

DuPont™ Minlon®

mineral reinforced nylon resin

PRELIMINARY DATA

Minlon® 73GM25HSL BK516

Minlon® 73GM25HSL BK516 is a 25% mineral/glass reinforced, heat stabilized, lubricated, black polyamide 6 resin for injection molding.

Property	Test Method	Units	Value
			DAM
Identification			
Resin Identification	ISO 1043		PA6-(MD+GF)25
Part Marking Code	ISO 11469		>PA6-(MD+GF)25<
Mechanical			
Stress at Break	ISO 527	MPa (kpsi)	98 (14.2)
Strain at Break	ISO 527	%	6.6
Tensile Modulus	ISO 527	MPa (kpsi)	5800 (841)
Flexural Modulus	ISO 178	MPa (kpsi)	5400 (783)
Notched Charpy Impact Strength	ISO 179/1eA	kJ/m ²	3.5
Thermal			
Deflection Temperature 1.80MPa	ISO 75-1/-2	°C (°F)	144 (291)
Melting Temperature 10°C/min	ISO 11357-1/-3	°C (°F)	221 (430)
Other			
Density	ISO 1183	kg/m ³ (g/cm ³)	1330 (1.33)
Molding Shrinkage Normal, 2.0mm	ISO 294-4	%	0.7
Parallel, 2.0mm			0.5

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc
ISO Mechanical properties measured at 4.0mm, ISO Electrical properties measured at 2.0mm, and all ASTM properties measured at 3.2mm.
Test temperatures are 23°C unless otherwise stated.

The above data are preliminary and are subject to change as additional data are developed on subsequent lots.

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Product Information

Minlon® 73GM25HSL BK516

Property	Test Method	Units	Value
			DAM
Processing			
Melt Temperature Range		°C (°F)	260-280 (500-535)
Melt Temperature Optimum		°C (°F)	270 (520)
Mold Temperature Range		°C (°F)	70-120 (160-250)
Mold Temperature Optimum		°C (°F)	100 (210)
Drying Time, Dehumidified Dryer		h	2-4
Drying Temperature		°C (°F)	80 (175)
Processing Moisture Content		%	<0.2

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