

Zytel® BM70G20HSLX BK537

NYLON RESIN

Product Description

Zytel® BM70G20HSLX BK537 is a 20% glass fiber reinforced polyamide 66 for blow molding.

General

Material Status	• Preliminary Data ¹		
Availability	• Africa & Middle East • Asia Pacific • Central America	• Europe • Latin America • North America	• South America
Filler / Reinforcement	• Glass Fiber Reinforcement, 20% Filler by Weight		
RoHS Compliance	• Contact Manufacturer		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Blow Molding		
Part Marking Code (ISO 11469)	• >PA66-IGF20<		
Resin ID (ISO 1043)	• PA66-IGF20		
Product Category	• Blow Moldable Resins	• Glass Reinforced Resins	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.25	--	g/cm ³	ISO 1183
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	6400	4000	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	120	70.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	3.9	14	%	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	14	15	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	72	72	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	9.0	9.0	kJ/m ²	ISO 180/1A
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature 1.8 MPa, Unannealed	237	--	°C	ISO 75-2/A
Melting Temperature ³	262	--	°C	ISO 11357-3
Additional Information	Dry	Conditioned	Unit	
Drying Temperature - Blow Molding	100 to 110	--	°C	
Drying Time - Dehumidified Dryer, Blow Molding	4.0 to 5.0	--	hr	
Melt Temperature - Blow Molding	285 to 305	--	°C	
Processing Moisture Content - Blow Molding	< 0.050	--	%	

Injection	Dry Unit
Drying Temperature	80.0 °C
Drying Time - Desiccant Dryer	2.0 to 4.0 hr
Suggested Max Moisture	< 0.20 %
Processing (Melt) Temp	285 to 305 °C
Melt Temperature, Optimum	
Blow Molding	290 °C
Injection Molding	295 °C
Mold Temperature	70.0 to 120 °C
Mold Temperature, Optimum - Injection Molding	100 °C
Drying Recommended	Yes, if moisture content of resin exceeds recommended level

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Extrusion	Dry Unit
Drying Temperature	80.0 °C
Drying Time	4.0 to 6.0 hr
Suggested Max Moisture	< 0.060 %
Melt Temperature	275 to 290 °C
Extrusion Melt Temperature, Optimum	285 °C

Notes

¹ The above data are preliminary and are subject to change as additional data are developed on subsequent lots.

² Typical properties: these are not to be construed as specifications.

³ 10°C/min

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc.

ISO Mechanical properties measured at 4.0mm, ISO Electrical properties measured at 2.0mm, and all ASTM properties measured at 3.2mm.

Test temperatures are 23°C unless otherwise stated.

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