

Zytel® PLUS PLS95G35DH1 BK549

NYLON RESIN

DuPont Performance Polymers

Message:

35% Glass Reinforced, Heat Stabilized, Polyamide

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 35% filler by weight		
Additive		heat stabilizer		
		demoulding		
Features		Thermal Stability		
RoHS Compliance		Contact manufacturer		
Forms		Particle		
Processing Method		Injection molding		
Multi-Point Data		Creep Modulus vs. Time (ISO 11403-1)		
		Isochronous Stress vs. Strain (ISO 11403-1)		
		Isothermal Stress vs. Strain (ISO 11403-1)		
		Secant Modulus vs. Strain (ISO 11403-1)		
		Shear Stress vs. Shear Rate (ISO 11403-1)		
		Specific Volume vs Temperature (ISO 11403-2)		
		Tensile Fatigue (Wöhler) (ISO 11403-2)		
		Tensile Modulus vs. Temperature (ISO 11403-1)		
		Tensile Modulus vs. Temperature, Dynamic (ISO 11403-1)		
		Viscosity vs. Shear Rate (ISO 11403-2)		
Part Marking Code (ISO 11469)		>PA-GF35		
Resin ID (ISO 1043)		PA-GF35		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.43	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Transverse flow	0.70	--	%	ISO 294-4
Flow	0.20	--	%	ISO 294-4
Water Absorption				ISO 62
Saturated, 23°C, 2.00mm	6.0	--	%	ISO 62
Balance, 23°C, 2.00mm, 50% RH	1.8	--	%	ISO 62
Viscosity Number (96% H2SO4)	130	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	11000	8000	MPa	ISO 527-2

Tensile Stress (Break)	200	140	MPa	ISO 527-2
Tensile Strain (Break)	3.3	6.0	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-40°C	12	--	kJ/m ²	ISO 179/1eA
23°C	13	14	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	70	70	kJ/m ²	ISO 179/1eU
23°C	80	90	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	261	--	°C	ISO 75-2/B
1.8 MPa, not annealed	242	--	°C	ISO 75-2/A
Glass Transition Temperature ¹	85.0	--	°C	ISO 11357-2
Melting Temperature ²	265	--	°C	ISO 11357-3
Linear thermal expansion coefficient				ISO 11359-2
Flow	1.8E-5	--	cm/cm/°C	ISO 11359-2
Lateral	7.2E-5	--	cm/cm/°C	ISO 11359-2
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate ³ (1.00 mm)	< 100	--	mm/min	ISO 3795
Flammability Classification (1.5 mm)	HB	--		IEC 60695-11-10, -20
FMVSS Flammability	B	--		FMVSS 302
Specific Heat Capacity of Melt	2300	--	J/kg/°C	
Thermal Conductivity of Melt	0.22	--	W/m/K	
Melt Temperature, Optimum	280		°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	
Melt Density	1.26	--	g/cm ³	
Ejection Temperature	210	--	°C	
Injection	Dry	Unit		
Drying Temperature	80		°C	

Drying Time - Desiccant Dryer	2.0 - 4.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	275 - 285	°C
Mold Temperature	70 - 120	°C
Holding Pressure	50.0 - 100	MPa

NOTE		
1.	10°C/min	
2.	10°C/min	
3.	FMVSS 302	

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