

DuPont™ Zytel®

nylon resin

PRELIMINARY DATA

Zytel® FR7280V0 BK031

Zytel® FR7280V0 BK031 is an unreinforced, flame retardant polyamide 66/6 copolymer for injection molding. It is modified for improved toughness and elongation at break.

Property	Test Method	Units	Value
			DAM
Identification			
Resin Identification	ISO 1043		PA66/6-FR(16)
Part Marking Code	ISO 11469		>PA66/6-FR(16)<
Mechanical			
Yield Stress	ISO 527	MPa (kpsi)	40 (6)
Yield Strain	ISO 527	%	56
Flexural Modulus	ISO 178	MPa (kpsi)	2300 (300)
Flexural Strength	ISO 178	MPa (kpsi)	72 (10)
Notched Charpy Impact Strength	ISO 179/1eA	kJ/m ²	
-40°C (-40°F)			3
23°C (73°F)			5
Unnotched Charpy Impact Strength	ISO 179/1eU	kJ/m ²	
-40°C (-40°F)			69
23°C (73°F)			83

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.

During molding, use proper protective equipment and adequate ventilation. Avoid exposure to fumes and limit the hold up time and temperature of the resin in the machine. Purge degraded resin carefully with HDPE.

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

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Property	Test Method	Units	Value
			DAM
Electrical			
Surface Resistivity	IEC 60093	ohm	4E15
Volume Resistivity	IEC 60093	ohm m	1E13
Dielectric Constant	IEC 60250	E-4	
1E2 Hz			3.3
1E6 Hz			2.9
Dissipation Factor	IEC 60250	E-4	
1E2 Hz			0.04
1E6 Hz			0.02
CTI	IEC 60112	V	200
Other			
Density	ISO 1183	kg/m ³ (g/cm ³)	1360 (1.36)
Molding Shrinkage	ISO 294-4	%	
Normal, 2.0mm			1.5
Parallel, 2.0mm			1.6
Processing			
Melt Temperature Range		°C (°F)	255-275 (490-530)
Melt Temperature Optimum		°C (°F)	265 (510)
Mold Temperature Range		°C (°F)	50-90 (120-190)
Mold Temperature Optimum		°C (°F)	70 (160)
Drying Time, Dehumidified Dryer		h	2-4
Drying Temperature		°C (°F)	80 (175)
Processing Moisture Content		%	<0.20

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