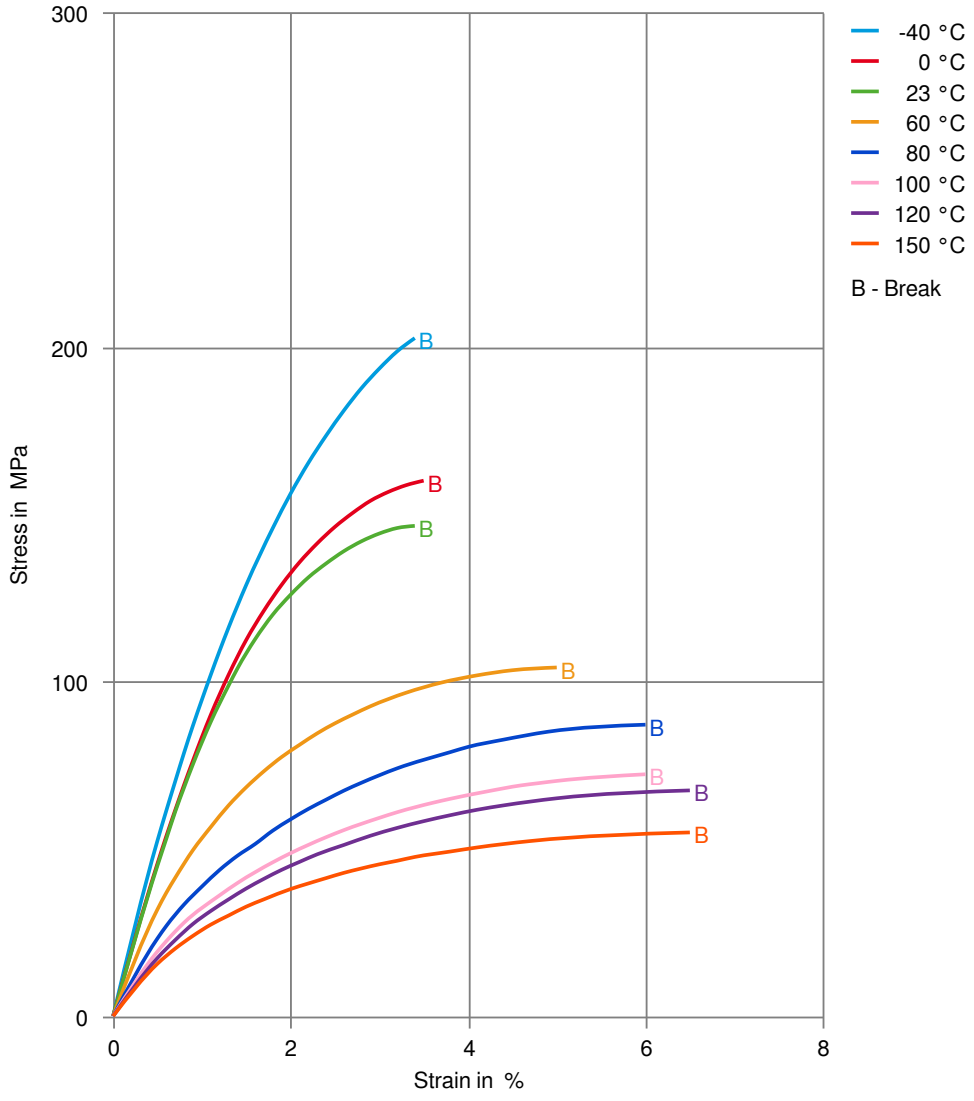
NYLON RESIN

Stress-strain (dry)



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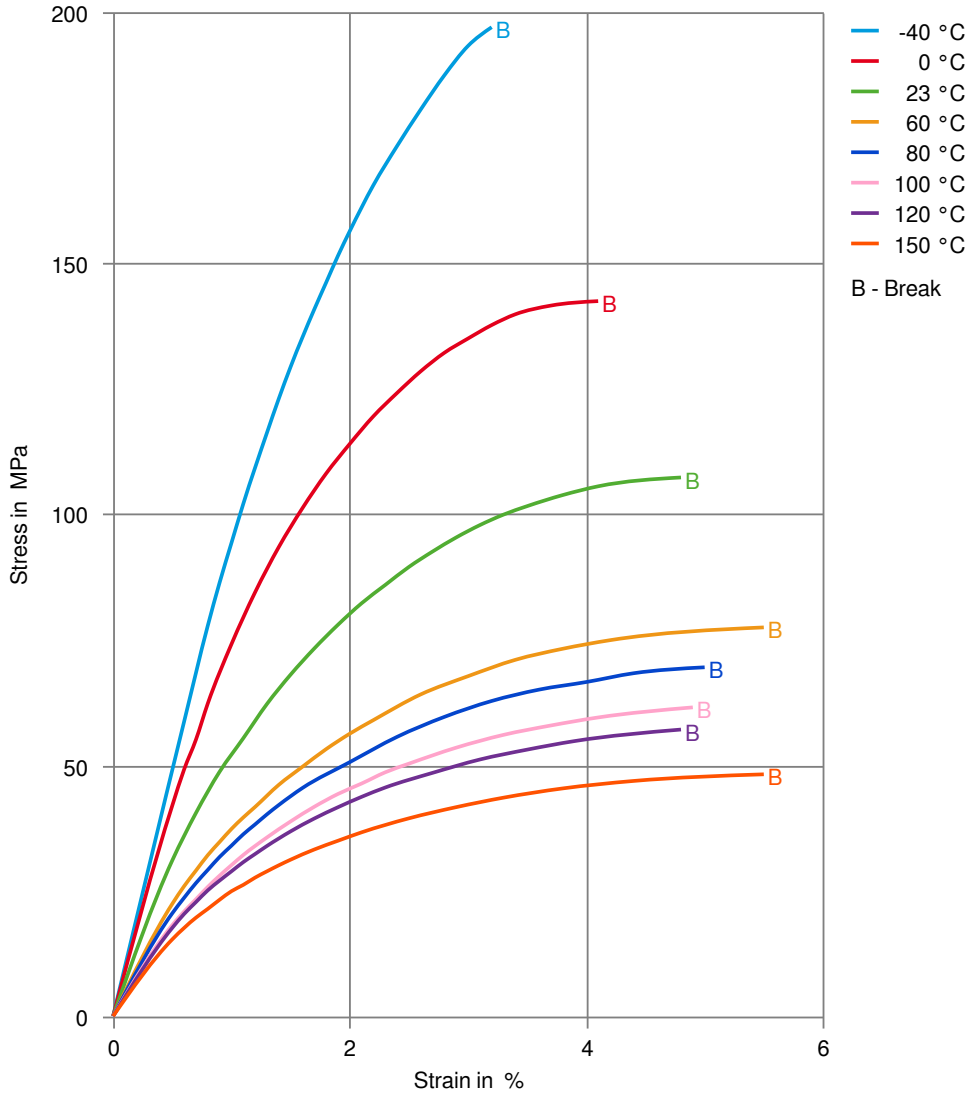
NYLON RESIN

Stress-strain (cond.)



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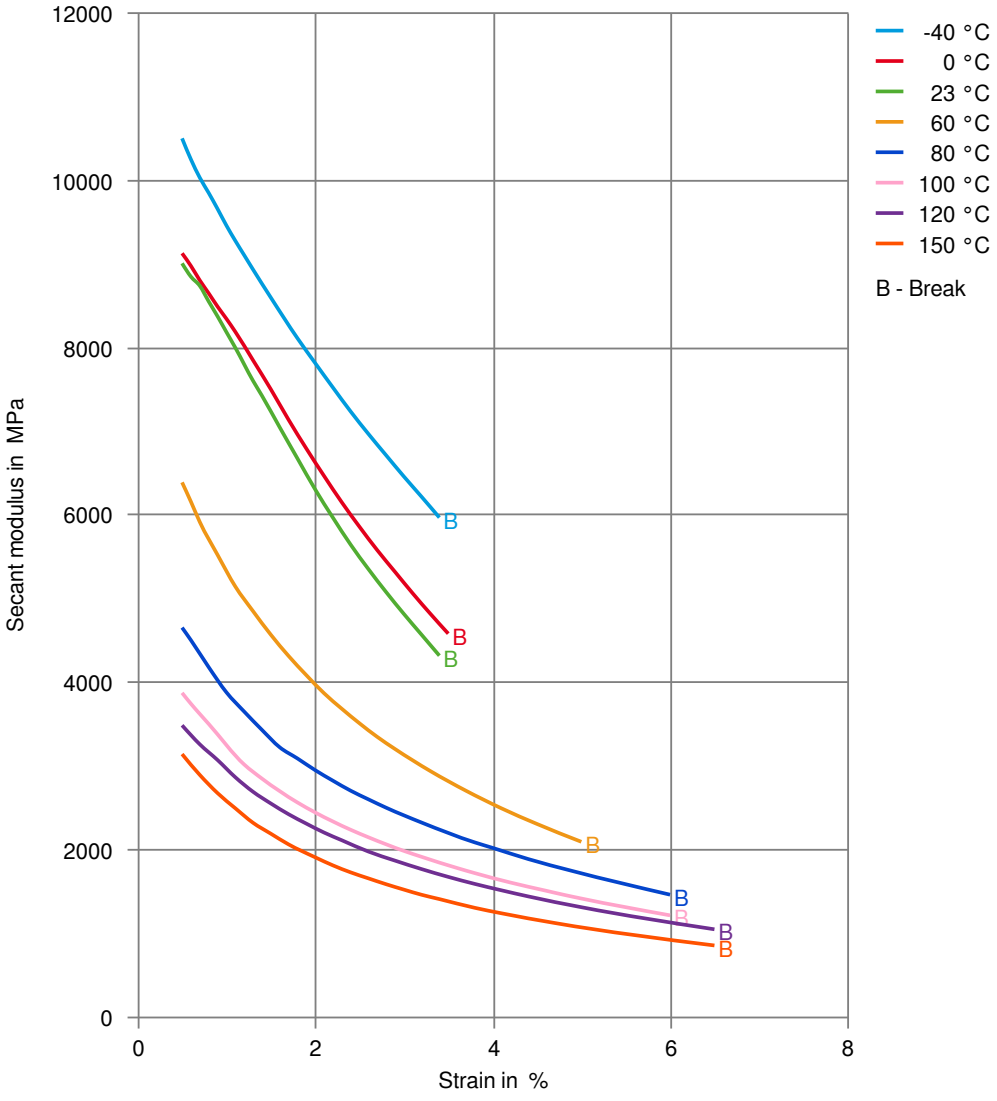
Secant modulus-strain (dry)



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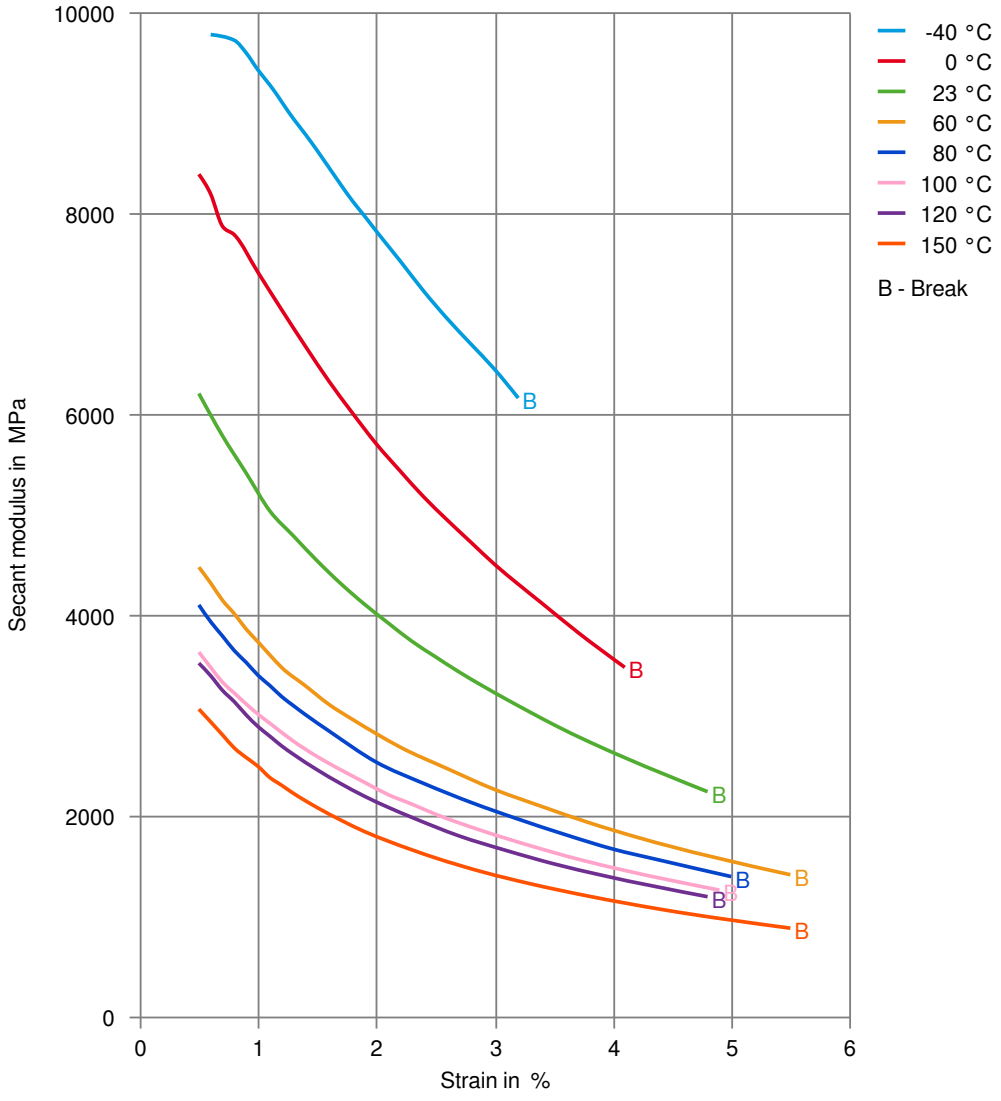
Secant modulus-strain (cond.)



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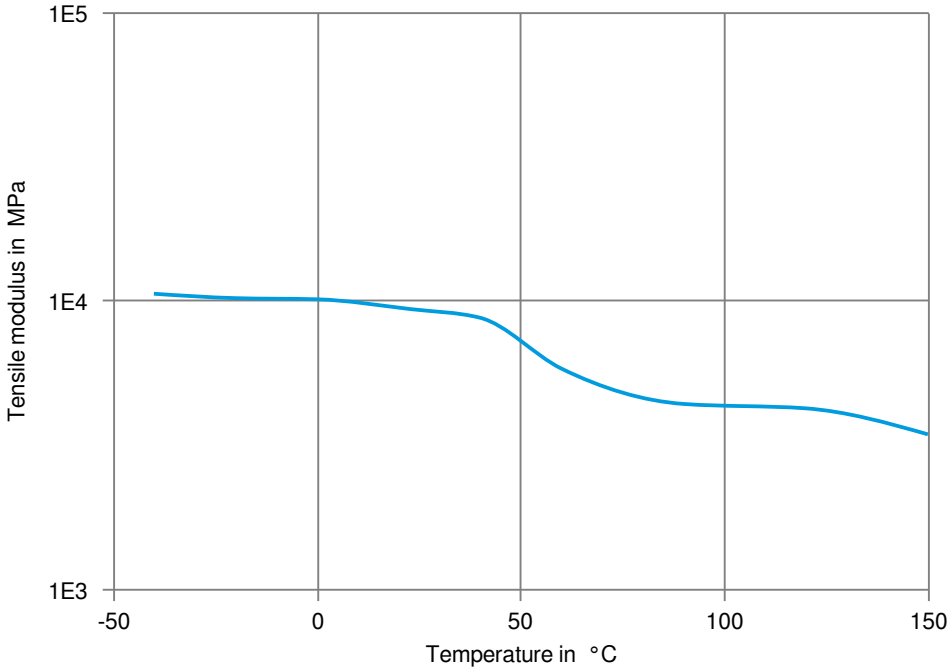
Tensile modulus-temperature (dry)
(measured on Zytel® 80G33HS1L NC010)



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Zytel® 80G33HS1L BK104

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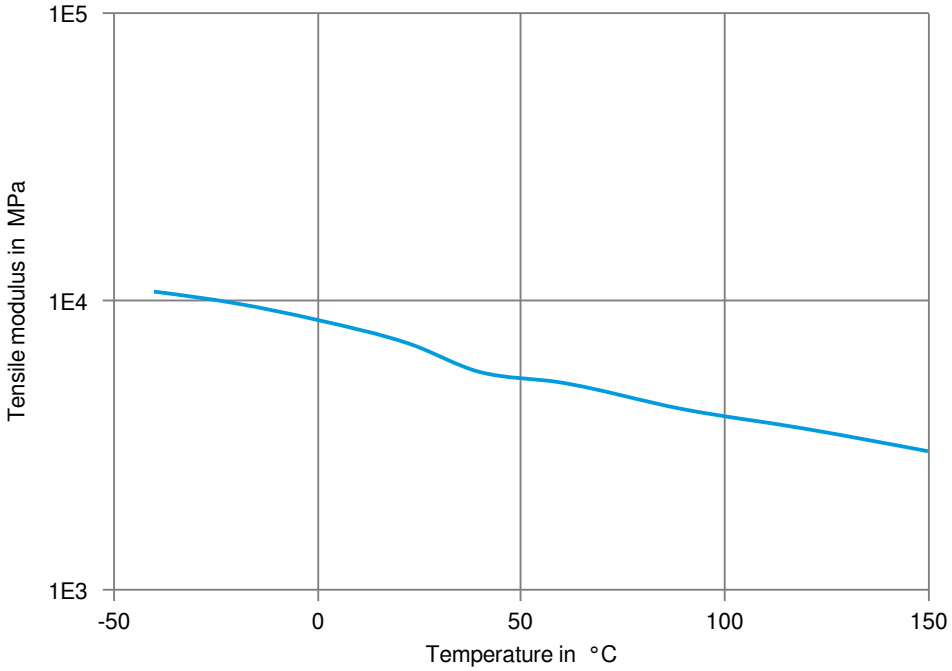
Tensile modulus-temperature (cond.)
(measured on Zytel® 80G33HS1L NC010)



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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
- ✔ 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

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- ✔ 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
- ✔ Urea solution (32.5% 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).