

Zytel® BM7300THS BK317

NYLON RESIN
DuPont Performance Polymers

Message:
Toughened, Heat Stabilized, Polyamide 6 Developed for Blow Molding

General Information				
Additive		heat stabilizer		
		Lubricant		
Features		Thermal Stability		
Uses		Blow molding applications		
RoHS Compliance		Contact manufacturer		
Forms		Particle		
Processing Method		Blow molding		
Multi-Point Data		Isothermal Stress vs. Strain (ISO 11403-1)		
		Secant Modulus vs. Strain (ISO 11403-1)		
		Tensile Modulus vs. Temperature (ISO 11403-1)		
Part Marking Code (ISO 11469)		>PA6-HI		
Resin ID (ISO 1043)		PA6-HI		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.09	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	1.1	--	%	ISO 294-4
Flow	1.1	--	%	ISO 294-4
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2200	600	MPa	ISO 527-2
Tensile Stress (Yield)	60.0	--	MPa	ISO 527-2
Tensile Strain (Yield)	4.2	--	%	ISO 527-2
Nominal Tensile Strain at Break	> 50	--	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	21	22	kJ/m ²	ISO 179/1eA
23°C	45	150	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C ¹	No Break	No Break		ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU

Notched Izod Impact				ISO 180/1A
-30°C	18	20	kJ/m ²	ISO 180/1A
23°C	38	120	kJ/m ²	ISO 180/1A
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	100	--	°C	ISO 75-2/B
1.8 MPa, not annealed	52.0	--	°C	ISO 75-2/A
Melting Temperature ²	220	--	°C	ISO 11357-3
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate ³ (1.00 mm)	< 100	--	mm/min	ISO 3795
FMVSS Flammability	B	--		FMVSS 302
Melt Temperature, Optimum	270		°C	
Mold Temperature, Optimum	70		°C	
Drying Recommended	yes			
Hold Pressure Time	3.00		s/mm	
Maximum Screw Tangential Speed	200		mm/sec	
Fill Analysis	Dry	Conditioned	Unit	Test Method
Melt Viscosity (280°C, 1000 sec ⁻¹)	440000	--	mPa·s	ISO 11443
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time - Desiccant Dryer	2.0 - 4.0		hr	
Suggested Max Moisture	0.20		%	
Processing (Melt) Temp	260 - 280		°C	
Mold Temperature	50 - 100		°C	
Holding Pressure	50.0 - 100		MPa	
NOTE				
1.	Assessed			
2.	10°C/min			
3.	FMVSS 302			

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