



Zytel® FG70G30HSR2 BK309

NYLON RESIN

Zytel® FG70G30HSR2 BK309 is a 30% Glass Reinforced, Heat Stabilized, Polyamide 66

Product information

Resin Identification	PA66-GF30	ISO 1043
Part Marking Code	>PA66-GF30<	ISO 11469
ISO designation	ISO 16396-PA66,GF30,M1CGHRW,S14-100	

Rheological properties

	dry/cond.		
Viscosity number	158/*	cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage, parallel	0.2/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.0/-	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile Modulus	10000/7000	MPa	ISO 527-1/-2
Stress at break	200/130	MPa	ISO 527-1/-2
Strain at break	3.3/5	%	ISO 527-1/-2
Charpy impact strength, 23°C	70/80	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	12/15	kJ/m ²	ISO 179/1eA
Poisson's ratio	0.34/0.35	-	

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	263/*	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	75/20	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.8 MPa	250/*	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	260/*	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	209/*	°C	ISO 306
Coeff. of linear therm. expansion, parallel	28/*	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	95/*	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.22	W/(m K)	
Eff. thermal diffusivity	6.85E-8	m ² /s	
Spec. heat capacity of melt	2220	J/(kg K)	

Flammability

	dry/cond.		
Oxygen index	24/*	%	ISO 4589-1/-2
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80	mm/min	ISO 3795 (FMVSS 302)



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Electrical properties

Surface resistivity	dry/cond. */1E13	Ohm	IEC 62631-3-2
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Other properties

Density	dry/cond. 1370/-	kg/m ³	ISO 1183
Density of melt	1200	kg/m ³	

Injection

Drying Recommended	yes
Drying Temperature	80 °C
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
Max. screw tangential speed	0.2 m/s
Mold Temperature Optimum	100 °C
Min. mould temperature	50 °C
Max. mould temperature	120 °C
Hold pressure range	50 - 100 MPa
Hold pressure time	3 s/mm
Ejection temperature	210 °C

Characteristics

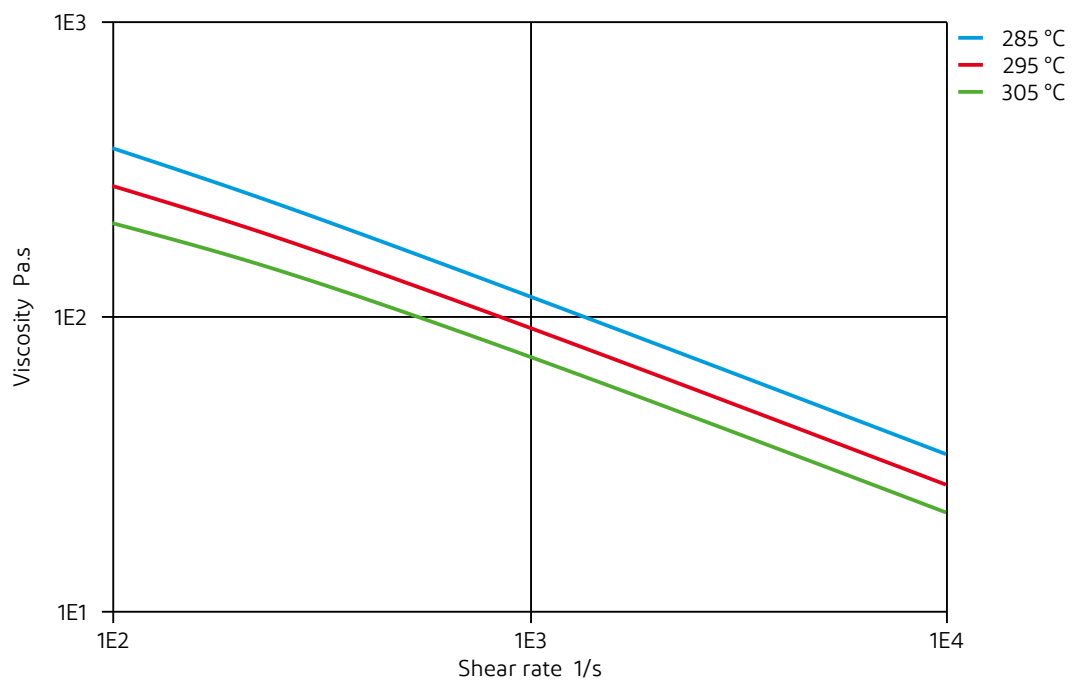
Additives	Release agent
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Viscosity-shear rate

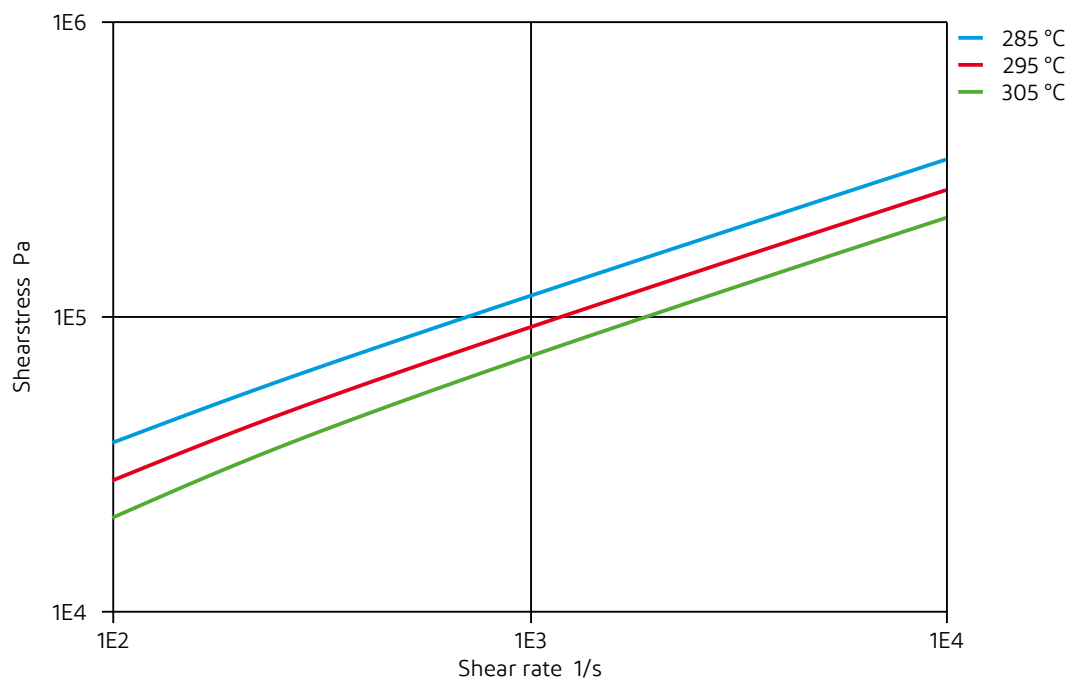




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Shearstress-shear rate

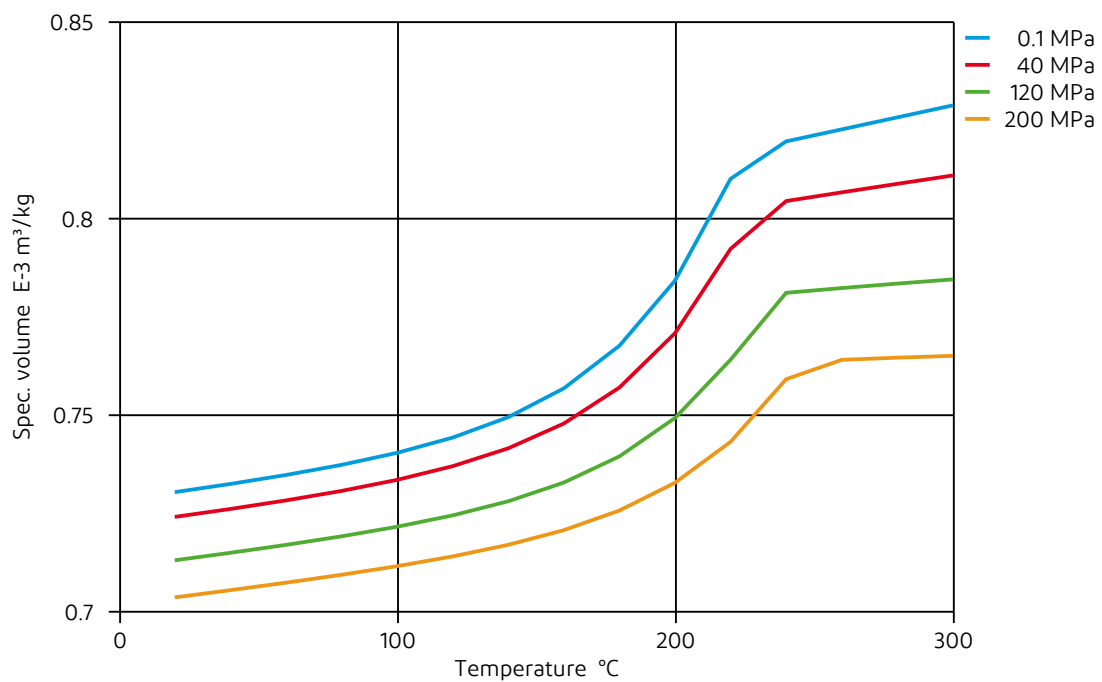




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Specific volume-temperature (pvT)



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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

- ✓ Insulating Oil, 23°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
- ✓ 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



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- ✓ 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).

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