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ZYTEL® T70 ECO-R 311 BLK1

NYLON RESIN

Zytel® T70 ECO-R 311 BLK1 incorporates 30% of post-industrial recycled content by weight in the finished product. It is a general purpose PA66 grade with improved flexibility.

Product information			
Resin Identification	PA66-I(R30)		ISO 1043
Part Marking Code	>PA66-I(R30)<		ISO 11469
Rheological properties			
Moulding shrinkage range, parallel	1.3 - 1.8		ISO 294-4, 2577
Moulding shrinkage range, normal	1.3 - 1.8	%	ISO 294-4, 2577
Typical mechanical properties	dry/cond.		
Tensile modulus	2900/-	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	70/-	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	5/-	%	ISO 527-1/-2
Tensile stress at break, 50mm/min	60/-	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	25/-	%	ISO 527-1/-2
Flexural modulus	2600/-	MPa	ISO 178
Flexural strength	100/- 180/-	MPa kJ/m²	ISO 178 ISO 179/1eU
Charpy impact strength, 23°C Charpy notched impact strength, 23°C	7.5/-	kJ/m²	ISO 179/1eO
Charpy notched impact strength, -30°C	7.5/- 5/-	kJ/m²	ISO 179/1eA
Poisson's ratio	0.37/- ^[C]	10/111	100 170/10/1
[C]: Calculated			
Thermal properties	dry/cond.		
Melting temperature, 10°C/min	265/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	65/*	°C	ISO 75-1/-2
Physical/Other properties	dry/cond.		
Humidity absorption, 2mm	2.2/*	%	Sim. to ISO 62
Water absorption, 2mm	7.9/*	%	Sim. to ISO 62
Density	1120/-	kg/m³	ISO 1183
Injection			
Drying Recommended	yes		
Drying Temperature	-	°C	
Drying Time, Dehumidified Dryer	2-4 h		
Processing Moisture Content	≤0.15 %		
Melt Temperature Optimum	290 °C		
Min. melt temperature	280		
Max. melt temperature	300		
Screw tangential speed	≤0.3		
Mold Temperature Optimum	80	°C	

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Min. mould temperature 50 °C Max. mould temperature 100 °C

Characteristics

Processing Injection Moulding

Delivery form Granules
Additives Nucleated

Special characteristics High impact or impact modified, Heat stabilised or stable to heat

Sustainability Recycled Content

Additional information

Injection molding

Preprocessing

PA materials, stocked in a moisture-proof packaging, can be processed without drying; however, it is always recommended drying the product that comes from a large package (e.g. Octabin). The moisture content suggested for the injection molding process should be lower than 0.15%, according to the grade and to the molded part characteristics. The materials containing flame retardants should have moisture content below 0.10%. Red phosphorous containing grades must always be dried below 0.08%. The drying time depends on the moisture content and the drying conditions. Typically, 4-8 hours at 80-90°C using dehumidified air (dew point of -20°C) are suitable conditions for a starting moisture content of 0.20%-0.40%.

Processing

The following conditions apply to a standard injection molding process. Machine temperatures: barrel 265-290°C (PA66), 235-270°C (PA6), nozzle and hot runners up to 300°C (up to 290°C products with flame retardants). Mold temperatures: 60-80°C, (80-100°C highly reinforced grades). Back pressure: typically, 5-10 bar (hydraulic pressure). Temperatures exceeding 300°C and long residence time could lead to additives degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the molded part characteristics. For further details, please refer to the document 'Instructions for injection molding' or contact our technical support team.

Postprocessing

PA materials reach their final performance with a water content of about 1.5 to 3.5% by weight, depending on the type. This percentage corresponds to the point of equilibrium between the rates of absorption and desorption of moisture. After molding, in favorable environmental conditions, a part can quickly absorbs moisture up to 0.5-1.0%, while the equilibrium will be reached during its life. A conditioning treatment can accelerate further the initial water absorption of the molded parts. Conditioning is usually carried out in hot and humid environment (for example 50 °C, 100% RH), inside climatic chambers. Slight dimensional

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variations (increase in volume due to the water absorbed) must be considered, especially in unfilled grades. Post-treatments of parts may also include the annealing (60-80 °C in oven, up to four hours). This procedure can be useful to relax any internal stresses.

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