Zytel® PLS95G35DH1EF BK314LM

ZYTEL® PLUS & XT 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® PLS95G35DH1EF BK314LM is a high flow, 35% glass fiber reinforced, SHIELD protected polyamide resin for injection molding. It has been developped for electrical and electronics applications. It provides excellent surface appearance and exceptional resistance to hot air. it is well suited for laser marking

Product information

Resin Identification	PA66/6T-GF35	ISO 1043
Part Marking Code	>PA66/6T-GF35<	ISO 11469
ISO designation	ISO 16396-PA66/6T,GF35,M1GHNR,S12-110	
Infrared spectrum	available	
TGA curve	available	ISO 11358-1

Rheological properties

	dry/cond.		
Viscosity number	3180[1]/*[PV]	in³/lb	ISO 307, 1628
Molding shrinkage, parallel	0.2 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9 / -	%	ISO 294-4, 2577
Melt viscosity , @ 1000 sec-1, 280 °C	1400[2]/*	P	ISO 11443

[PV]: Preliminary Value

[1]: sulphuric acid 96%

[2]: Performed at 280 °C with a Shear Rate of 1000/sec and a Dwell Time of 300 secs using an Orifice with an L/D ratio of 20:1 and an Entrance Angle of 120 °. Results are corrected to 0.13% Moisture.

Typical mechanical properties

	dry/cond.		
Tensile modulus	1.6E6 / 1.16E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	29000 / 20300	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3 / 6	%	ISO 527-1/-2
Charpy impact strength, 23 °C	33.3 / 42.8[DS]	ftlb/in²	ISO 179/1eU
Charpy impact strength, -30 °C	33.3 / 33.3[DS]	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23 °C	5.71 / 6.66[DS]	ftlb/in²	ISO 179/1eA

[DS]: Derived from similar grade

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Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	514 / *	°F	ISO 11357-1/-3
Glass transition temperature, 10°C/min	176 / 104	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	473 / *	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.10 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), Parallel, 23-55°C(73-130°F)	0.1 / -	E-4/°F	ASTM E 831
Coefficient of linear thermal expansion (CLTE), parallel, -40-23°C	0.1 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel, 55-160°C	0.0722 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.489 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), Normal,23-55°C (73-130°F)	0.489 / -	E-4/°F	ASTM E 831
Coefficient of linear thermal expansion (CLTE), normal, -40-23°C	0.389 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal, 55-160°C	0.722 / *	E-4/°F	ISO 11359-1/-2
Thermal conductivity of melt	0.22	W/(m K)	ISO 22007-2
Specific heat capacity of melt	2300[DS]	J/(kg K)	ISO 22007-4

[DS]: Derived from similar grade

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *[DS]	class	IEC 60695-11-10
Thickness tested	0.0591 / *[DS]	in	IEC 60695-11-10
Oxygen index	23 / *	%	ISO 4589-1/-2
FMVSS Class	B[OT]		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	0.984	in/min	ISO 3795 (FMVSS 302)

[DS]: Derived from similar grade

[OT]: One time tested

Electrical properties

	dry/cond.		
Electric strength	838 / -	kV/in	IEC 60243-1
Comparative tracking index	600[3] / -		IEC 60112

[3]: CTI measured up to 700V

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8 / *	%	Sim. to ISO 62
Water absorption, 2mm	6 / *	%	Sim. to ISO 62
Density	0.0516 / -	lb/in³	ISO 1183
Density of melt	78.7[DS]	lb/ft³	

[DS]: Derived from similar grade

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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	536	°F
Max. melt temperature	554	°F
Max. screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	158	°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	410	°F

Characteristics

Processing	Injection Molding
Additives	Release agent, Low halide content
Special characteristics	Heat stabilized or stable to heat, Laser Markable

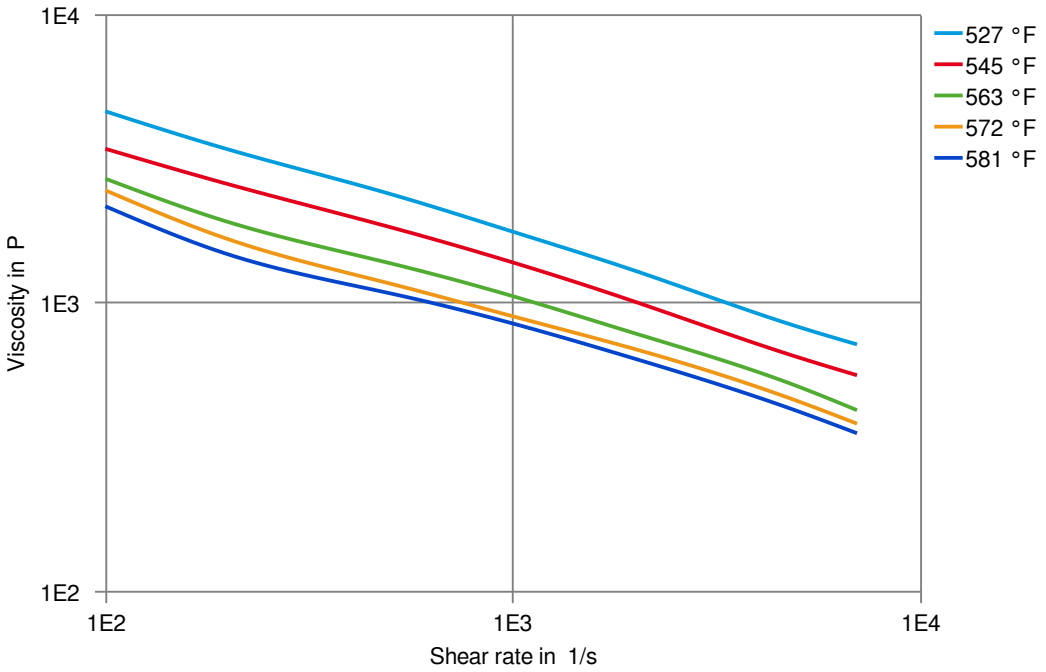
Additional information

Injection molding	Moulding datasheets Moulding guide

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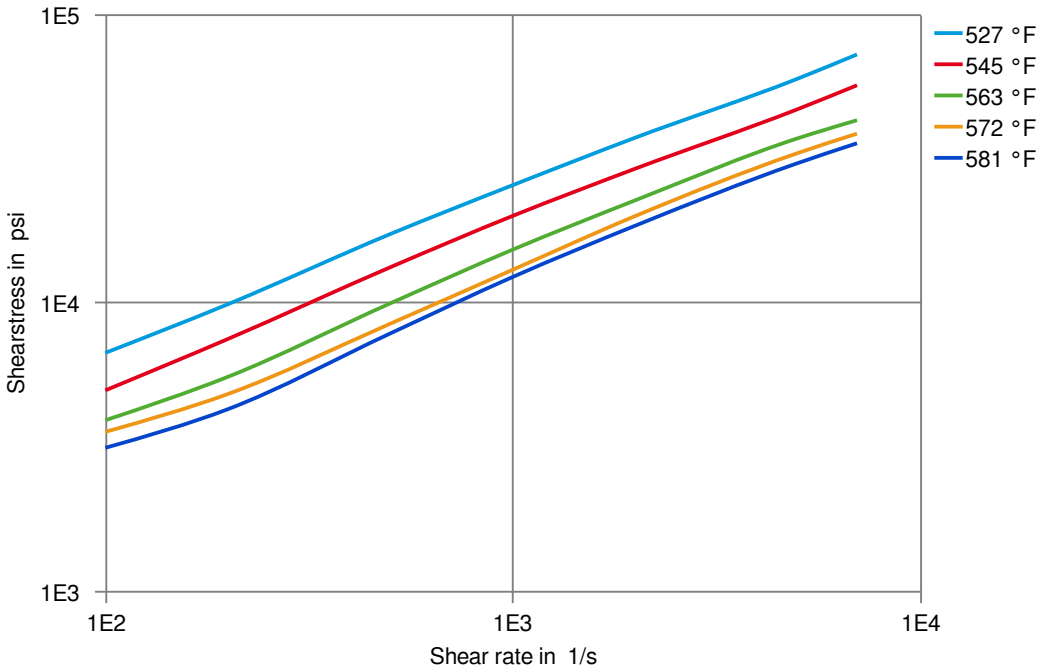
Viscosity-shear rate



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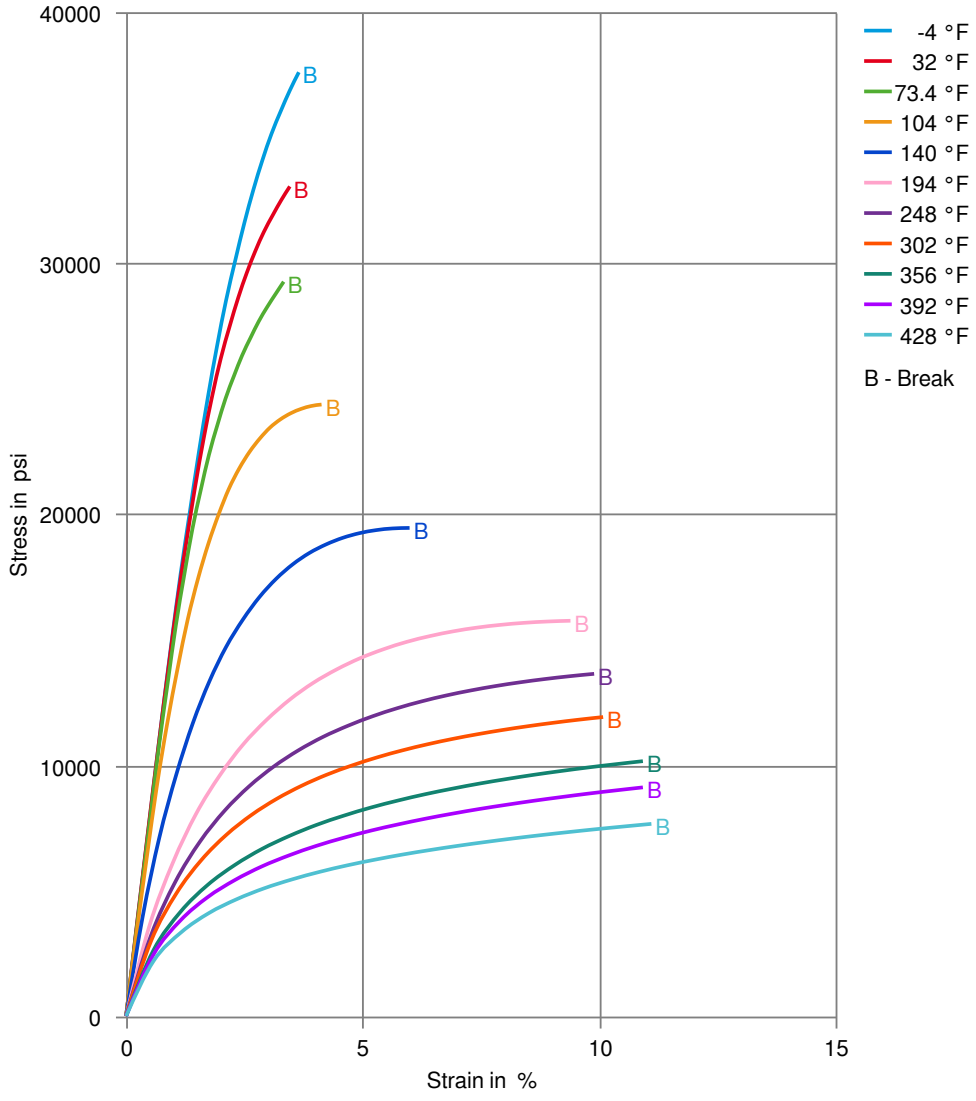
Shearstress-shear rate



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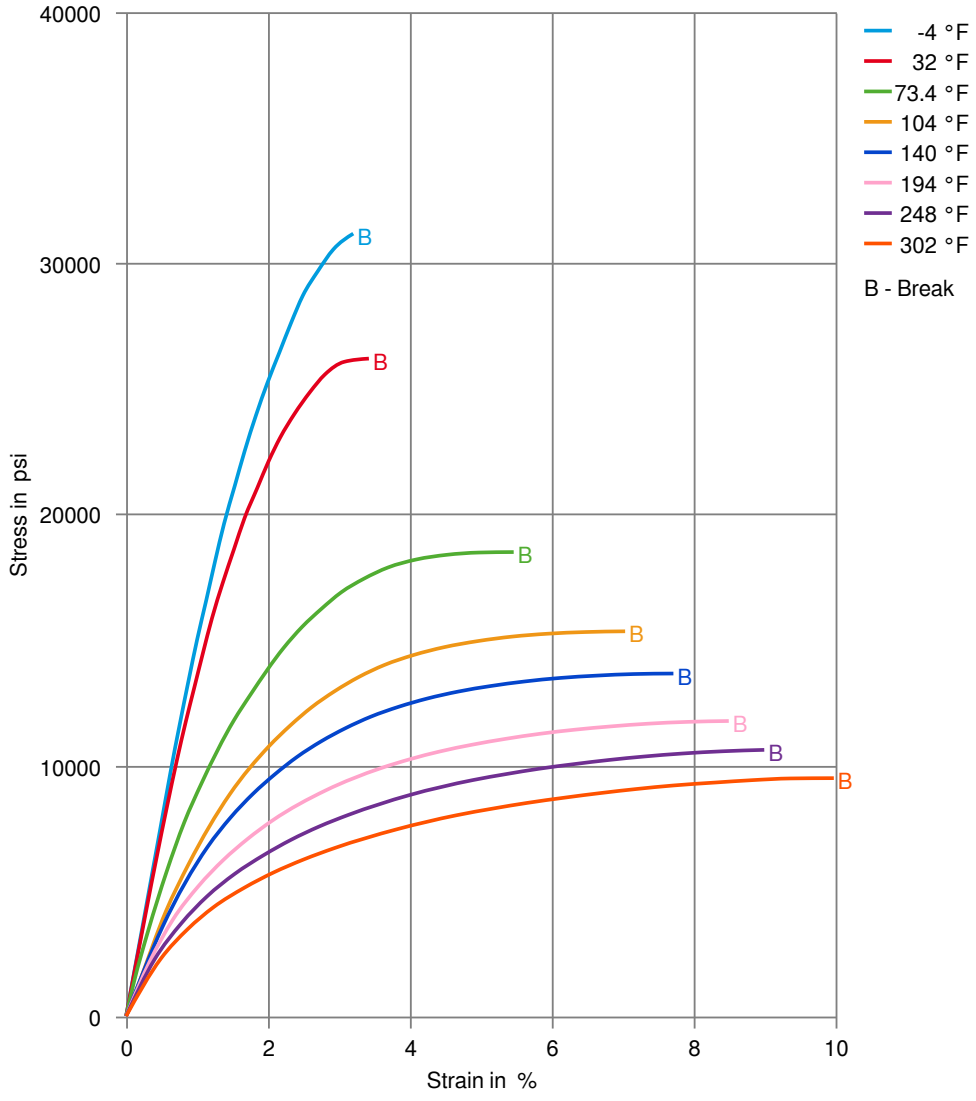
Stress-strain (dry)
(measured on Zytel® PLS95G35DH1 BK549)



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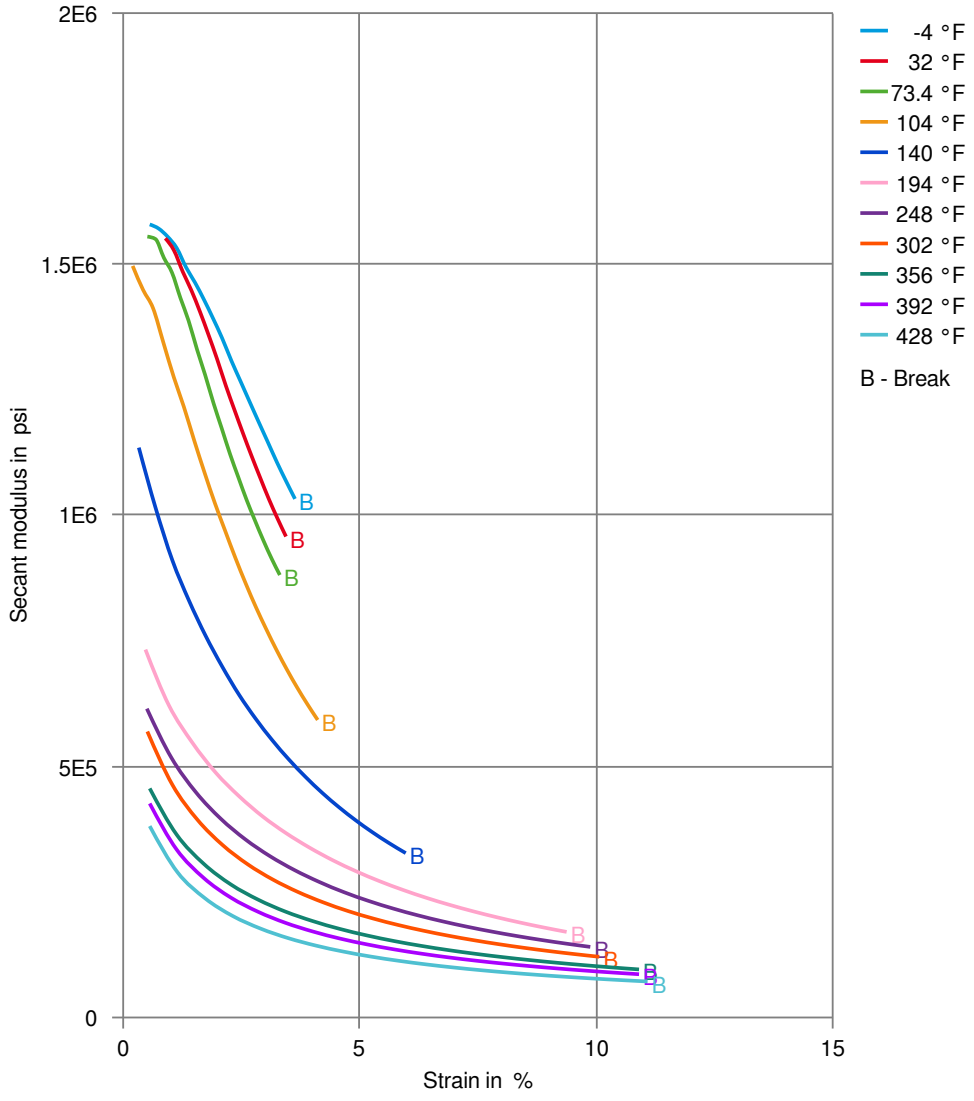
Stress-strain (cond.)
(measured on Zytel® PLS95G35DH1 BK549)



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Secant modulus-strain (dry)
(measured on Zytel® PLS95G35DH1 BK549)

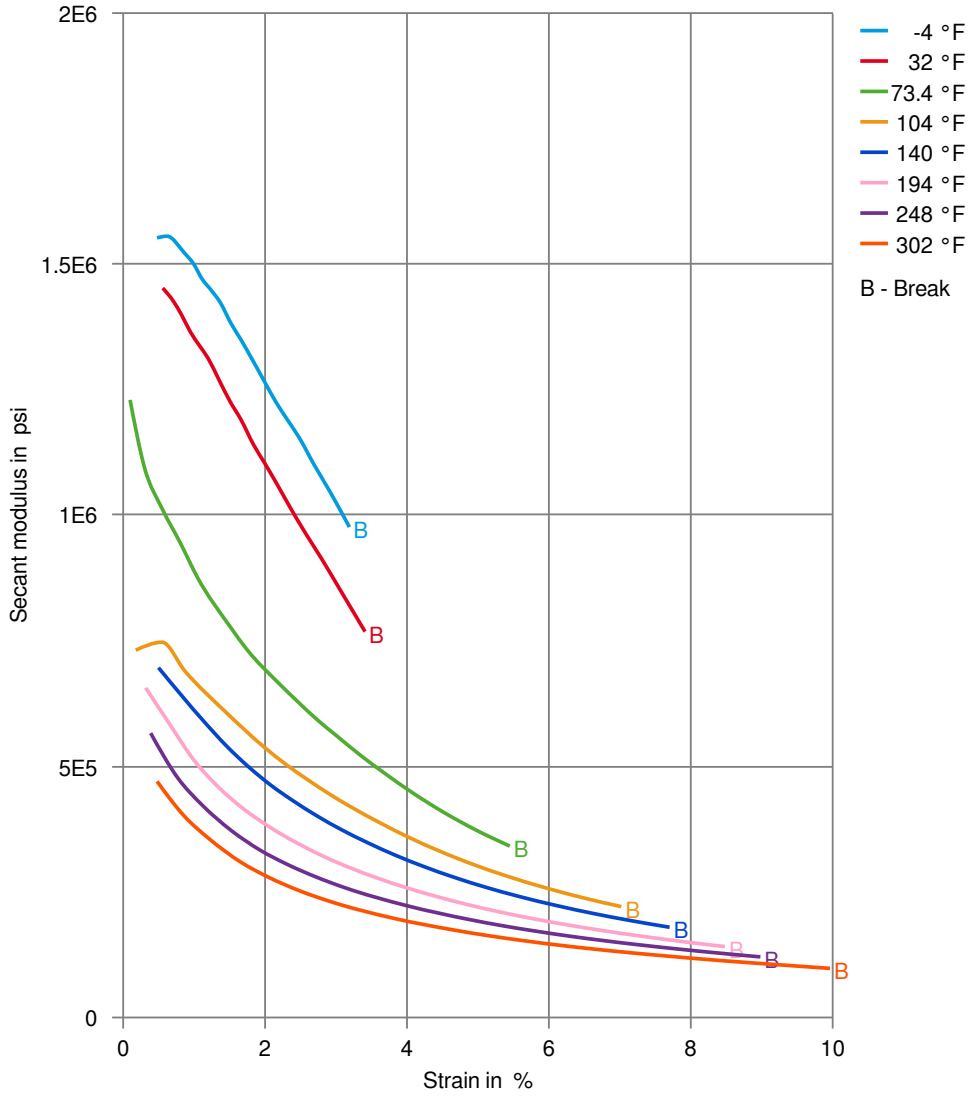


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Secant modulus-strain (cond.)
(measured on Zytel® PLS95G35DH1 BK549)



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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

Mineral oils

- ✔ SAE 10W40 multigrade motor oil, 130°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

- ✘ Zinc Chloride solution (50% by mass), 23°C

Other

- ✔ Water, 23°C
- ✘ Water, 90°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).

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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. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, 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 seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.
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