Celanese
The chemistry inside innovation™

Zytel® 70G30HSLR ECO-R 312 BK099

NYLON RESIN

Common features of Zytel® nylon resin include mechanical and physical properties such as high mechanical strength, excellent balance of stiffness and toughness, good high temperature performance, good electrical and flammability properties, good abrasion and chemical resistance. In addition, Zytel® nylon resins are available in different modified and reinforced grades to create a wide range of products with tailored properties for specific processes and end-uses. Zytel® nylon resin, including most flame retardant grades, offer the ability to be coloured.

The good melt stability of Zytel® nylon resin normally enables the recycling of properly handled production waste. If recycling is not possible, we recommend, as the preferred option, incineration with energy recovery (-31kJ/g of base polymer) in appropriately equipped installations. For disposal, local regulations have to be observed.

Zytel® nylon resin typically is used in demanding applications in the automotive, furniture, domestic appliances, sporting goods and construction industry.

Zytel® 70G30HSLR ECO-R BK099 is a 30% glass fibre reinforced, heat stabilised, hydrolysis resistant polyamide 66 resin for injection molding. It has same performance and processing properties as Zytel® 70G30HSLR BK099.

Zytel® 70G30HSLR ECO-R BK099 belongs to the Zytel® ECO-R family. The products of this family contain polyamide derived from certified* post-industrial recyclate streams. This results in reduced lifecycle greenhouse gas emissions and lower fossil resource use.

*certified circular according to ISCC PLUS mass balance approach.

Rheological properties

	dry/cond.		
Viscosity number	150[1]/*	cm³/g	ISO 307, 1628
Moulding shrinkage, parallel	0.3 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.0 / -	%	ISO 294-4, 2577
Melt viscosity , @ 1000 sec-1, 280 °C	190 / *	Pa.s	ISO 11443

[1]: acid sulphuric 96%

Typical mechanical properties

	dry/cond.		
Tensile modulus	10000 / 7000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	200 / 130	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3 / 5	%	ISO 527-1/-2
Flexural modulus	9000 / 6500[DS]	MPa	ISO 178
Flexural strength	280 / 200[DS]	MPa	ISO 178
Flexural stress at 3.5%	270 / 170	MPa	ISO 178
Charpy impact strength, 23 °C	70 / 80	kJ/m²	ISO 179/1eU
Charpy impact strength, -30 °C	70 / 70[DS]	kJ/m²	ISO 179/1eU
Charpy impact strength, -40 °C	65 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23 °C	12 / 15	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30 °C	9 / 9[DS]	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40 °C	9 / 9	kJ/m²	ISO 179/1eA

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Izod notched impact strength, 23°C	10 / 12	kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	10.0 / -	kJ/m²	ISO 180/1A
Izod notched impact strength, -40°C	10.0 / -	kJ/m²	ISO 180/1A
Hardness, Rockwell, M-scale	104 / 88		ISO 2039-2
Hardness, Rockwell, R-scale	124 / 117		ISO 2039-2
Ball indentation hardness, H 961/30	270 / 185	MPa	ISO 2039-1
Poisson's ratio	0.34 / 0.35		
Multiaxial Impact, Total Energy, 4.5m/s, 2mm	5 / -	J	ISO 6603-2

[DS]: Derived from similar grade

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	262 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	75 / 20	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	253 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	261 / *	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel, -40-23°C	26 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	22 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, parallel, 55-160°C	13 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	70 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	80 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, 55-160°C	130 / *	E-6/K	ISO 11359-1/-2
Thermal conductivity, flow	0.36	W/(m K)	ISO 22007-2
Thermal conductivity of melt	0.21	W/(m K)	ISO 22007-2
Specific heat capacity of melt	2290	J/(kg K)	ISO 22007-4

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	IEC 60695-11-10
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.75 / *	mm	IEC 60695-11-10
Oxygen index	24 / *	%	ISO 4589-1/-2
Glow Wire Flammability Index, 1.0mm	700 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 2.0mm	750 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	800 / -	°C	IEC 60695-2-12
Glow Wire Ignition Temperature, 1.0mm	725 / -	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 2.0mm	725 / -	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3.0mm	775 / -	°C	IEC 60695-2-13
Glow Wire Temperature, No Flame, 3mm	750 / -	°C	IEC 60335-1
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	37[2]	mm/min	ISO 3795 (FMVSS 302)

[2]: Based on Zytel® 70G30HSLR BK099

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Electrical properties

	dry/cond.		
Volume resistivity	>1E13 / 1E9[DS]	Ohm.m	IEC 62631-3-1
Surface resistivity	* / 1E12[DS]	Ohm	IEC 62631-3-2
Electric strength	38 / 32	kV/mm	IEC 60243-1
Comparative tracking index	400 / -		IEC 60112

[DS]: Derived from similar grade

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.9 / *	%	Sim. to ISO 62
Water absorption, 2mm	6 / *	%	Sim. to ISO 62
Water absorption, Immersion 24h	1.3 / *	%	Sim. to ISO 62
Density	1370 / -	kg/m³	ISO 1183

VDA Properties

Odour	5[2]	class	VDA 270

[2]: Based on Zytel® 70G30HSLR BK099

Injection

Drying Recommended	yes	
Drying Temperature	80	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	295	°C
Min. melt temperature	285	°C
Max. melt temperature	305	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	100	°C
Min. mould temperature	70	°C
Max. mould temperature	120	°C
Hold pressure range	50 - 100	MPa
Hold pressure time	3	s/mm
Ejection temperature	210	°C

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Additives	Release agent
Special characteristics	Heat stabilised or stable to heat, Hydrolysis resistant
Sustainability	Recycled Content

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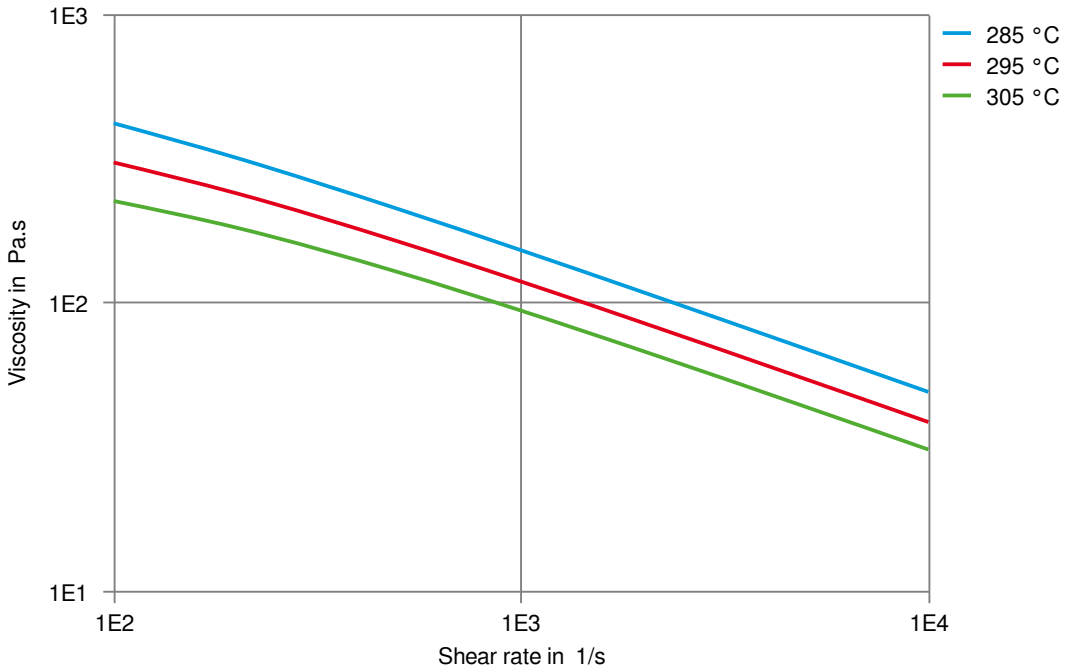
Viscosity-shear rate
(measured on Zytel® 70G30HSLR BK099)



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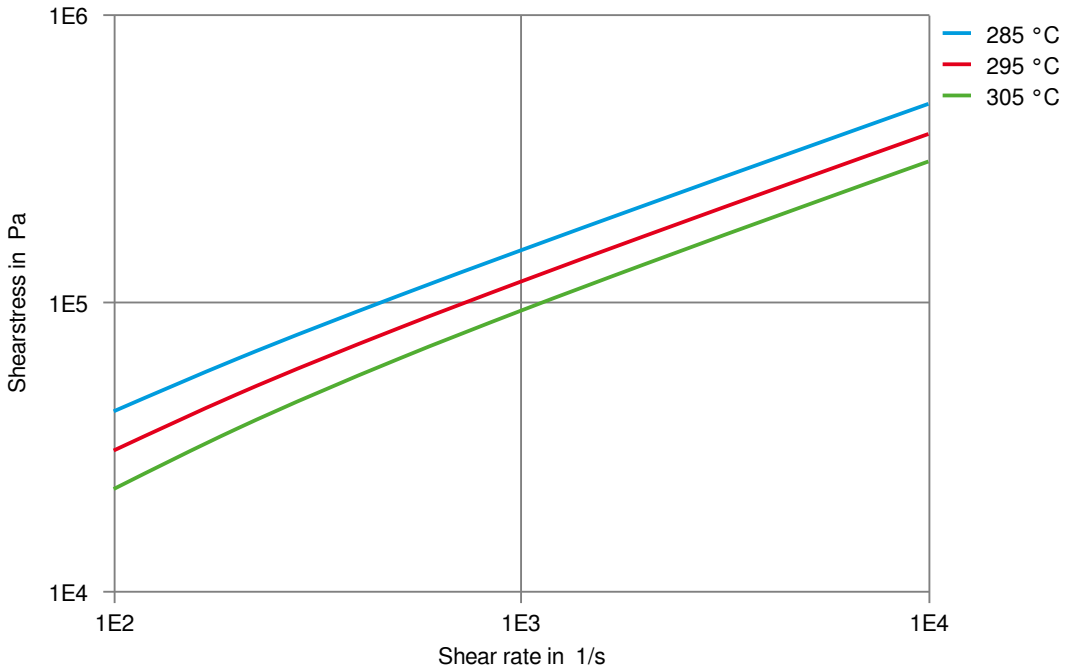
NYLON RESIN

Shearstress-shear rate
(measured on Zytel® 70G30HSLR BK099)



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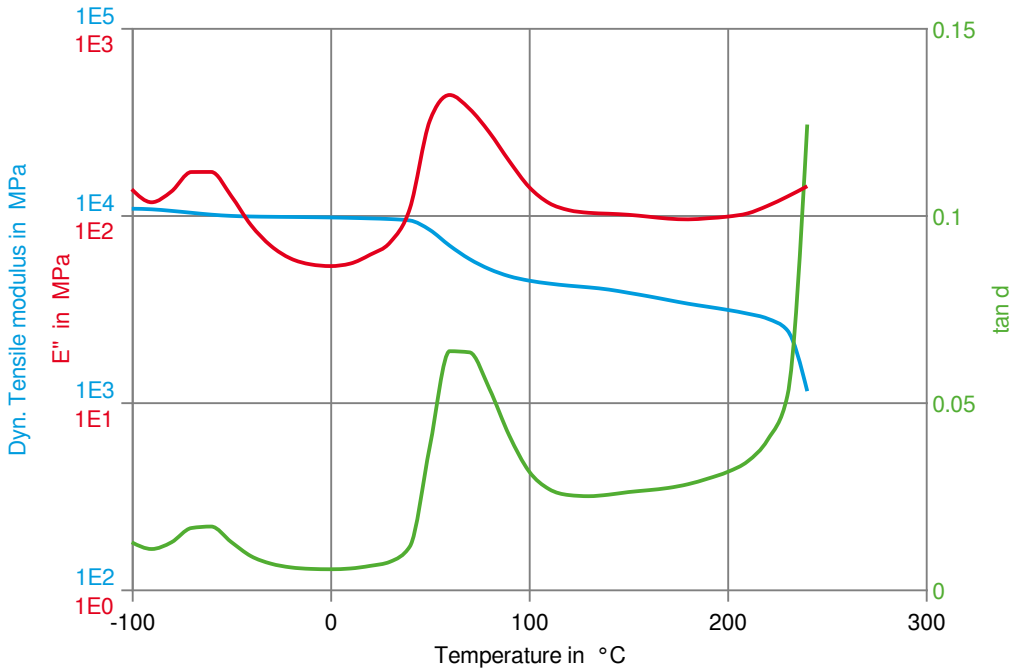
Dynamic Tensile modulus-temperature (dry) (measured on Zytel® 70G30HSLR BK099)



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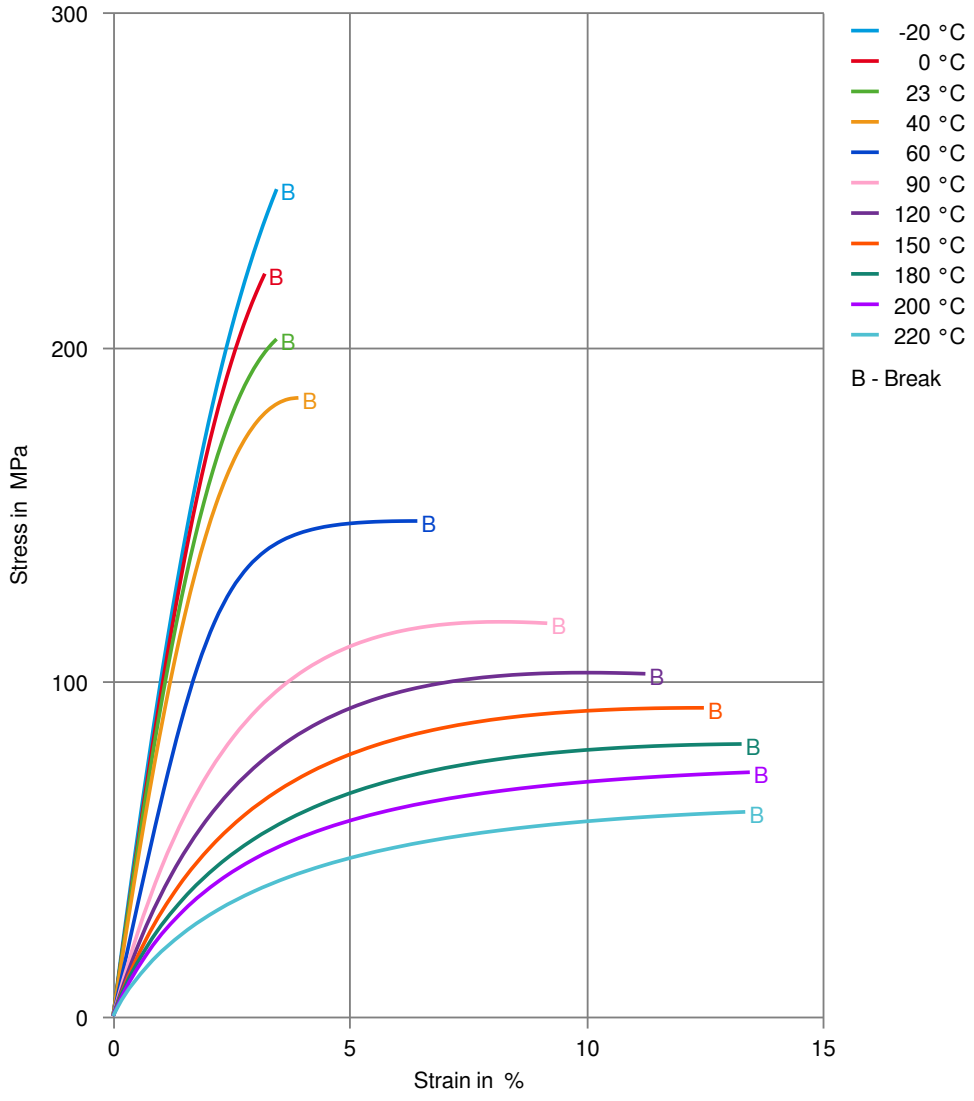
Stress-strain (dry)
(measured on Zytel® 70G30HSLR BK099)



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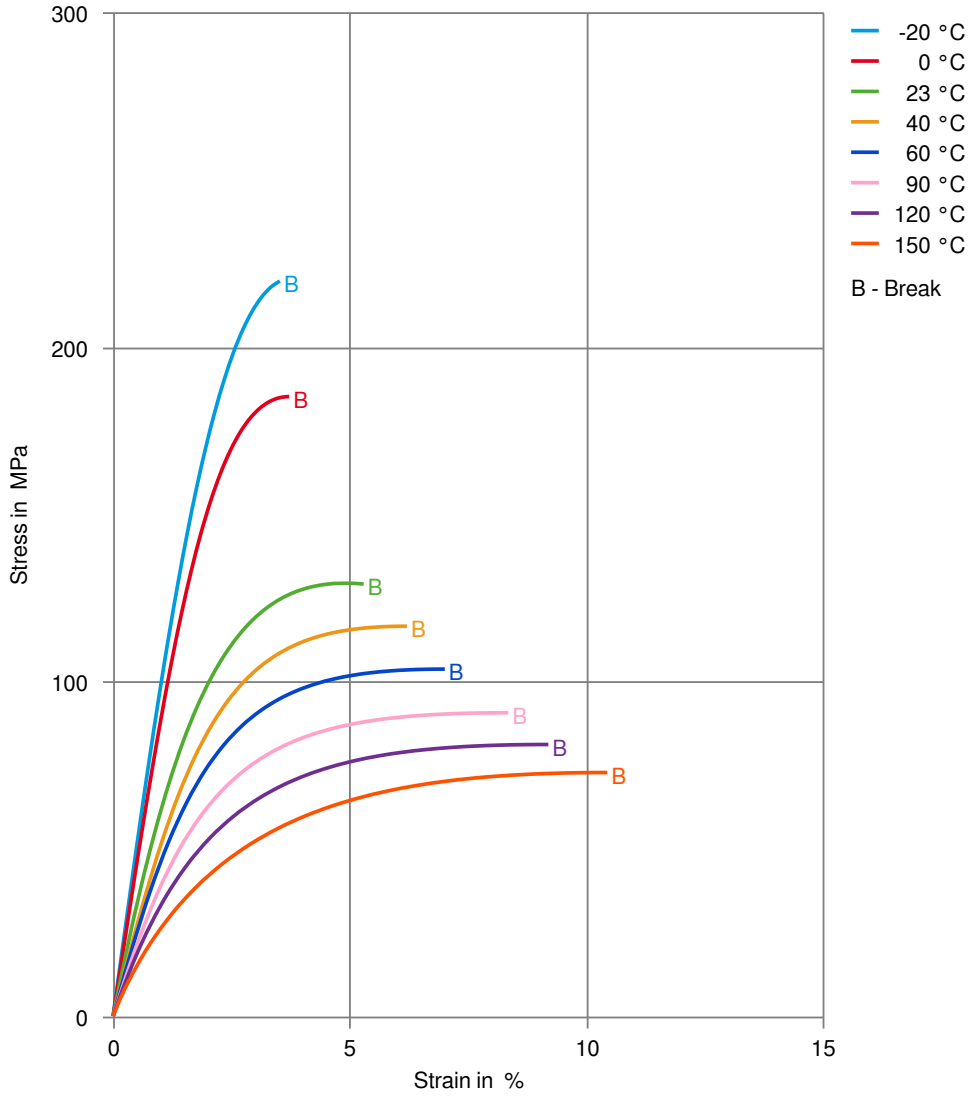
Stress-strain (cond.)
(measured on Zytel® 70G30HSLR BK099)



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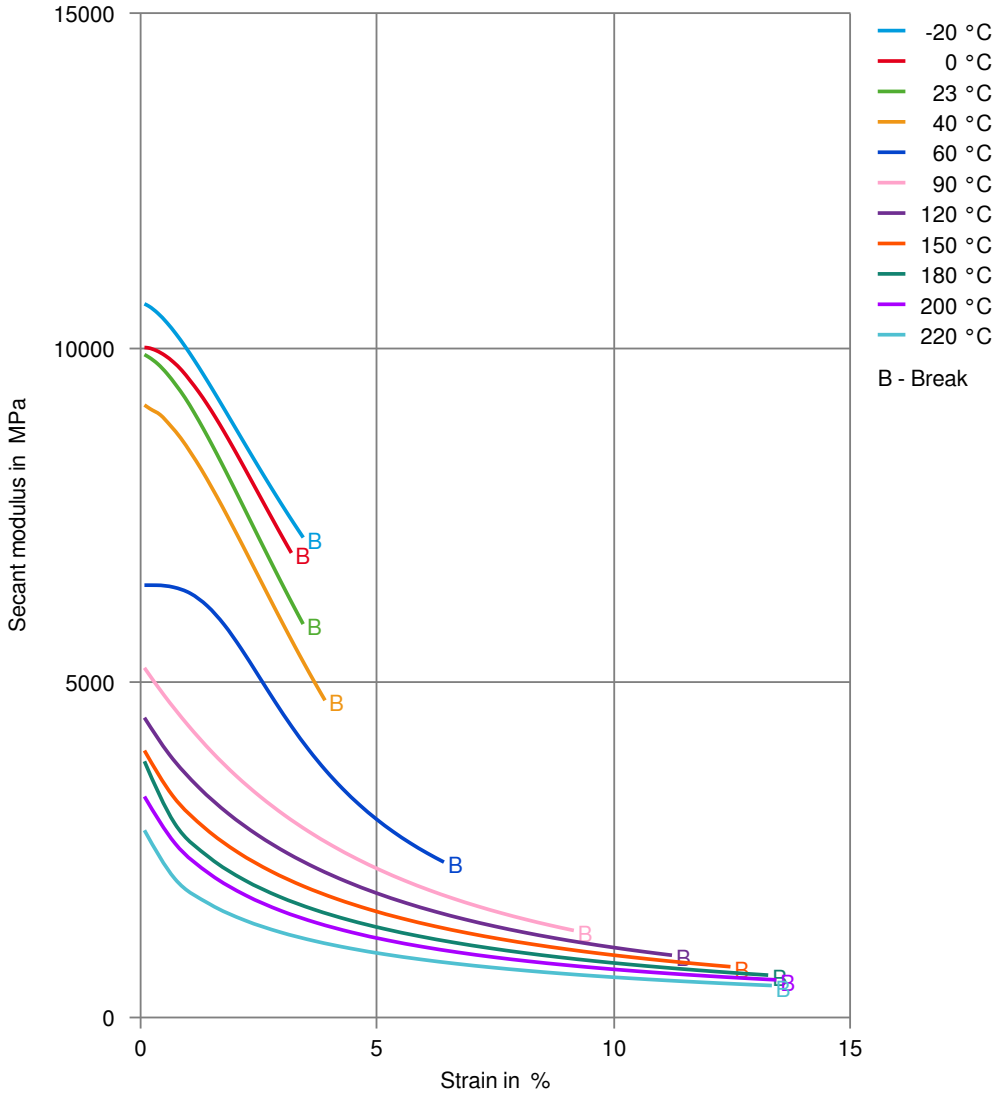
Secant modulus-strain (dry)
(measured on Zytel® 70G30HSLR BK099)



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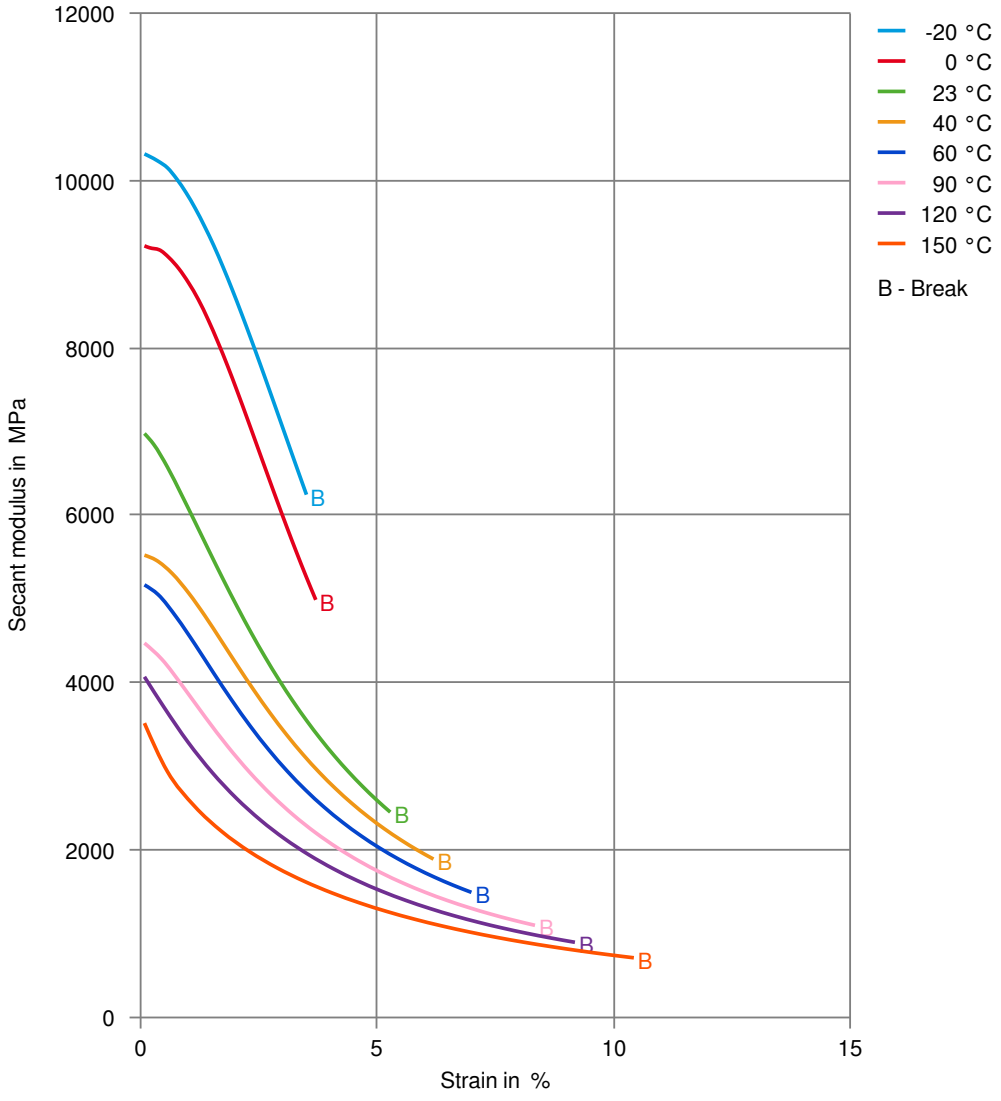
Secant modulus-strain (cond.)
(measured on Zytel® 70G30HSLR BK099)



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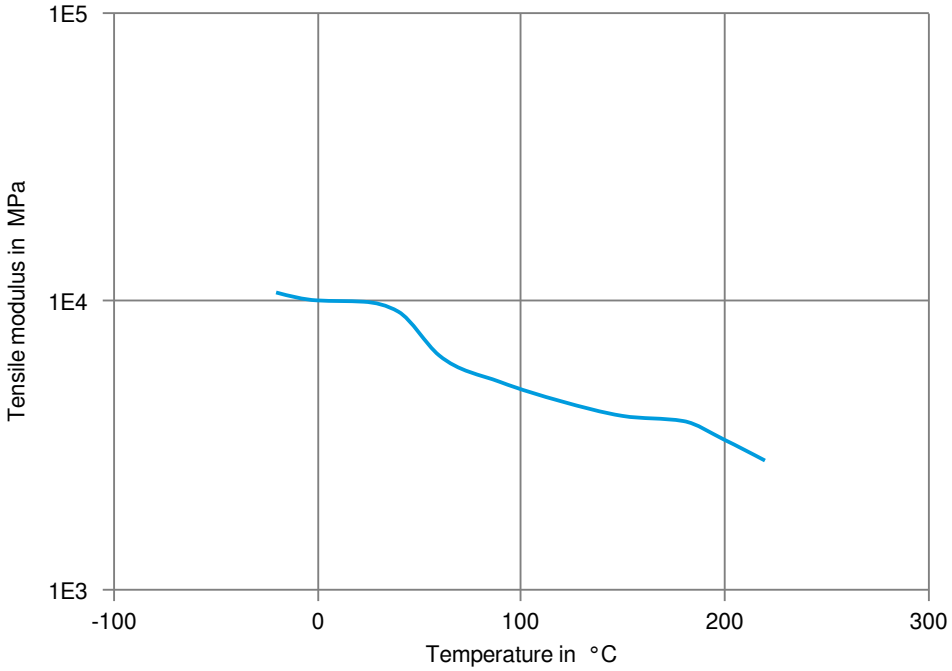
Tensile modulus-temperature (dry)
(measured on Zytel® 70G30HSLR BK099)



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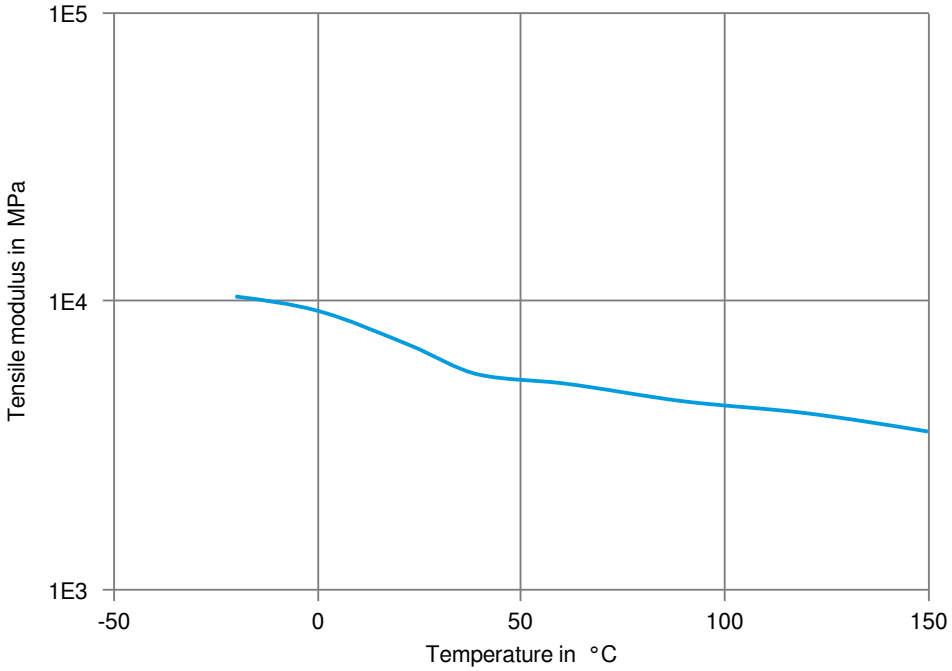
Tensile modulus-temperature (cond.)
(measured on Zytel® 70G30HSLR BK099)



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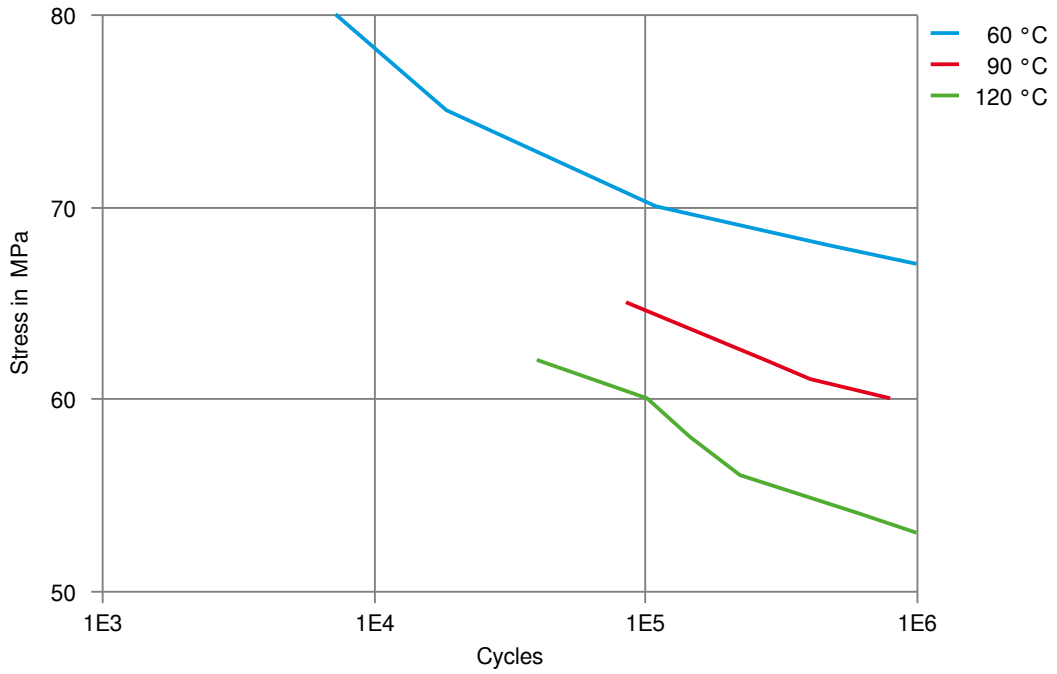
Tensile Fatigue, 10Hz, R=0.1 @ 0mm (dry)
(measured on Zytel® 70G30HSLR BK099)



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Chemical Media Resistance

Acids
- ✔ Acetic Acid (5% by mass), 23°C
- ✔ Citric Acid solution (10% by mass), 23°C
- ✔ Lactic Acid (10% by mass), 23°C
- ✘ Hydrochloric Acid (36% by mass), 23°C
- ✘ Nitric Acid (40% by mass), 23°C
- ✘ Sulfuric Acid (38% by mass), 23°C
- ✘ Sulfuric Acid (5% by mass), 23°C
- ✘ Chromic Acid solution (40% by mass), 23°C

Bases
- ✘ Sodium Hydroxide solution (35% by mass), 23°C
- ✔ Sodium Hydroxide solution (1% by mass), 23°C
- ✔ Ammonium Hydroxide solution (10% by mass), 23°C

Alcohols
- ✔ Isopropyl alcohol, 23°C
- ✔ Methanol, 23°C
- ✔ Ethanol, 23°C

Hydrocarbons
- ✔ n-Hexane, 23°C
- ✔ Toluene, 23°C
- ✔ iso-Octane, 23°C

Ketones
- ✔ Acetone, 23°C

Ethers
- ✔ Diethyl ether, 23°C

Mineral oils
- ✔ SAE 10W40 multigrade motor oil, 23°C
- ✔ SAE 10W40 multigrade motor oil, 130°C
- ✔ SAE 80/90 hypoid-gear oil, 130°C
- ✔ Insulating Oil, 23°C
- ✔ Motor oil OS206 304 Ref.Eng.Oil, ISP, 135°C
- ✔ Automatic hypoid-gear oil Shell Donax TX, 135°C
- ✔ Hydraulic oil Pentosin CHF 202, 125°C

Standard Fuels
- ✔ ISO 1817 Liquid 1 - E5, 60°C
- ✔ ISO 1817 Liquid 2 - M15E4, 60°C
- ✔ ISO 1817 Liquid 3 - M3E7, 60°C
- ✔ ISO 1817 Liquid 4 - M15, 60°C
- ✔ Standard fuel without alcohol (pref. ISO 1817 Liquid C), 23°C
- ✔ Standard fuel with alcohol (pref. ISO 1817 Liquid 4), 23°C
- ✔ Diesel fuel (pref. ISO 1817 Liquid F), 23°C
- ✔ Diesel fuel (pref. ISO 1817 Liquid F), 90°C
- ✔ Diesel fuel (pref. ISO 1817 Liquid F), >90°C

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Salt solutions
- ✔ Sodium Chloride solution (10% by mass), 23°C
- ✘ Sodium Hypochlorite solution (10% by mass), 23°C
- ✔ Sodium Carbonate solution (20% by mass), 23°C
- ✔ Sodium Carbonate solution (2% by mass), 23°C
- ✘ Zinc Chloride solution (50% by mass), 23°C

Other
- ✔ Ethyl Acetate, 23°C
- ✘ Hydrogen peroxide, 23°C
- ✔ DOT No. 4 Brake fluid, 130°C
- ✔ DOT No. 4 Brake fluid, 120°C
- ✔ Ethylene Glycol (50% by mass) in water, 108°C
- ✔ 1% nonylphenoxy-polyethyleneoxy ethanol in water, 23°C
- ✔ 50% Oleic acid + 50% Olive Oil, 23°C
- ✔ Water, 23°C
- ✔ Water, 90°C
- ✘ Phenol solution (5% by mass), 23°C
- ✔ Coolant Glysantin G48, 1:1 in water, 125°C

Symbols used:

✔ possibly resistant
Defined as: Supplier has sufficient indication that contact with chemical can be potentially accepted under the intended use conditions and expected service life. Criteria for assessment have to be indicated (e.g. surface aspect, volume change, property change).

✘ not recommended - see explanation
Defined as: Not recommended for general use. However, short-term exposure under certain restricted conditions could be acceptable (e.g. fast cleaning with thorough rinsing, spills, wiping, vapor exposure).

Revised: 2025-05-26 Source: Celanese Materials Database