

Zytel® 73G40T BK416

NYLON RESIN
DuPont Performance Polymers

Message:
40% Glass Reinforced, Toughened, Polyamide 6

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 40% filler by weight		
RoHS Compliance		Contact manufacturer		
Multi-Point Data		Shear Stress vs. Shear Rate (ISO 11403-1)		
		Viscosity vs. Shear Rate (ISO 11403-2)		
Part Marking Code (ISO 11469)		>PA6-IGF40		
Resin ID (ISO 1043)		PA6-IGF40		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.44	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.50	--	%	ISO 294-4
Flow	0.10	--	%	ISO 294-4
Water Absorption ¹				ISO 62
Saturated, 23°C, 2.00mm	5.3	--	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	1.5	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	12500	8040	MPa	ISO 527-2
Tensile Stress (Break)	210	147	MPa	ISO 527-2
Tensile Strain (Break)	3.8	6.9	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	14	14	kJ/m ²	ISO 179/1eA
23°C	19	23	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ² (23°C)				ISO 179/1eU
	110	120	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)				
	215	--	°C	ISO 75-2/A
Melting Temperature ³				
	220	--	°C	ISO 11357-3
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate ⁴ (1.00 mm)				
	< 100	--	mm/min	ISO 3795
FMVSS Flammability				
	B	--		FMVSS 302

Melt Temperature, Optimum	270		°C	
Mold Temperature, Optimum	100		°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)	190000	--	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	70 - 120		°C	
Holding Pressure	50.0 - 100		MPa	
NOTE				
1.	Derived from Similar Grade			
2.	Derived from Similar Grade			
3.	10°C/min			
4.	FMVSS 302			

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