INJECTION DATASHEET

Zytel® FN727 NC010A

NYLON RESIN

Zytel® FN727 NC010A is an impact modified, plasticizer free, very flexible polyamide 6 alloy resin having good low temperature toughness, good heat aging and good chemical resistance. Uses include cable jacketing, hose and tube applications.

General Information

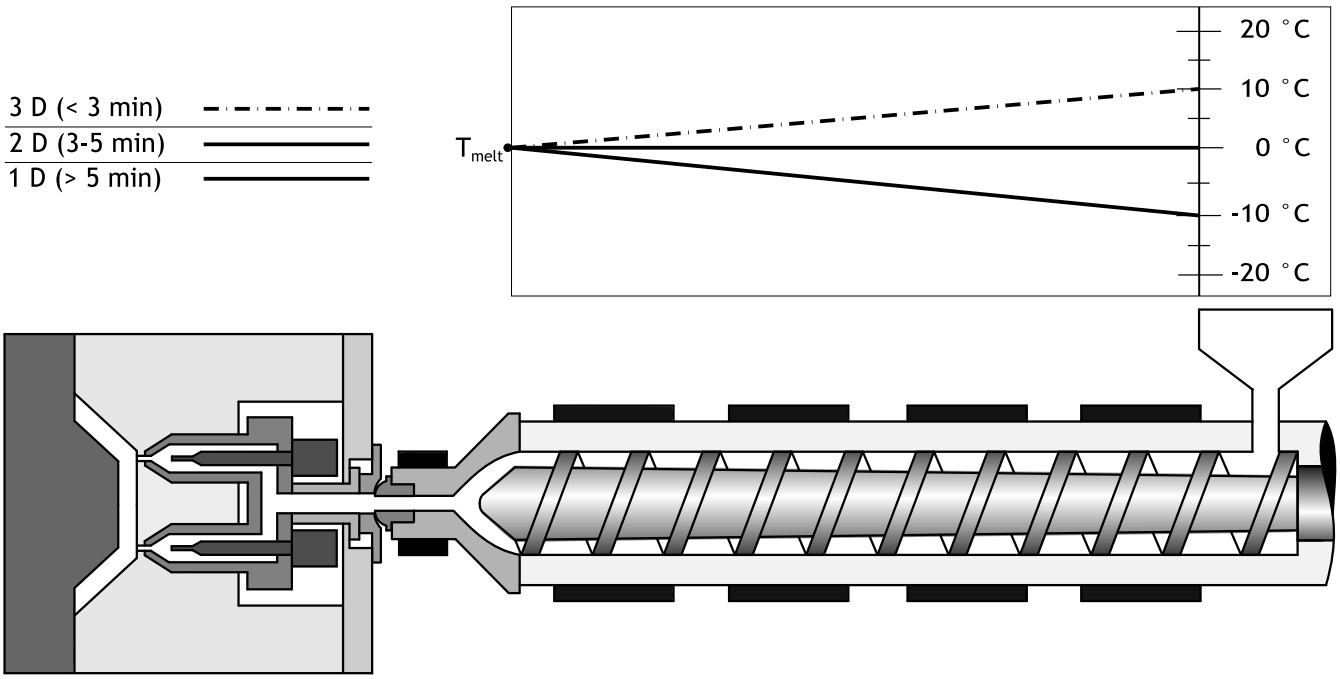
Resin Identification ISO 1043	PA6-F
Density ISO 1183	1020/- kg/m³

Drying

Drying Recommended	yes
Drying Time*	2 - 4 h
Processing Moisture Content - Optimum**	0.1 %
Processing Moisture Content	≤0.1 %

Temperature settings

Melt Temperature Optimum Internal	260 °C
Min. melt temperature***	250 °C
Max. melt temperature	280 °C
Min. mould temperature	40 °C
Max. mould temperature	80 °C



INJECTION DATASHEET

Zytel® FN727 NC010A

NYLON RESIN

Recommended general settings

Residence time - optimum range	3 - 5 min
Residence time - maximum	10 min
Hold Pressure Time	$1.5h^2+2$ s

(h is the max. wall thickness of the part in mm)

$$\text{Residence time} = \frac{8*\text{screw } \varnothing \text{ [mm]}*\text{cycle time [s]}}{60*\text{dosing stroke [mm]}}$$

Hot runner residence time not included in calculation

Special precautions

During molding, use proper protective equipment and adequate ventilation. Avoid fumes and limit the residence time and temperature of the resin in the machine.

Links for further information

Trouble Shooting Guide
For further information e.g. on Shrinkage, Hot runner systems, Venting, Gating, Drying and moisture measurement, Regrind, Purging, please refer to the detailed Molding Guide.

Footnotes:

*	Improper storage may lead to longer drying times
**	Excessive drying may lead to viscosity increase during processing. A discoloration of natural colored materials is possible.
***	Using melt temperature lower than recommended could create unmelt, leading to weak parts