Celanese
The chemistry inside innovation™

Zytel® FN718 BK230A

NYLON RESIN

Zytel® FN718 BK230A is a flexible polyamide 66 resin.

Product information

Resin Identification	PA66-HI		ISO 1043
Part Marking Code	>PA66-HI<		ISO 11469
ISO designation	ISO 16396-PA66-F,,M1CG1,S14-010		

Typical mechanical properties

	dry/cond.		
Tensile modulus	131000 / 63800	psi	ISO 527-1/-2
Tensile stress at 50% strain	4790 / 3050	psi	ISO 527-1/-2
Flexural modulus	131000 / -	psi	ISO 178
Charpy notched impact strength, 23 °C	49.9 / -	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -40 °C	14.3 / -	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23 °C	45.2 / -	ftlb/in²	ISO 180/1A
Izod notched impact strength, -40 °C	11.9 / -	ftlb/in²	ISO 180/1A

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	505 / *	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	122 / *	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	154 / *	°F	ISO 75-1/-2

Flammability

FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<80	in/min	ISO 3795 (FMVSS 302)

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.4 / *	%	Sim. to ISO 62
Density	0.0375 / -	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	176	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	545	°F
Min. melt temperature	527	°F
Max. melt temperature	563	°F
Mold Temperature Optimum	140	°F
Min. mold temperature	104	°F
Max. mold temperature	176	°F
Hold Pressure Time (h is the max. wall thickness of the part in mm)	h^2+2	s

Revised: 2025-08-04 Source: Celanese Materials Database

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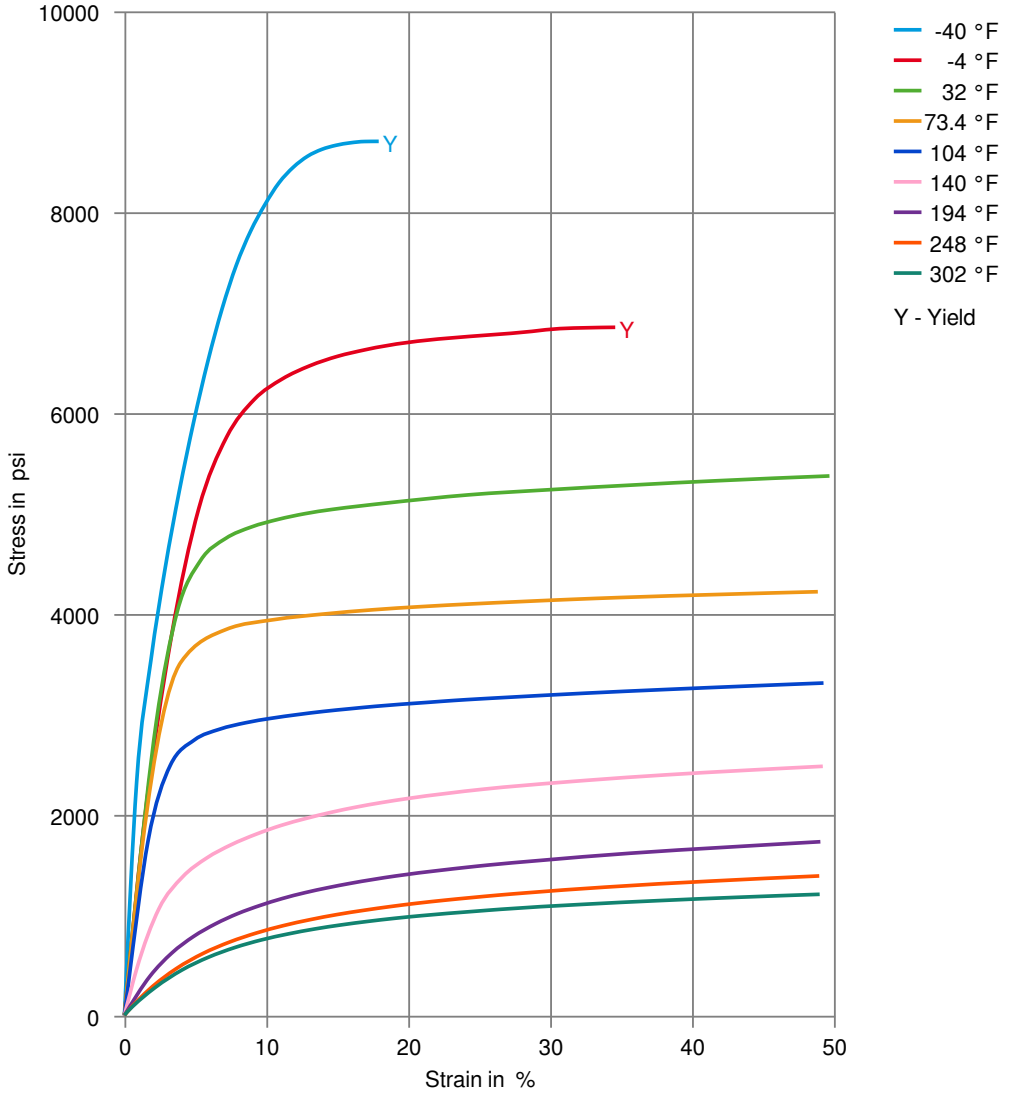
Extrusion

Drying Temperature	176 °F
Drying Time, Dehumidified Dryer	4 - 6 h
Processing Moisture Content	≤0.06 %
Melt Temperature Range	527 - 554 °F

Characteristics

Processing	Injection Molding, Extrusion

Stress-strain (dry)

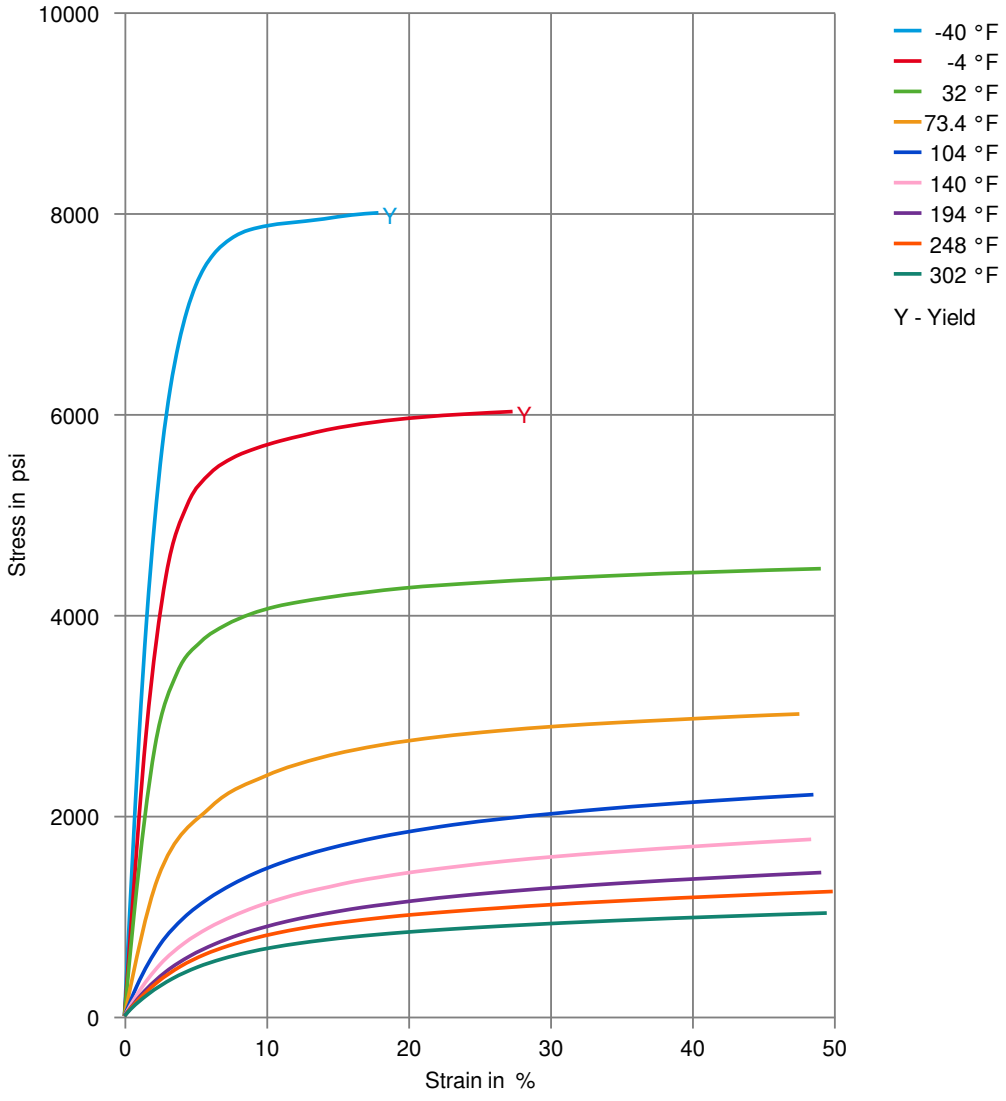


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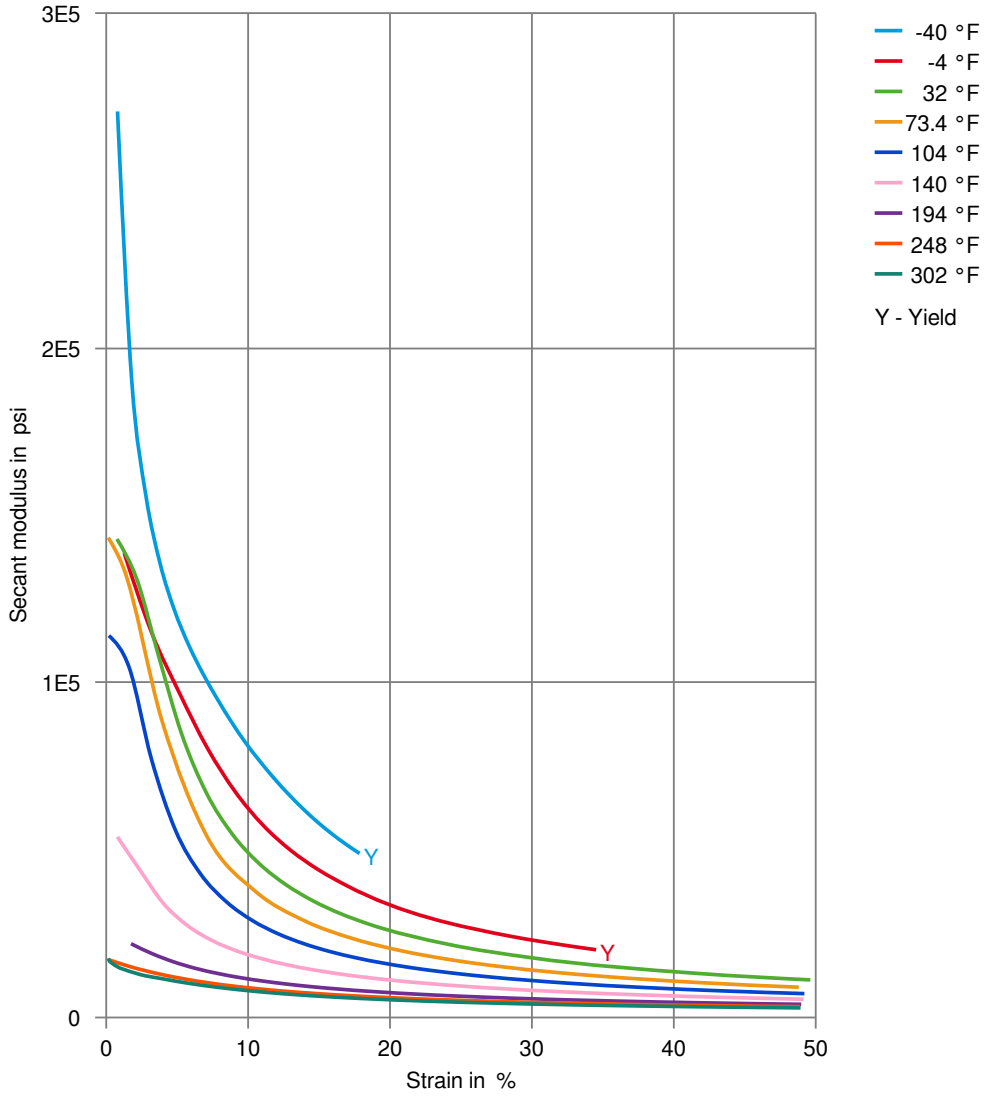
Stress-strain (cond.)



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Secant modulus-strain (dry)

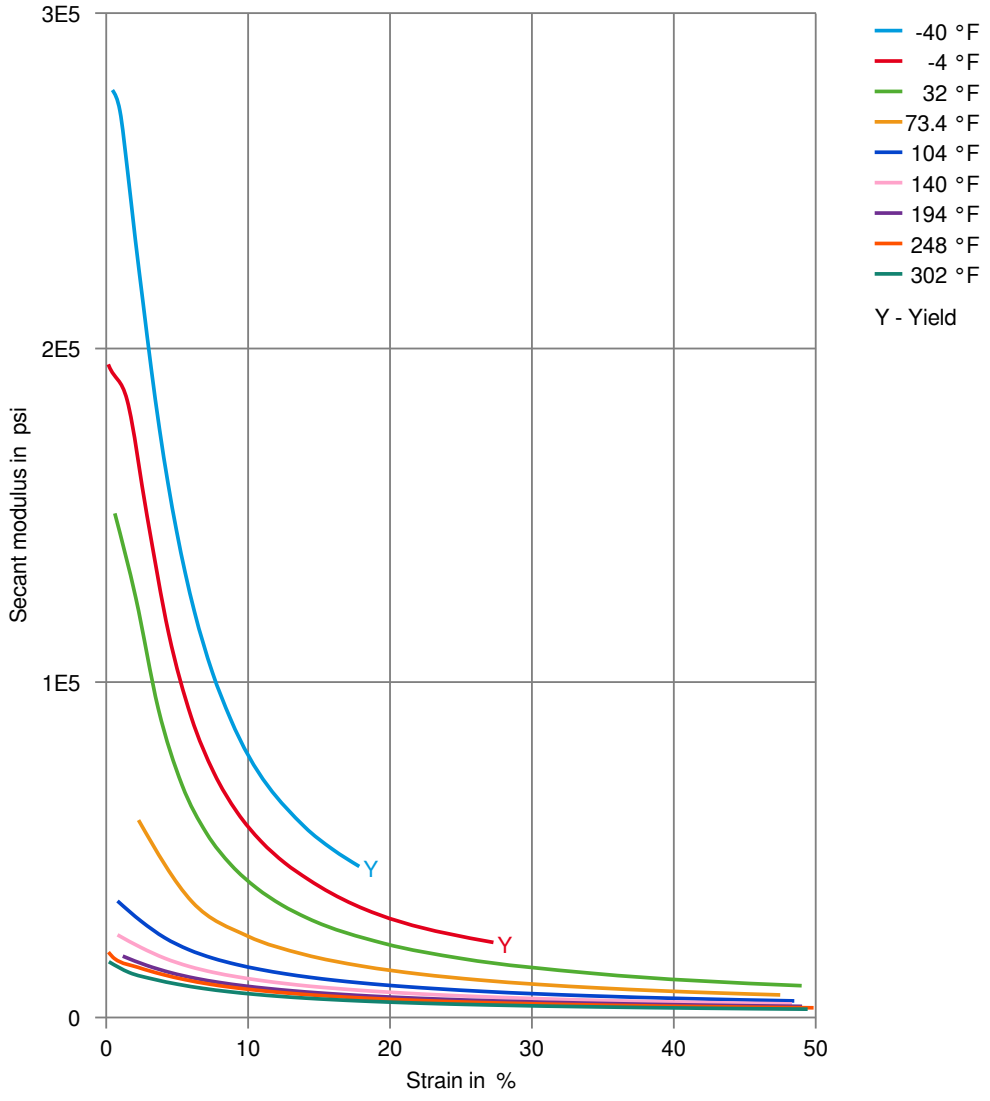


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Secant modulus-strain (cond.)

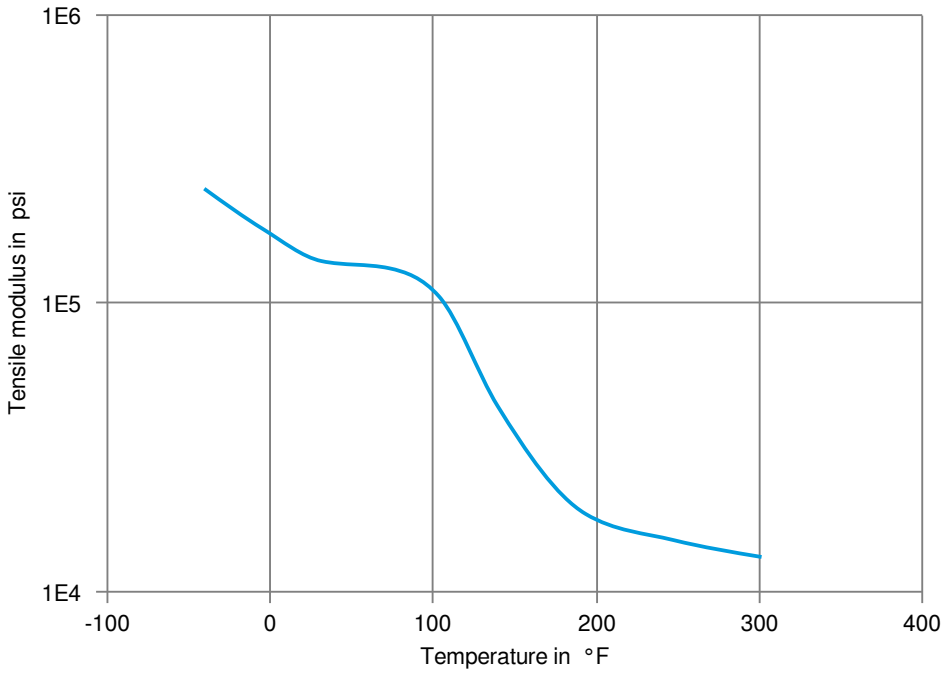


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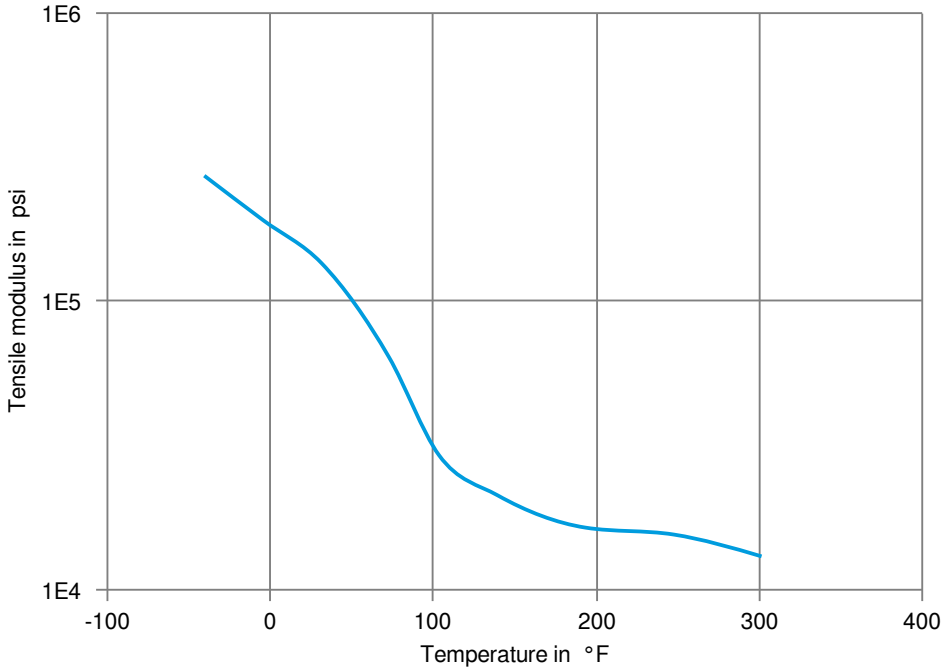
Tensile modulus-temperature (dry)



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Tensile modulus-temperature (cond.)



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