

DuPont™ Zytel®

nylon resin

Zytel® 80G25HS BK117

Zytel® 80G25HS BK117 is a 25% glass fiber reinforced, toughened, heat stabilized, black polyamide 66 resin for injection molding.

| Property | Test Method | Units | Value | |
|----------------------------------|----------------|-------------------|---------------|------------|
| | | | DAM | 50%RH |
| Identification | | | | |
| Resin Identification | ISO 1043 | | PA66-IGF25 | |
| Part Marking Code | ISO 11469 | | >PA66-IGF25< | |
| Mechanical | | | | |
| Stress at Break | ISO 527 | MPa (kpsi) | 122 (17.7) | 87 (12.6) |
| Strain at Break | ISO 527 | % | 4 | 8 |
| Tensile Modulus | ISO 527 | MPa (kpsi) | 6900 (1000) | 4700 (682) |
| Flexural Modulus | ISO 178 | MPa (kpsi) | 6000 (870) | |
| Notched Charpy Impact Strength | ISO 179/1eA | kJ/m ² | | |
| | | | -30°C (-22°F) | 14 |
| | | | 22 | 24 |
| Unnotched Charpy Impact Strength | ISO 179/1eU | kJ/m ² | | |
| | | | -30°C (-22°F) | 89 |
| | | | 83 | 81 |
| Thermal | | | | |
| Deflection Temperature | ISO 75f | °C (°F) | | |
| | | | 0.45MPa | 258 (496) |
| | | | 240 (464) | |
| Melting Temperature | ISO 11357-1/-3 | °C (°F) | | |
| | | | 10°C/min | 262 (504) |

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.

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050330/050330

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Zytel® 80G25HS BK117

| Property | Test Method | Units | Value | |
|--------------------------------------|-------------|----------------------------------------|-------------------|-------|
| | | | DAM | 50%RH |
| Other | | | | |
| Density | ISO 1183 | kg/m ³ (g/cm ³) | 1250 (1.25) | |
| Molding Shrinkage Parallel, 2.0mm | ISO 294-4 | % | 0.3 | |
| Processing | | | | |
| Melt Temperature Range | | °C (°F) | 285-305 (545-580) | |
| Melt Temperature Optimum | | °C (°F) | 295 (565) | |
| Mold Temperature Range | | °C (°F) | 50-100 (120-210) | |
| Mold Temperature Optimum | | °C (°F) | 80 (175) | |
| Drying Time, Dehumidified Dryer | | h | 2-4 | |
| Drying Temperature | | °C (°F) | 80 (175) | |
| Processing Moisture Content | | % | <0.20 | |

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