

Zytel® PLS93G35DH1 BK549

ZYTEL® PLUS & XT NYLON RESIN

Zytel® PLS93G35DH1 is a 35% glass fibre reinforced, SHIELD protected polyamide 6 for injection moulding. It provides exceptional welding resistance and excellent heat resistance.

General Information

Resin Identification ISO 1043

Density ISO 1183

PA6-GF35

1400/- kg/m³

Drying

Drying Recommended

yes

Drying Temperature**

80 °C

Drying Time*

2 - 4 h

Processing Moisture Content - Optimum**

0.05 %

Processing Moisture Content

≤0.2 %

Temperature settings

Melt Temperature Optimum Internal

270 °C

Min. melt temperature***

260 °C

Max. melt temperature

280 °C

Mold Temperature Optimum

100 °C

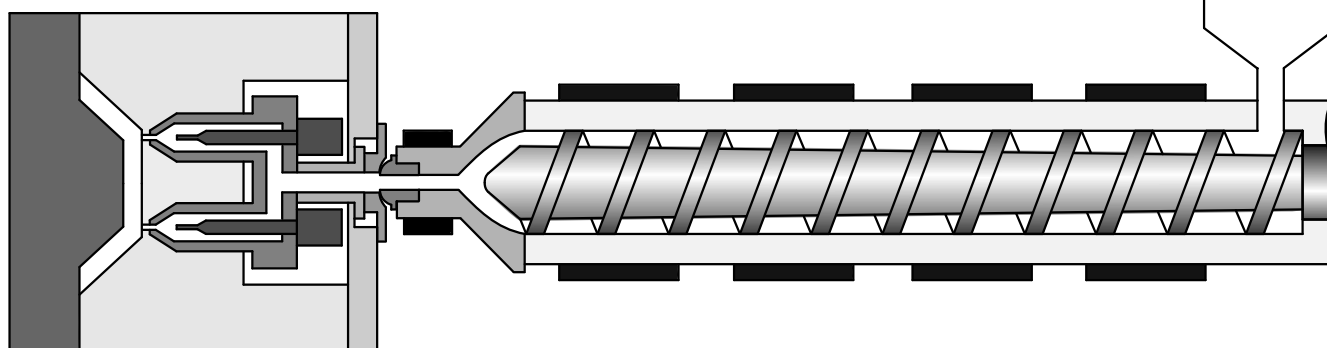
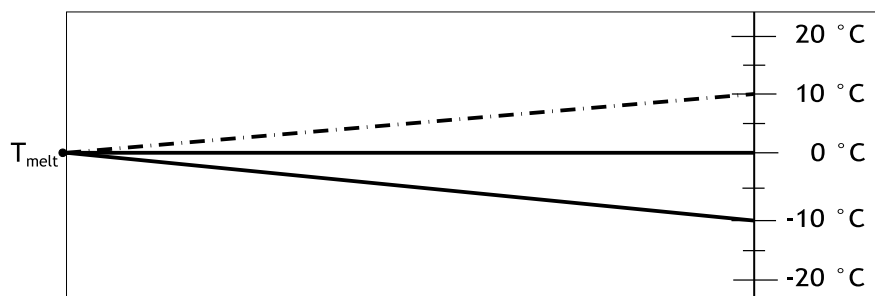
Min. mould temperature

70 °C

Max. mould temperature

120 °C

3 D (< 3 min)	---
2 D (3-5 min)	==
1 D (> 5 min)	---



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Recommended general settings

Residence time - optimum range	3 - 5 min
Residence time - maximum	10 min
Hold pressure range	50 - 100 MPa
Hold Pressure Time	$h^2 + 2$ s
(h is the max. wall thickness of the part in mm)	
Max. screw tangential speed	≤ 0.2 m/s

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

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