Zytel® 80G33HS1L BK104

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® 80G33HS1L BK104 is a 33% glass fiber reinforced heat stabilized polyamide 66 resin with outstanding impact resistance developed using our Super Tough technology.

Product information

Resin Identification	PA66-I-GF33	ISO 1043
Part Marking Code	>PA66-I-GF33<	ISO 11469
ISO designation	ISO 16396-PA66-I,GF33,M1CGHR,S14-090	
Infrared spectrum	available	

Rheological properties

	dry/cond.		
Molding shrinkage, parallel	0.3 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	1.28E6 / 943000	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	21500 / 16200	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.6 / 6.6	%	ISO 527-1/-2
Flexural modulus	1.1E6 / -	psi	ISO 178
Flexural strength	31000 / -	psi	ISO 178
Charpy impact strength, 23°C	46.1 / 45.7	ftlb/in²	ISO 179/1eU
Charpy impact strength, -40°C	51.9 / 46.1	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	9.51 / 12.8	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	8.56 / 8.09	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -40°C	8.56 / -	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	9.99 / 12.4	ftlb/in²	ISO 180/1A
Izod notched impact strength, -30°C	8.09 / 7.61	ftlb/in²	ISO 180/1A
Izod notched impact strength, -40°C	7.14 / -	ftlb/in²	ISO 180/1A
Izod impact strength, -30°C	41.4 / -	ftlb/in²	ISO 180/1U
Ball indentation hardness, H 961/30	31900 / -	psi	ISO 2039-1

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	504 / *	°F	ISO 11357-1/-3
Glass transition temperature, 10°C/min	167 / 68	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	473 / *	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	502 / *	°F	ISO 75-1/-2

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Coefficient of linear thermal expansion (CLTE), parallel	0.13 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel, -40-23°C	0.139 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel, 55-160°C	0.05 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.556 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal, -40-23°C	0.533 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal, 55-160°C	0.667 / *	E-4/°F	ISO 11359-1/-2
RTI, electrical, 0.75mm	266	°F	UL 746B
RTI, electrical, 1.5mm	266	°F	UL 746B
RTI, electrical, 3.0mm	266	°F	UL 746B
RTI, impact, 0.75mm	149	°F	UL 746B
RTI, impact, 1.5mm	221	°F	UL 746B
RTI, impact, 3.0mm	221	°F	UL 746B
RTI, strength, 0.75mm	185	°F	UL 746B
RTI, strength, 1.5mm	203 / *	°F	UL 746B
RTI, strength, 3.0mm	221	°F	UL 746B

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	0.0591 / *	in	IEC 60695-11-10
UL recognition	yes / *		UL 94
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.0295 / *	in	IEC 60695-11-10
UL recognition	yes / *		UL 94
Glow Wire Flammability Index, 1.0mm	1200 / -	°F	IEC 60695-2-12
Glow Wire Flammability Index, 2.0mm	1290 / -	°F	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	1650 / -	°F	IEC 60695-2-12
Glow Wire Ignition Temperature, 1.0mm	1290 / -	°F	IEC 60695-2-13
Glow Wire Ignition Temperature, 2.0mm	1290 / -	°F	IEC 60695-2-13
Glow Wire Ignition Temperature, 3.0mm	1380 / -	°F	IEC 60695-2-13
FMVSS Class	SE		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm		in/min	ISO 3795 (FMVSS 302)

Electrical properties

	dry/cond.		
Comparative tracking index	- / 400		IEC 60112

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.5 / *	%	Sim. to ISO 62
Water absorption, 2mm	4.5 / *	%	Sim. to ISO 62
Water absorption, Immersion 24h	0.91 / *	%	Sim. to ISO 62
Density	0.048 / -	lb/in³	ISO 1183

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Emissions

	dry/cond.		
Weather stability grey scale	1		ISO 105-A02
Emission of organic compounds	25.3	µgC/g	VDA 277
Odor test	3	class	VDA 270
Fogging, G-value (condensate)	0.8 / *	mg	ISO 6452

Injection

Drying Recommended	yes	
Drying Temperature	176	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	572	°F
Min. melt temperature	554	°F
Max. melt temperature	581	°F
Max. screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	203	°F
Min. mold temperature	149	°F
Max. mold temperature	248	°F
Hold pressure range	7250 - 14500	psi
Hold pressure time	0.0762	s/mil
Hold Pressure Time (h is the max. wall thickness of the part in mm)	h^2+2	s
Ejection temperature	428	°F

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Ford	WSS-M4D703-B1	
General Motors	GMW17263P-PA66-GF35	Black
Stellantis - Chrysler	MS.50017 / CPN-2735	Black
VW Group	VW 50133 PA66-7-A	

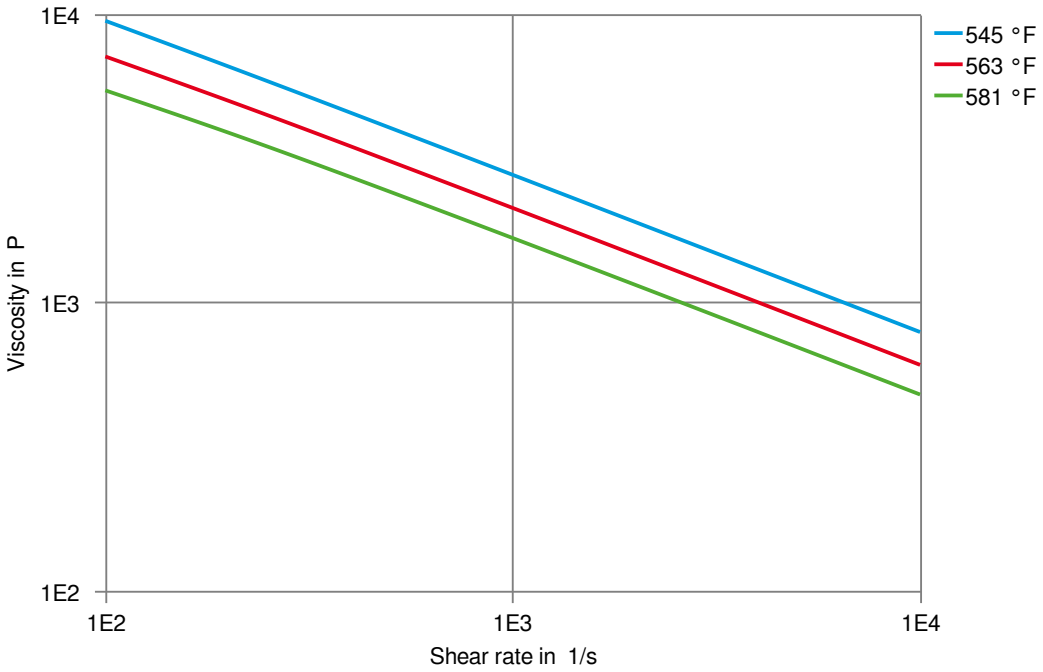
Characteristics

Processing	Injection Molding
Special characteristics	High impact or impact modified, Heat stabilized or stable to heat

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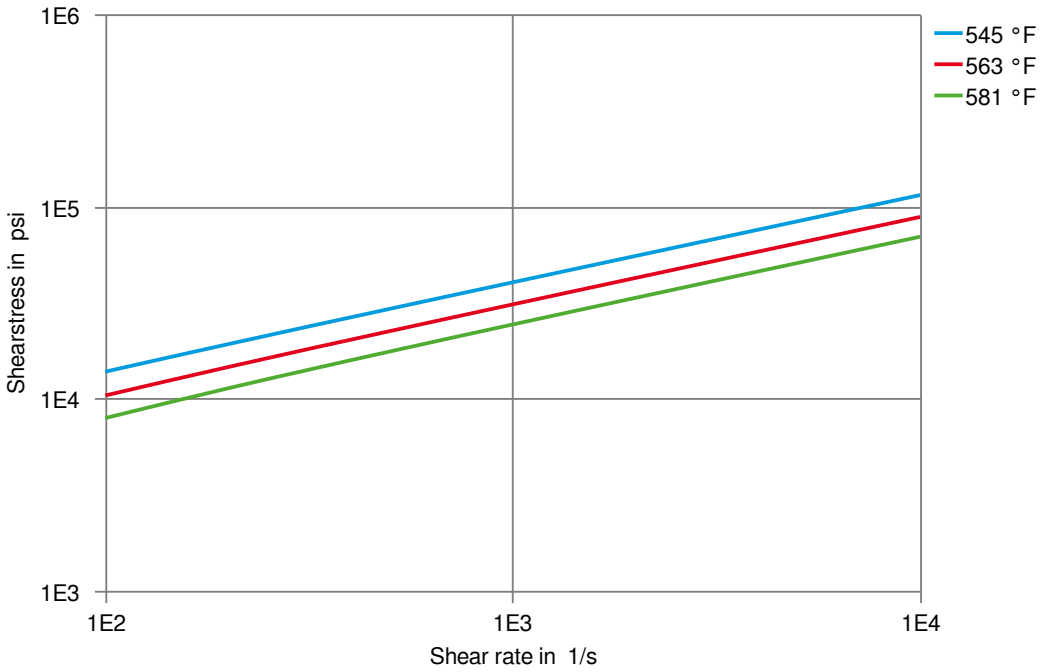
Viscosity-shear rate
(measured on Zytel® 80G33HS1L NC010)



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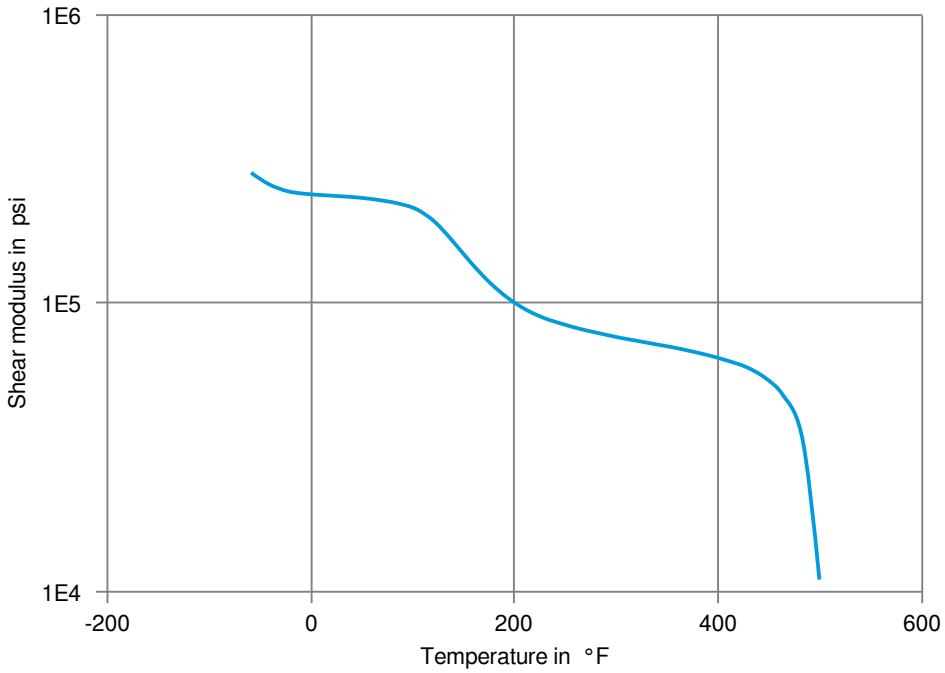
Shearstress-shear rate
(measured on Zytel® 80G33HS1L NC010)



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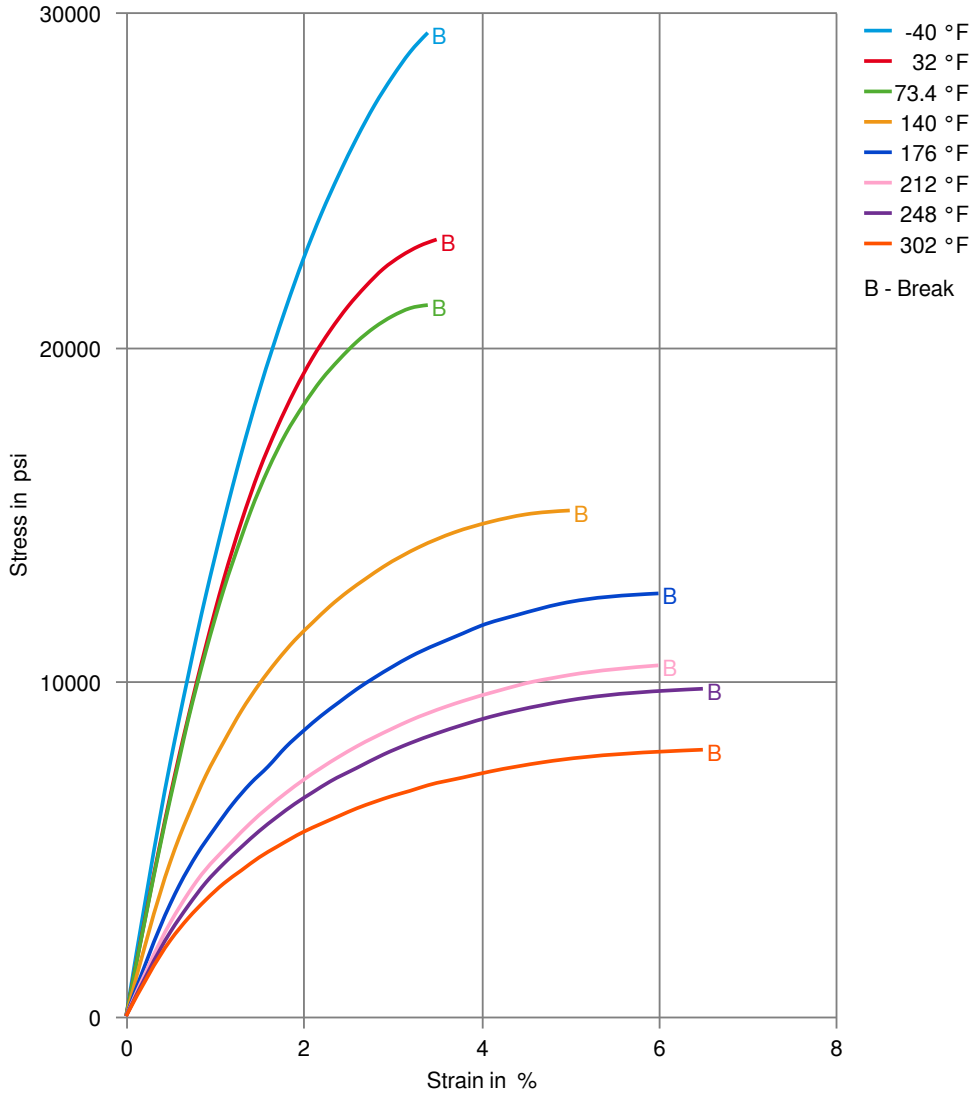
Dynamic Shear modulus-temperature (dry)



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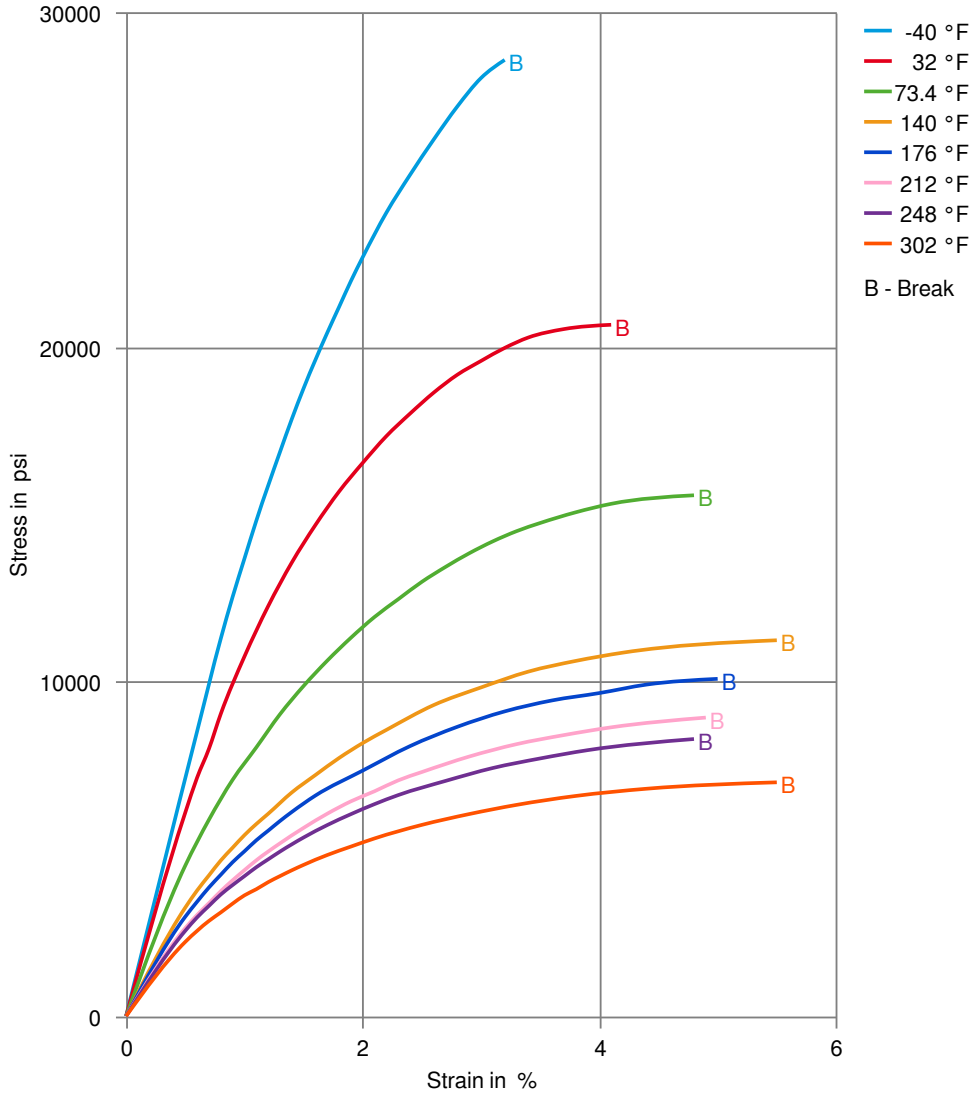
Stress-strain (dry)



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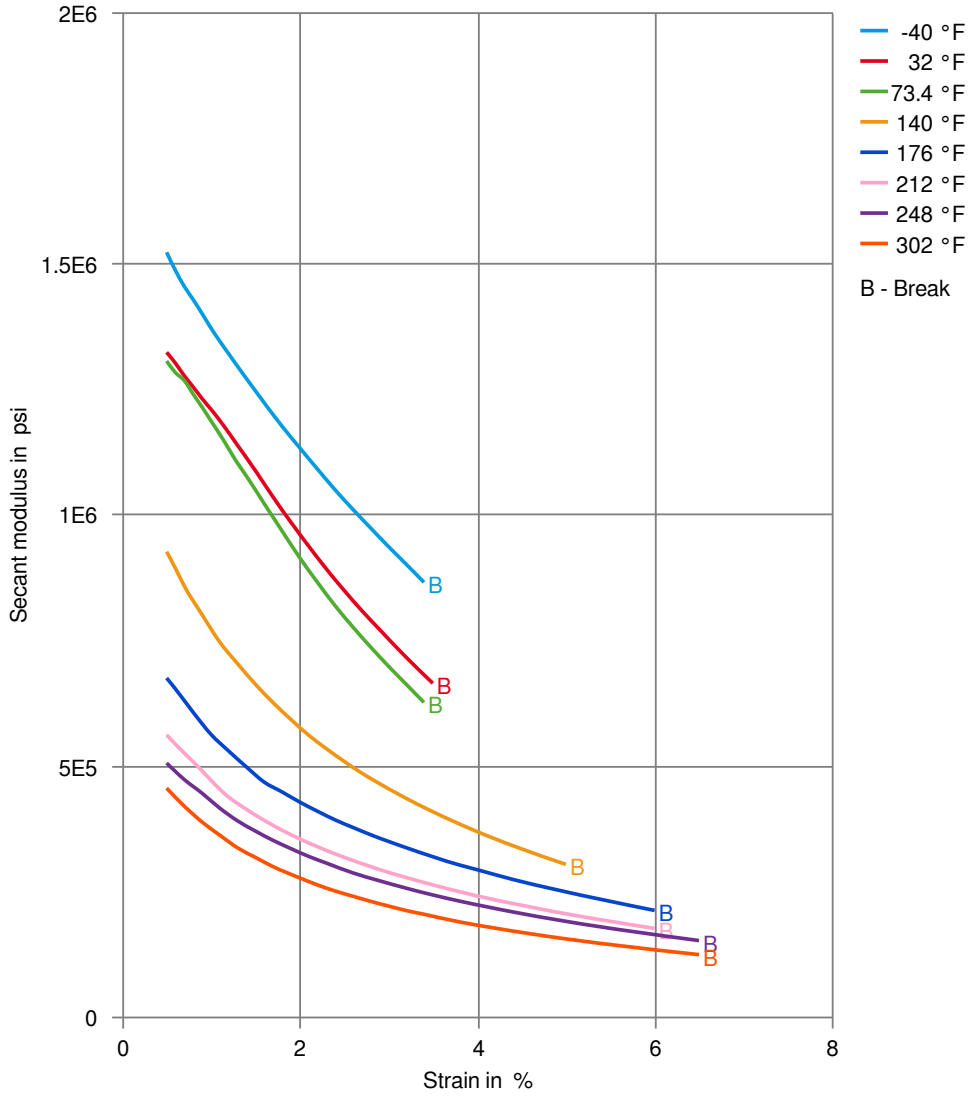
Stress-strain (cond.)



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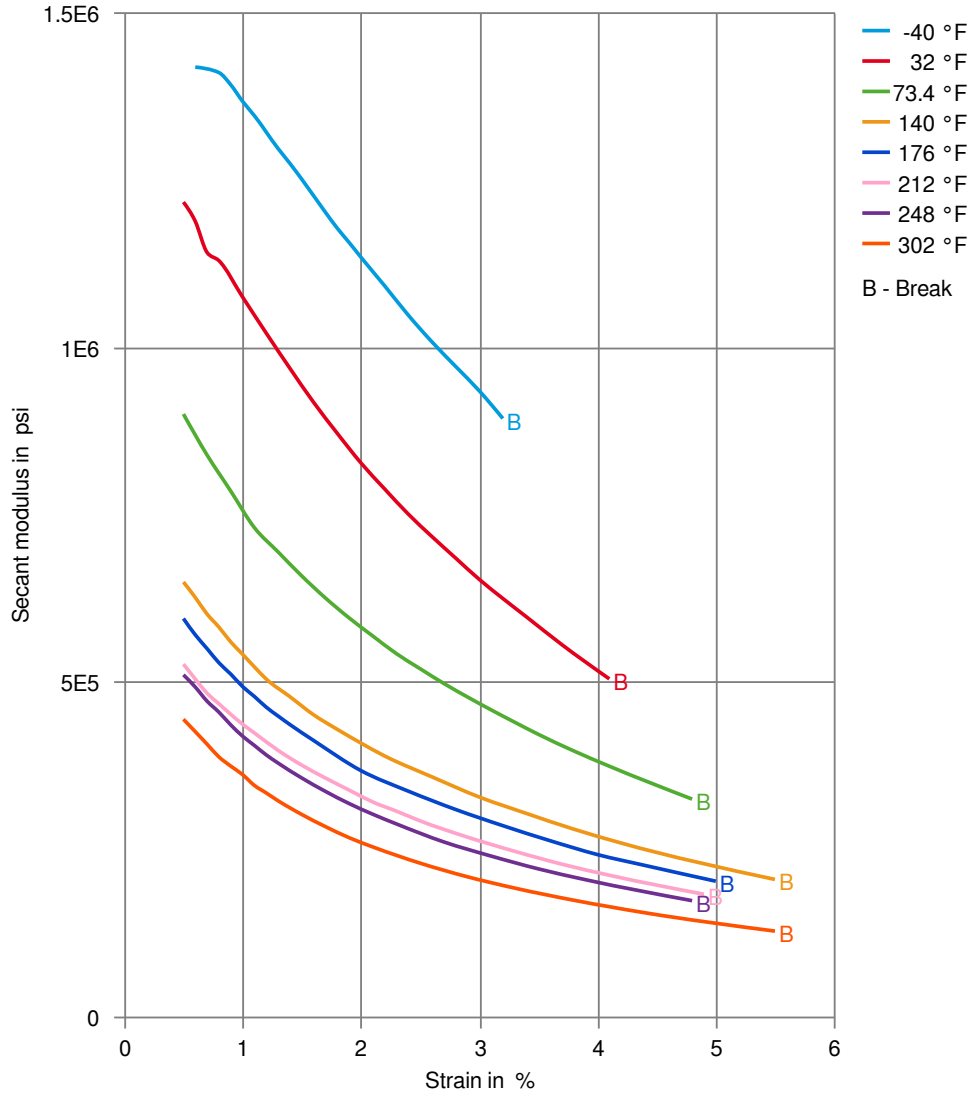
Secant modulus-strain (dry)



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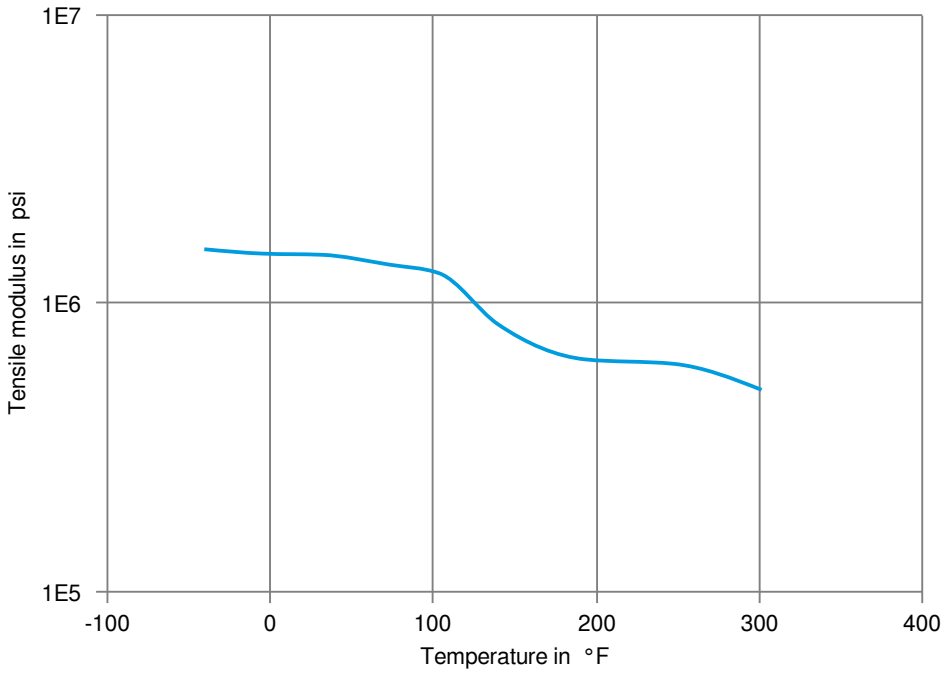
Secant modulus-strain (cond.)



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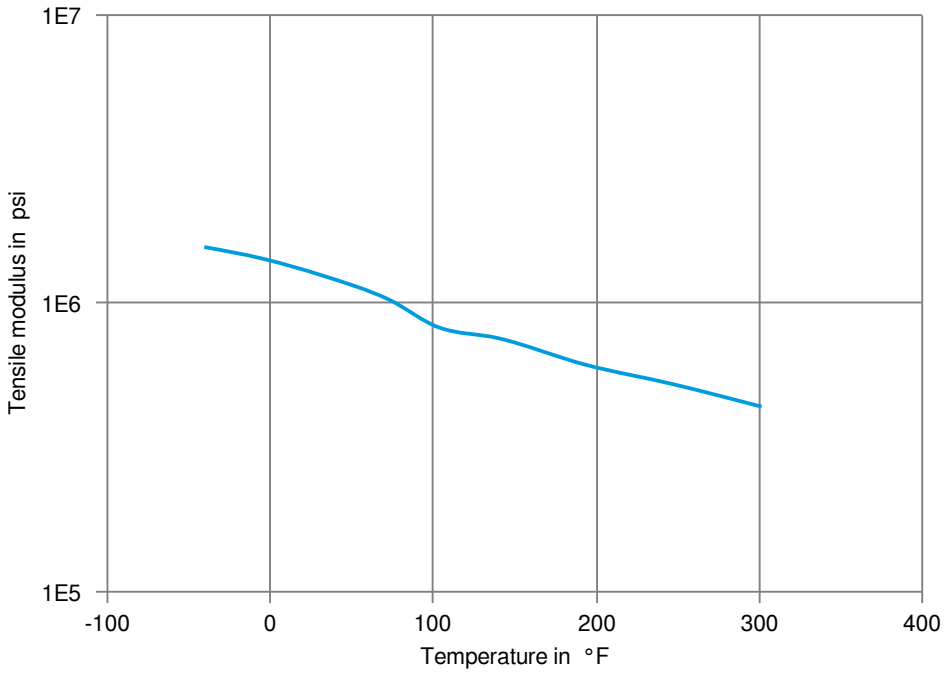
Tensile modulus-temperature (dry)
(measured on Zytel® 80G33HS1L NC010)



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Tensile modulus-temperature (cond.)
(measured on Zytel® 80G33HS1L NC010)



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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

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

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- ✔ 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
- ✔ 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
- ✔ Urea solution (32.5% 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).

✘ 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: 2026-08-12 Source: Celanese Materials Database

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