

# DuPont™ Zytel® 70G33HS1L BK031

## NYLON RESIN

Product Information

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, DuPont recommends, 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® 70G33HS1L BK031 is a 33% glass fiber reinforced, heat stabilized polyamide 66 resin for injection molding.**

General information	Value	Unit	Test Standard
Resin Identification	PA66-GF33	-	ISO 1043
Part Marking Code	PA66-GF33	-	ISO 11469
Rheological properties	dry / cond	Unit	Test Standard
Molding shrinkage, parallel	0.3 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1 / -	%	ISO 294-4, 2577
Mechanical properties	dry / cond	Unit	Test Standard
Tensile Modulus	11000 / 8000	MPa	ISO 527-1/-2
Stress at break	200 / 140	MPa	ISO 527-1/-2
Strain at break	3 / 5.4	%	ISO 527-1/-2
Flexural Modulus	9500 / 6000	MPa	ISO 178
Flexural Strength	280 / 195	MPa	ISO 178
Charpy impact strength, 73°F	75 / 80	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength			ISO 179/1eA
73°F	13 / 17	kJ/m <sup>2</sup>	
-40°F	10 / 10	kJ/m <sup>2</sup>	
Izod notched impact strength			ISO 180/1A
73°F	12 / 15	kJ/m <sup>2</sup>	
-40°F	10 / 10	kJ/m <sup>2</sup>	
Thermal properties	dry / cond	Unit	Test Standard
Melting temperature, 18°F/min	262 / *	°C	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
260 psi	252 / *	°C	
65 psi	261 / *	°C	
Coeff. of linear therm. expansion, parallel	18 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion			ISO 11359-1/-2
normal	83 / *	E-6/K	
Normal, -40-23°C	65 / *	E-6/K	
Normal, 55-160°C	140 / *	E-6/K	
Parallel, -40-23°C	24 / *	E-6/K	
Parallel, 55-160°C	13 / *	E-6/K	
RTI, electrical			UL 746B
30mil	140 / *	°C	
60mil	140 / *	°C	
120mil	140	°C	
RTI, impact			UL 746B
30mil	125	°C	
60mil	125 / *	°C	
120mil	125	°C	

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RTI, strength			UL 746B
30mil	140	°C	
60mil	140 / *	°C	
120mil	140	°C	
<b>Flammability</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Burning Behav. at 60mil nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
UL recognition	yes / *	-	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			IEC 60695-2-12
30mil	725 / -	°C	
60mil	700 / -	°C	
120mil	800 / -	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
30mil	750 / -	°C	
60mil	725 / -	°C	
120mil	825 / -	°C	
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	28	mm/min	ISO 3795 (FMVSS 302)
<b>Electrical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Comparative tracking index			
Comparative tracking index	400 / -	-	IEC 60112
CTI, 23°C	1 / -	PLC	UL 746A
Electric Strength, Short Time, 2mm	18 / -	kV/mm	IEC 60243-1
<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Humidity absorption, 80mil	1.8 / *	%	Sim. to ISO 62
Water absorption, 80mil	5.7 / *	%	Sim. to ISO 62
Density	1390 / -	kg/m <sup>3</sup>	ISO 1183
<b>VDA Properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Emission of organic compounds	10	µgC/g	VDA 277
Odor test	3	class	VDA 270
Fogging, G-value (condensate)	0.6 / *	mg	ISO 6452
<b>Injection</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Drying Recommended	yes	-	-
Drying Temperature	≥80	°C	-
Drying Time, Dehumidified Dryer	2 - 4	h	-
Processing Moisture Content	≤0.2	%	-
Melt Temperature Optimum	285	°C	-
Min. melt temperature	275	°C	-
Max. melt temperature	295 <sup>(1)</sup>	°C	-
Max. screw tangential speed	0.2 / *	m/s	-
Mold Temperature Optimum	100	°C	-
Min. mold temperature	70	°C	-
Max. mold temperature	120	°C	-
Hold pressure range	50 - 100	MPa	-
Hold pressure time	3	s/mm	-
Ejection temperature	210	°C	-

1: Melt temp can be up to 305C in case of moisture is low and HUT is short.

### Characteristics

Processing	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>
Special characteristics	<ul style="list-style-type: none"> <li>Heat stabilized or stable to heat</li> </ul>

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Regional Availability

- North America
- Europe

- Asia Pacific
- South and Central America

- Near East/Africa
- Global

Processing Texts

Injection molding

Maximum hold up time should be 10 minutes.

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

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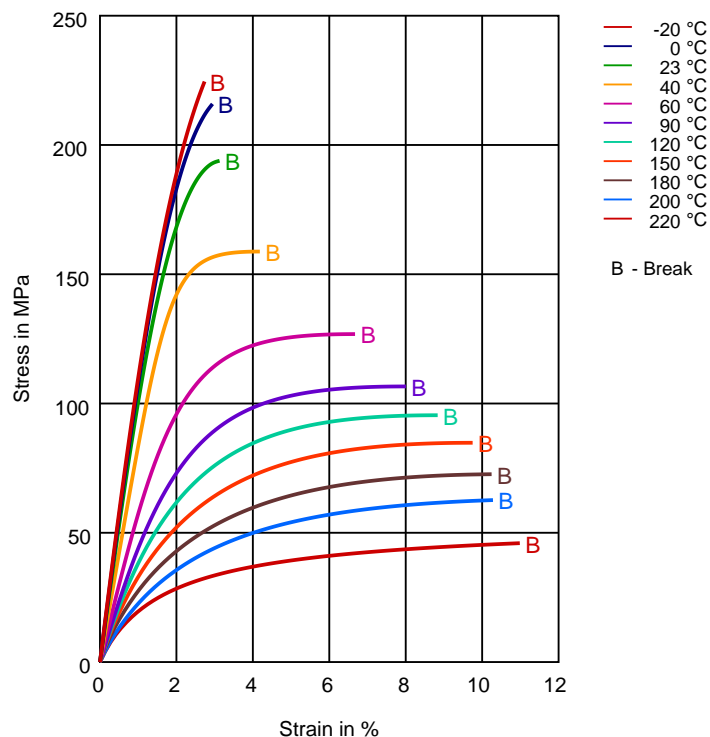
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# DuPont™ Zytel® 70G33HS1L BK031 NYLON RESIN

Diagrams

Stress-strain (dry)



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North America

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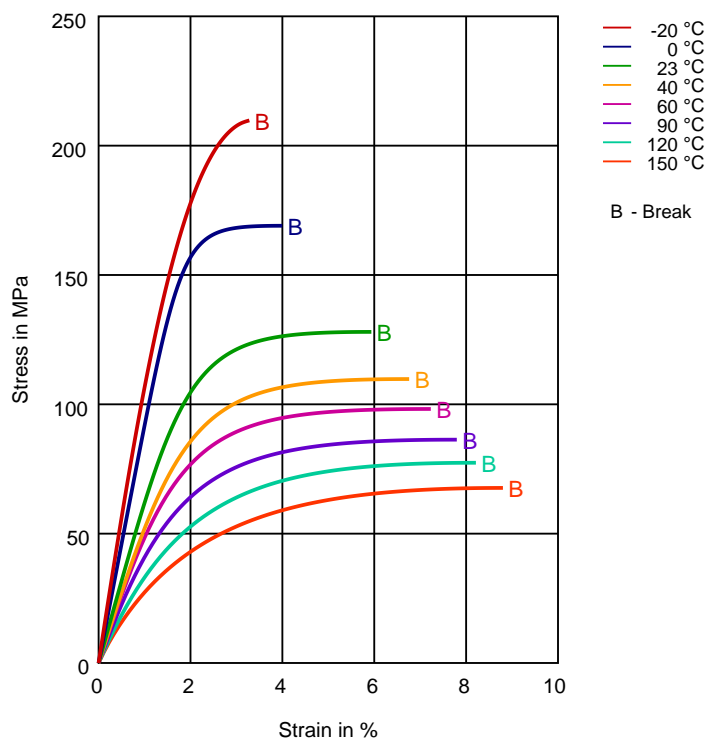
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# DuPont™ Zytel® 70G33HS1L BK031 NYLON RESIN

Stress-strain (cond.)



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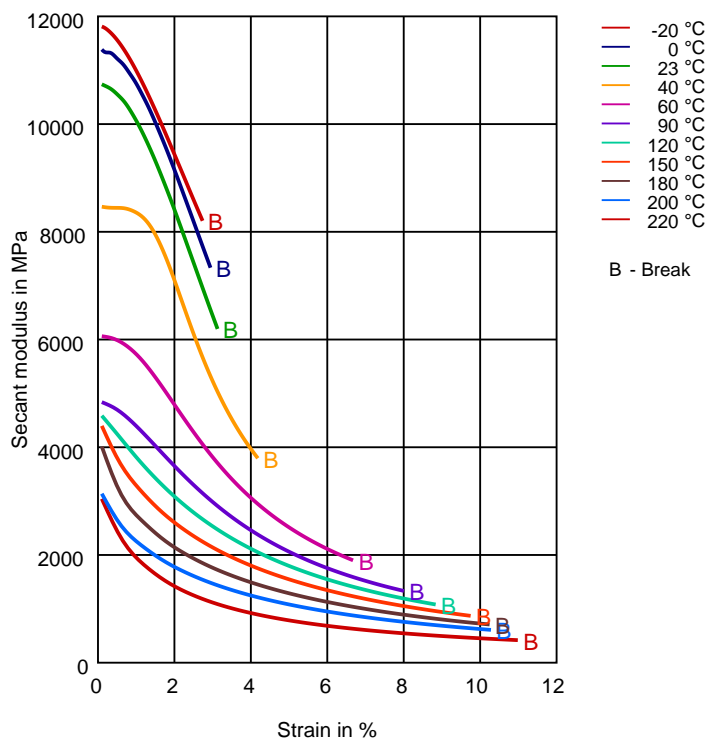
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# DuPont™ Zytel® 70G33HS1L BK031 NYLON RESIN

Secant modulus-strain (dry)



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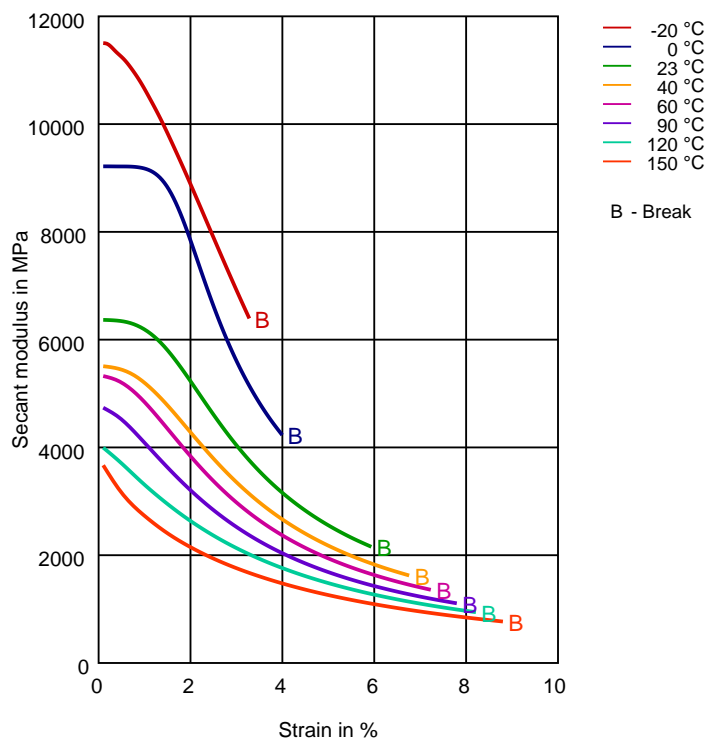
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Secant modulus-strain (cond.)



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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)
- ✓ Motor oil OS206 304 Ref.Eng.Oil, ISP (135°C)
- ✓ Automatic hypoid-gear oil Shell Donax TX (135°C)
- ✓ Hydraulic oil Pentosin CHF 202 (125°C)

#### Standard Fuels

- ✓ ISO 1817 Liquid 1 - E5 (60°C)
- ✓ ISO 1817 Liquid 2 - M15E4 (60°C)
- ✓ ISO 1817 Liquid 3 - M3E7 (60°C)





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- ✓ 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)
- ✓ 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)

### 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).

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrek® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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