



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® 70G33L BK031 is a 33% glass fiber reinforced polyamide 66 resin for injection moulding.

Product information

Resin Identification Part Marking Code ISO designation	PA66-GF33 >PA66-GF33< ISO 16396-PA66,GF33,M1CGR,S14-110		ISO 1043 ISO 11469
Rheological properties	dry/cond.		
Moulding shrinkage, parallel	0.3/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.1/-	%	ISO 294-4, 2577
Typical mechanical properties	dry/cond.		
Tensile modulus	11000/8000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	200/140	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3/4	%	ISO 527-1/-2
Flexural modulus	9300/-	MPa	ISO 178
Charpy impact strength, 23°C	80/80	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	13/13	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -40°C	9/-	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	12/-	kJ/m²	ISO 180/1A
Izod notched impact strength, -40°C	10.0/-	kJ/m²	ISO 180/1A
Poisson's ratio	0.34/0.34		
Thermal properties	dry/cond.		
Melting temperature, 10°C/min	262/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	252/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	261/*	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	18/*	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	83/*	E-6/K	ISO 11359-1/-2
RTI, electrical, 0.75mm	130	°C	UL 746B
RTI, electrical, 1.5mm	130	°C	UL 746B
RTI, electrical, 3.0mm	130	°C	UL 746B

Printed: 2025-05-29 Page: 1 of 8

Revised: 2025-04-18 Source: Celanese Materials Database





NYLON RESIN

RTI, impact, 0.75mm RTI, impact, 1.5mm RTI, impact, 3.0mm RTI, strength, 0.75mm RTI, strength, 1.5mm RTI, strength, 3.0mm	120 120 120 130 130/* 130	°C °C °C °C °C	UL 746B UL 746B UL 746B UL 746B UL 746B UL 746B
Flammability	dry/cond.		
Burning Behav. at 1.5mm nom. thickn. Thickness tested UL recognition	HB/* 1.5/* yes/*	class mm	IEC 60695-11-10 IEC 60695-11-10 UL 94
Burning Behav. at thickness h	HB/*	class	IEC 60695-11-10
Thickness tested	0.71/*	mm	IEC 60695-11-10
UL recognition	yes/*		UL 94
FMVSS Class Burning rate, Thickness 1 mm	B 35	mm/min	ISO 3795 (FMVSS 302) ISO 3795 (FMVSS 302)
Editing rate, Thiothose Thin	00	,	100 0700 (1 111100 002)
Electrical properties	dry/cond.		
Comparative tracking index Electric Strength, Short Time, 1mm	600/- 37/-	kV/mm	IEC 60112 IEC 60243-1
Physical/Other properties	dry/cond.		
Humidity absorption, 2mm	1.8/*	%	Sim. to ISO 62
Water absorption, 2mm	5.7/*	%	Sim. to ISO 62
Density	1390/-	kg/m³	ISO 1183
VDA Properties			
Emission of organic compounds	10	D μgC/g	VDA 277
Odour		3 class	VDA 270
Injection			
Drying Recommended	yes	S	
Drying Temperature) °C	
Drying Time, Dehumidified Dryer	2 - 4		
Processing Moisture Content		2 %	
Melt Temperature Optimum Min. melt temperature		5 °C 5 °C	
wiin. meit temperature	200	, 0	

Printed: 2025-05-29 Page: 2 of 8

305 °C

≤0.2 m/s

100 °C

70 °C

120 °C

210 °C

3 s/mm

50 - 100 MPa

Revised: 2025-04-18 Source: Celanese Materials Database

Max. melt temperature

Screw tangential speed

Min. mould temperature

Max. mould temperature

Hold pressure range

Ejection temperature

Hold pressure time

Mold Temperature Optimum





NYLON RESIN

Characteristics

Processing Injection Moulding

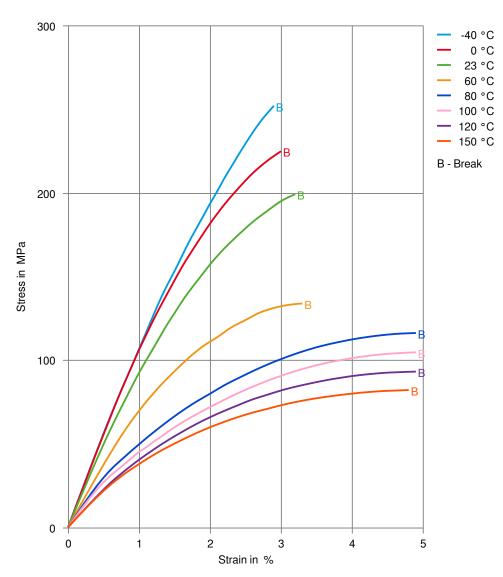
Automotive

OEM STANDARD ADDITIONAL INFORMATION

Hyundai MS211-37 Type E

Stellantis - Chrysler MS.50017 / CPN-2327 Black

Stress-strain (dry)



Printed: 2025-05-29 Page: 3 of 8

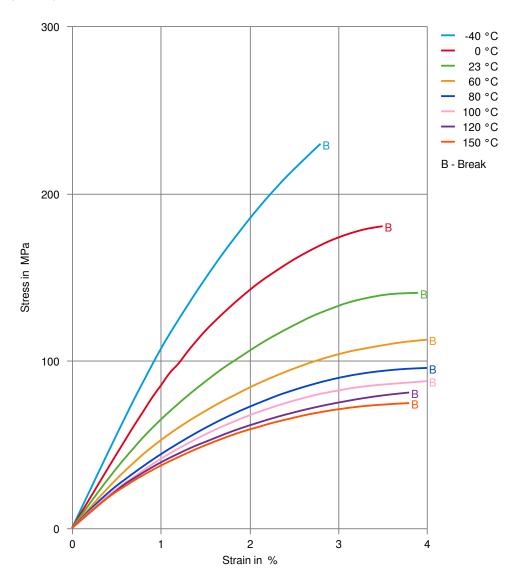
Revised: 2025-04-18 Source: Celanese Materials Database





NYLON RESIN

Stress-strain (cond.)



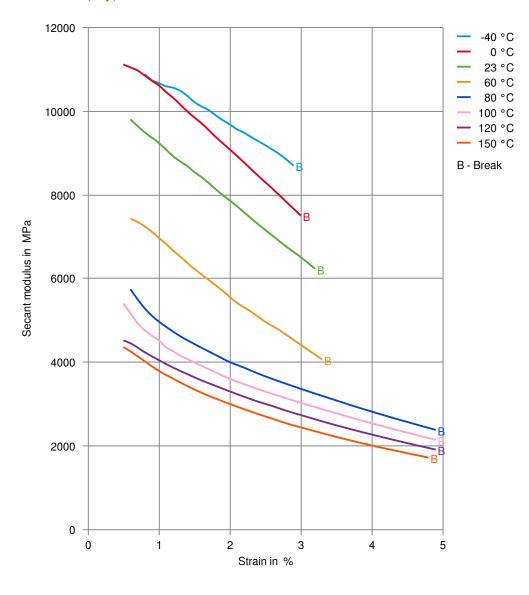
Printed: 2025-05-29 Page: 4 of 8





NYLON RESIN

Secant modulus-strain (dry)



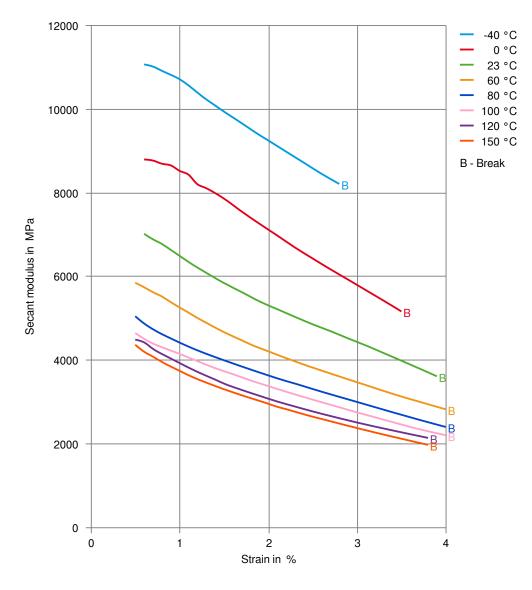
Printed: 2025-05-29 Page: 5 of 8





Zytel® 70G33L BK031 **NYLON RESIN**

Secant modulus-strain (cond.)



Printed: 2025-05-29 Page: 6 of 8 (+) 18816996168 Ponciplastics.com



Zytel® 70G33L BK031

NYLON RESIN

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
- X Hydrochloric Acid (36% by mass), 23°C
- X Nitric Acid (40% by mass), 23°C
- X Sulfuric Acid (38% by mass), 23°C
- X Sulfuric Acid (5% by mass), 23°C
- X Chromic Acid solution (40% by mass), 23°C

Bases

- X 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

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

Salt solutions

- ✓ Sodium Chloride solution (10% by mass), 23°C
- ★ Sodium Hypochlorite solution (10% by mass), 23°C

Printed: 2025-05-29 Page: 7 of 8

(+) 18816996168 Ponciplastics.com



Zytel® 70G33L BK031

NYLON RESIN

- ✓ Sodium Carbonate solution (20% by mass), 23°C
- ✓ Sodium Carbonate solution (2% by mass), 23°C
- X Zinc Chloride solution (50% by mass), 23°C

Other

- ✓ Ethyl Acetate, 23°C
- X Hydrogen peroxide, 23°C
- ✓ DOT No. 4 Brake fluid, 130°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

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).

x 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).

Printed: 2025-05-29 Page: 8 of 8

Revised: 2025-04-18 Source: Celanese Materials Database

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colourants or other additives may processing conditions and environmental exposure. Other than those products expressly identified as medical grade (including by MT® product designation or otherwise), Celanese's products are not intended for use in medical or dental implants. Regardless of any such product designation, any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users

© 2025 Celanese or its affiliates. All rights reserved. Celanese®, registered C-ball design and all other trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Celanese or its affiliates. Fortron is a registered trademark of Fortron Industries LLC.