

Zytel® 135F NC010

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® 135F is a nucleated polyamide 66 resin for injection moulding. It was developed for fast cycles and high productivity.

Product information

Resin Identification	PA66	ISO 1043
Part Marking Code	>PA66<	ISO 11469
ISO designation	ISO 16396-PA66,,M1G1NR,S14-040	

Rheological properties

	dry/cond.		
Viscosity number	150 ^[1] /*	cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage, parallel	0.7 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.3 / -	%	ISO 294-4, 2577

[1]: Sulfuric acid 96%

Typical mechanical properties

	dry/cond.		
Tensile Modulus	3600 / 2000	MPa	ISO 527-1/-2
Yield stress, 50mm/min	98 / 67	MPa	ISO 527-1/-2
Yield strain, 50mm/min	4.5 / 18	%	ISO 527-1/-2
Nominal strain at break	13 / 50	%	ISO 527-1/-2
Strain at break, 50mm/min	20 / -	%	ISO 527-1/-2
Flexural Modulus	3300 / -	MPa	ISO 178
Flexural Stress at 3.5%	110 / -	MPa	ISO 178
Tensile creep modulus, 1h	*/2000	MPa	ISO 899-1
Tensile creep modulus, 1000h	*/1280	MPa	ISO 899-1
Charpy impact strength, 23°C	N / N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N / N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4 / 9	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	3 / 2.5	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	3.5 / 9	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C	3 / 2	kJ/m ²	ISO 180/1A
Hardness, Rockwell, M-scale	87 / 64		ISO 2039-2
Hardness, Rockwell, R-scale	123 / 116		ISO 2039-2



Zytel® 135F NC010

NYLON RESIN

Poisson's ratio 0.36/0.4

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	263 / *	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	60 / 40	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	75 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	245 / *	°C	ISO 306
Coeff. of linear therm. expansion, parallel	121 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	121 / *	E-6/K	ISO 11359-1/-2
Thermal conductivity of melt	0.16	W/(m K)	Internal
Spec. heat capacity of melt	2790	J/(kg K)	Internal
RTI, electrical, 0.75mm	130	°C	UL 746B
RTI, electrical, 1.5mm	130	°C	UL 746B
RTI, electrical, 3mm	130	°C	UL 746B
RTI, electrical, 6mm	130	°C	UL 746B
RTI, impact, 0.75mm	75	°C	UL 746B
RTI, impact, 1.5mm	75	°C	UL 746B
RTI, impact, 3mm	75	°C	UL 746B
RTI, impact, 6mm	75	°C	UL 746B
RTI, strength, 0.75mm	85	°C	UL 746B
RTI, strength, 1.5mm	85 / *	°C	UL 746B
RTI, strength, 3mm	85	°C	UL 746B
RTI, strength, 6mm	85	°C	UL 746B

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	V-2 / *	class	UL 94
Thickness tested	1.5 / *	mm	UL 94
UL recognition	yes / *		UL 94
Burning Behav. at thickness h	V-2 / *	class	UL 94
Thickness tested	0.71 / *	mm	UL 94
UL recognition	yes / *		UL 94
Glow Wire Flammability Index, 0.75mm	960 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	960 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 3mm	960 / -	°C	IEC 60695-2-12
Glow Wire Ignition Temperature, 0.75mm	725 / -	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 1.5mm	750 / -	°C	IEC 60695-2-13
Glow Wire Ignition Temperature, 3mm	800 / -	°C	IEC 60695-2-13
Glow Wire Temperature, No Flame, 1mm	775 / -	°C	IEC 60335-1
Glow Wire Temperature, No Flame, 3mm	700 / -	°C	IEC 60335-1
FMVSS Class	DNI		ISO 3795 (FMVSS 302)



Zytel® 135F NC010

NYLON RESIN

Electrical properties

	dry/cond.	
Relative permittivity, 100Hz	3.9/8.7	IEC 62631-2-1
Relative permittivity, 1MHz	3.8/3.9	IEC 62631-2-1
Dissipation factor, 100Hz	70/2400 E-4	IEC 62631-2-1
Dissipation factor, 1MHz	200/600 E-4	IEC 62631-2-1
Comparative tracking index	600/-	IEC 60112

Other properties

	dry/cond.	
Humidity absorption, 2mm	2.7/* %	Sim. to ISO 62
Water absorption, 2mm	8.5/* %	Sim. to ISO 62
Density	1140/- kg/m ³	ISO 1183
Density of melt	1010 kg/m ³	Internal

Film Properties

	dry/cond.	
Strain at yield, parallel	4.5/* %	ISO 527-3

Injection

Drying Recommended	yes	
Drying Temperature	80 °C	
Drying Time, Dehumidified Dryer	2 - 4 h	
Processing Moisture Content	≤0.2 %	
Melt Temperature Optimum	290 °C	Internal
Min. melt temperature	280 °C	
Max. melt temperature	300 °C	
Screw tangential speed	≤0.3 m/s	
Mold Temperature Optimum	70 °C	
Min. mould temperature	50 °C	
Max. mould temperature	90 °C	
Hold pressure range	50 - 100 MPa	
Hold pressure time	3.5 s/mm	
Ejection temperature	190 °C	Internal

Characteristics

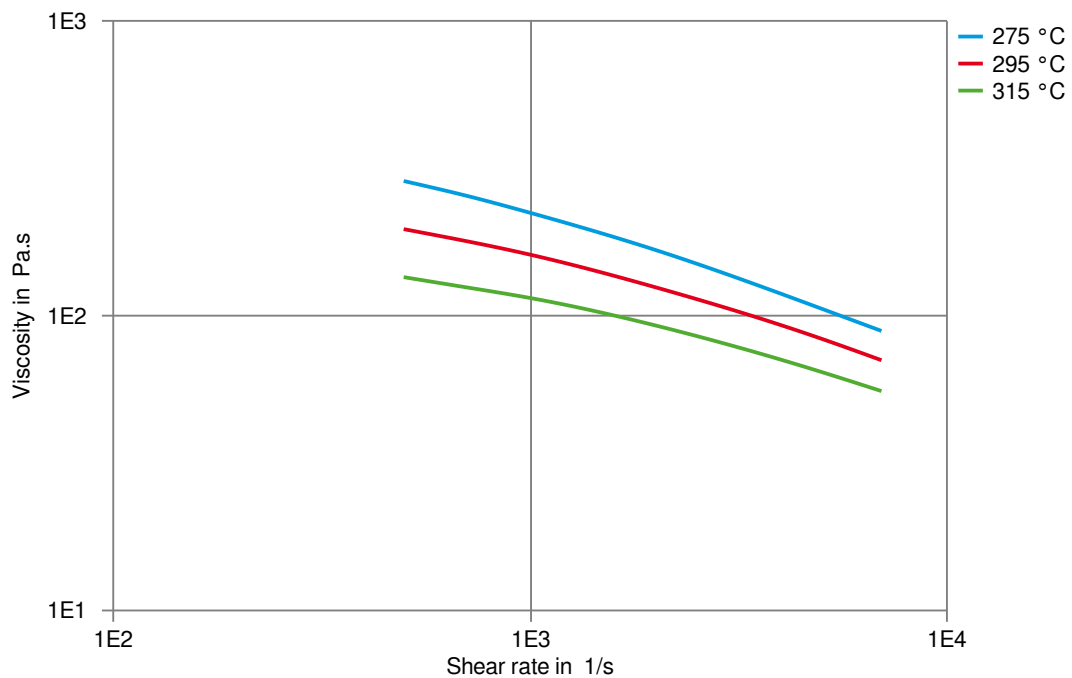
Additives	Release agent
-----------	---------------



Zytel® 135F NC010

NYLON RESIN

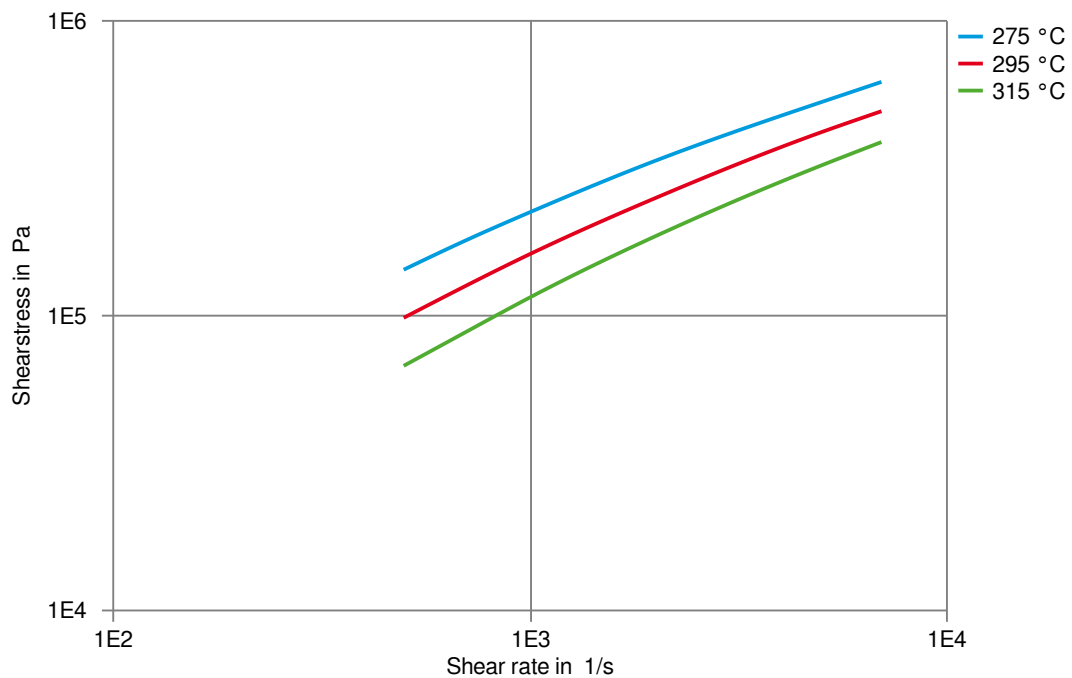
Viscosity-shear rate



Zytel® 135F NC010

NYLON RESIN

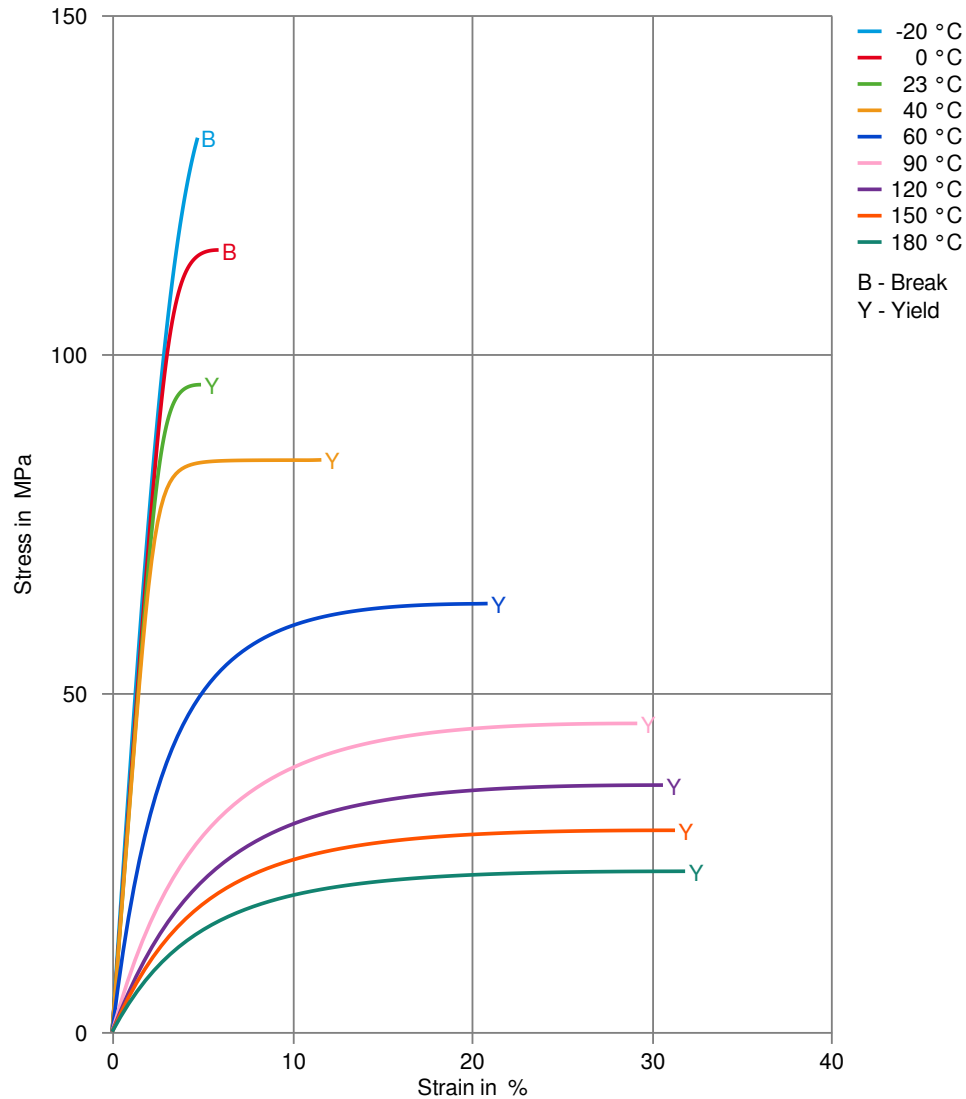
Shearstress-shear rate



Zytel® 135F NC010

NYLON RESIN

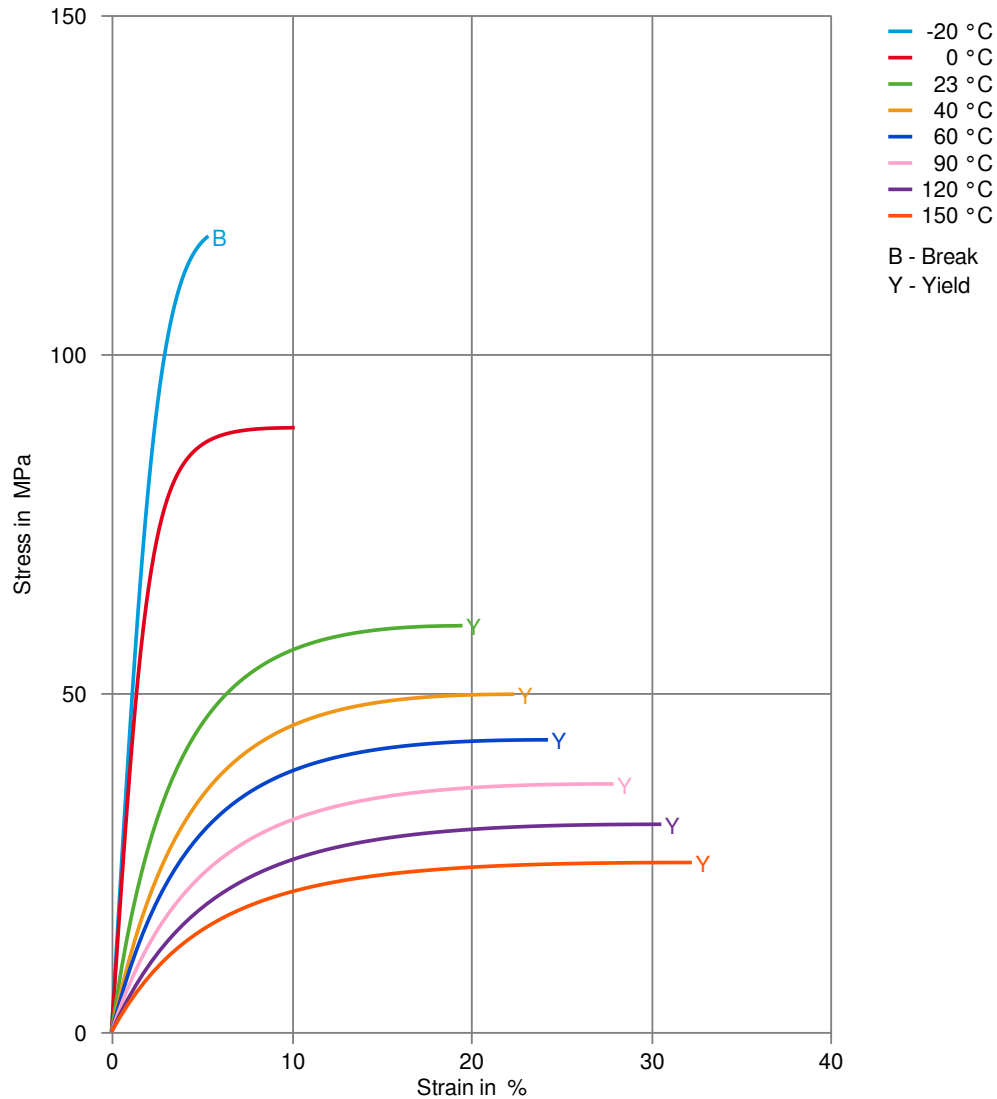
Stress-strain (dry)



Zytel® 135F NC010

NYLON RESIN

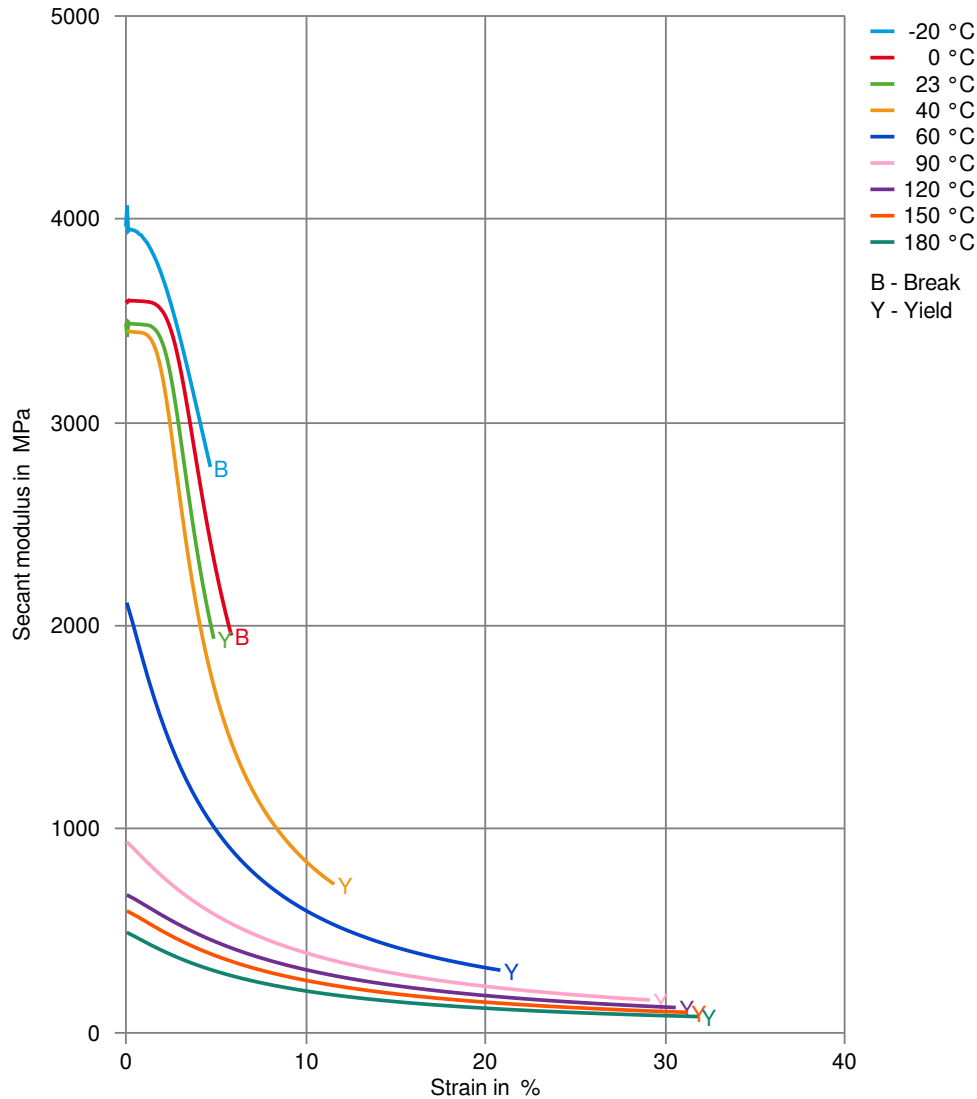
Stress-strain (cond.)



Zytel® 135F NC010

NYLON RESIN

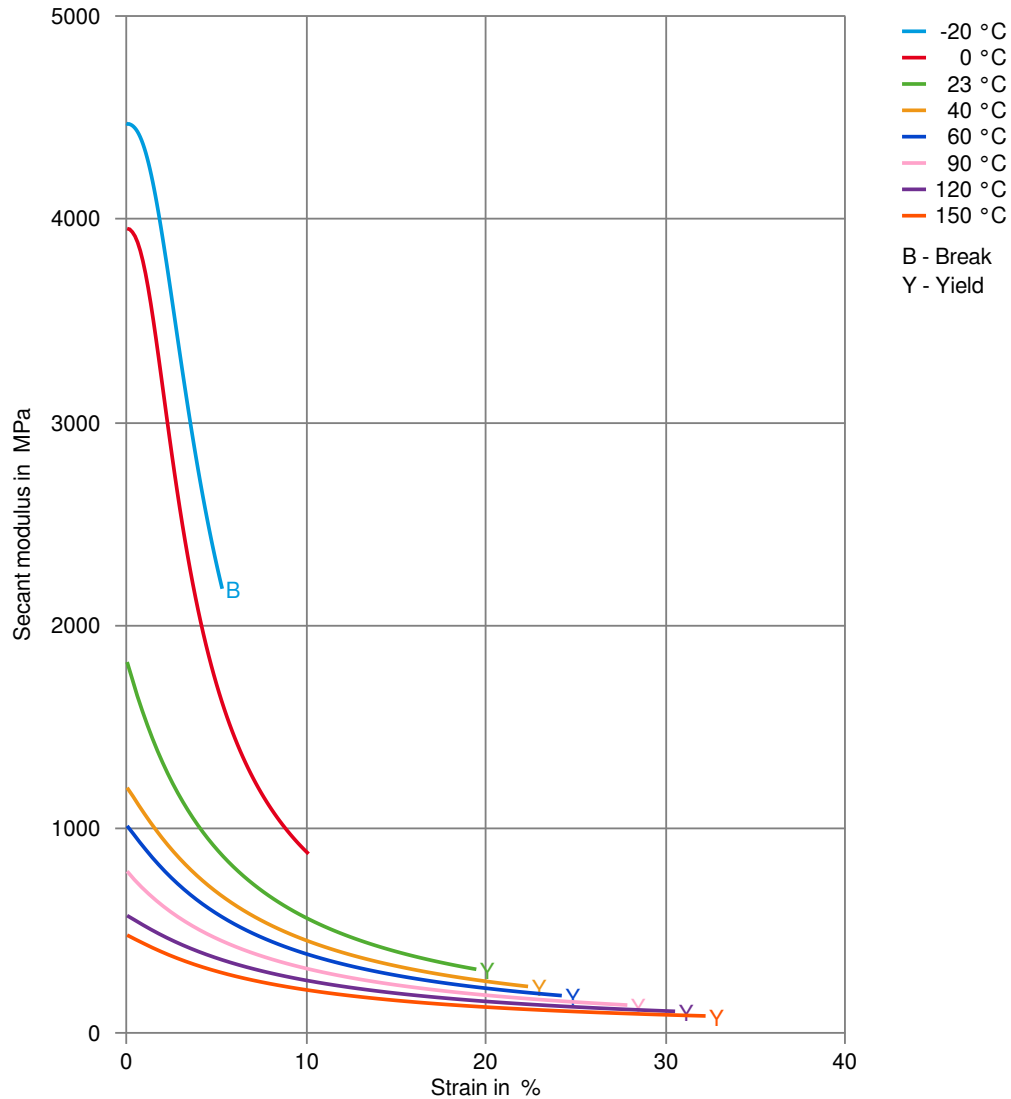
Secant modulus-strain (dry)



Zytel® 135F NC010

NYLON RESIN

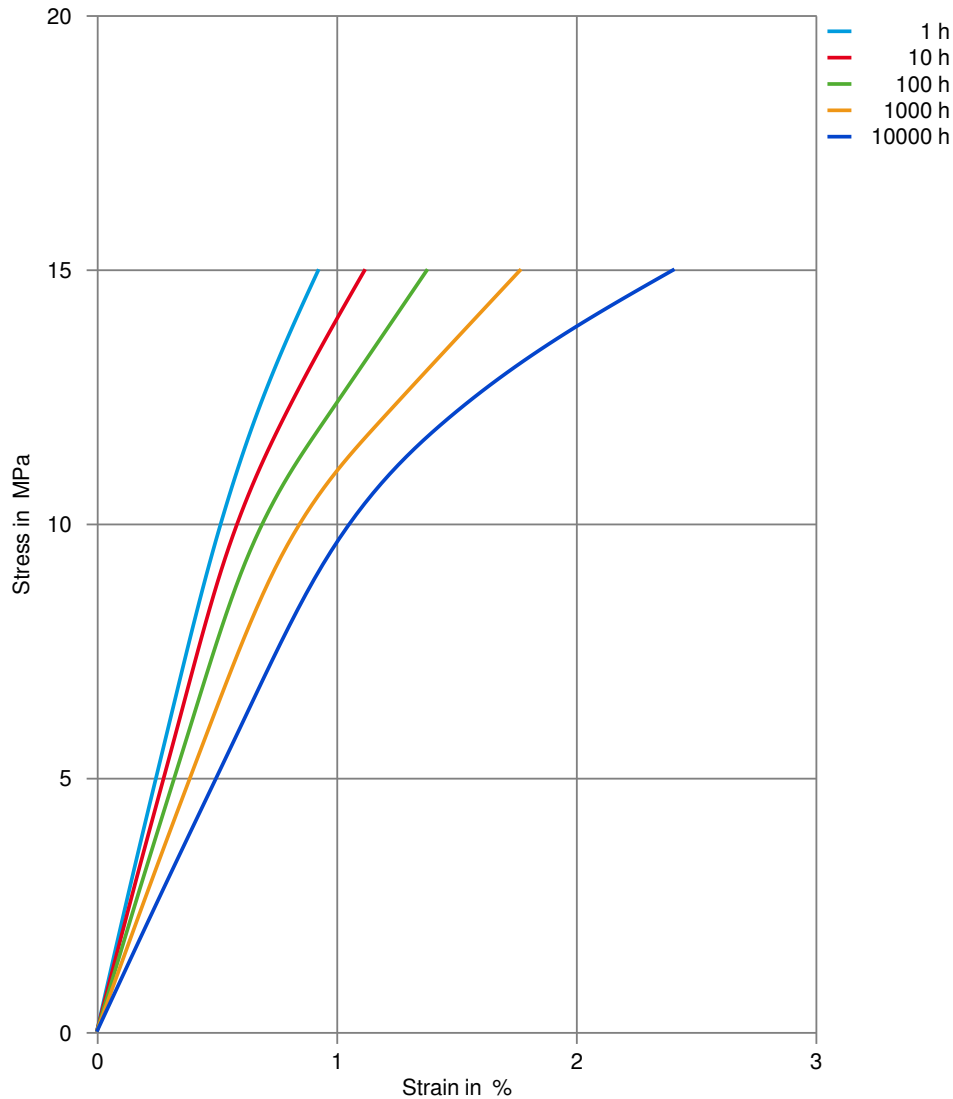
Secant modulus-strain (cond.)



Zytel® 135F NC010

NYLON RESIN

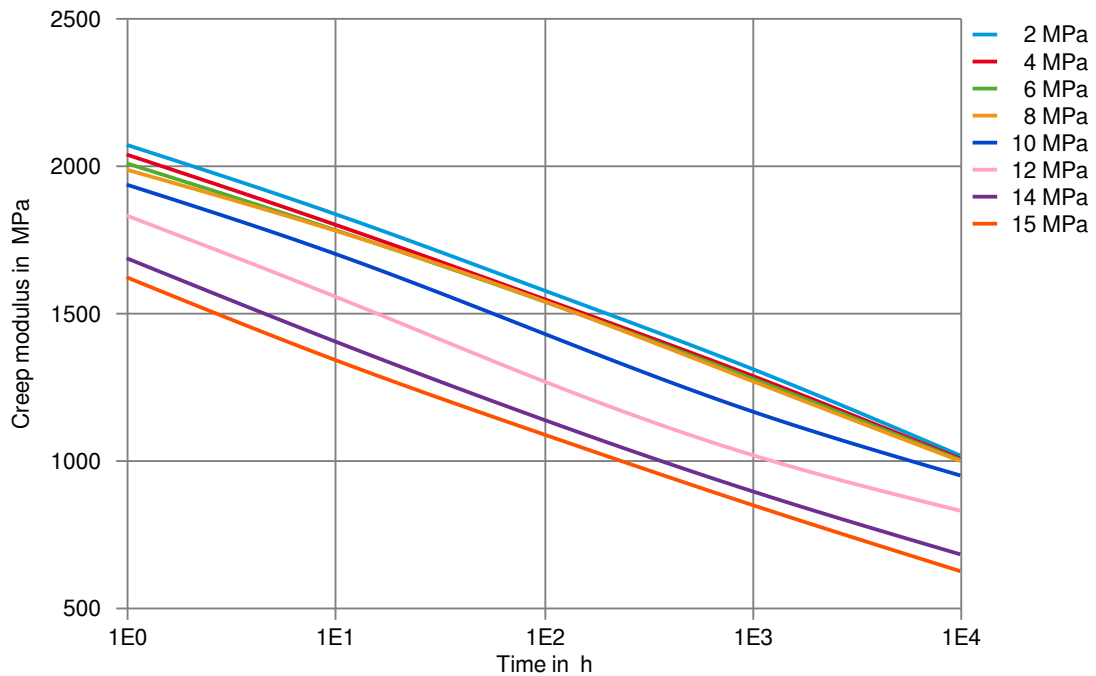
Stress-strain (isochronous) 23°C (cond.)



Zytel® 135F NC010

NYLON RESIN

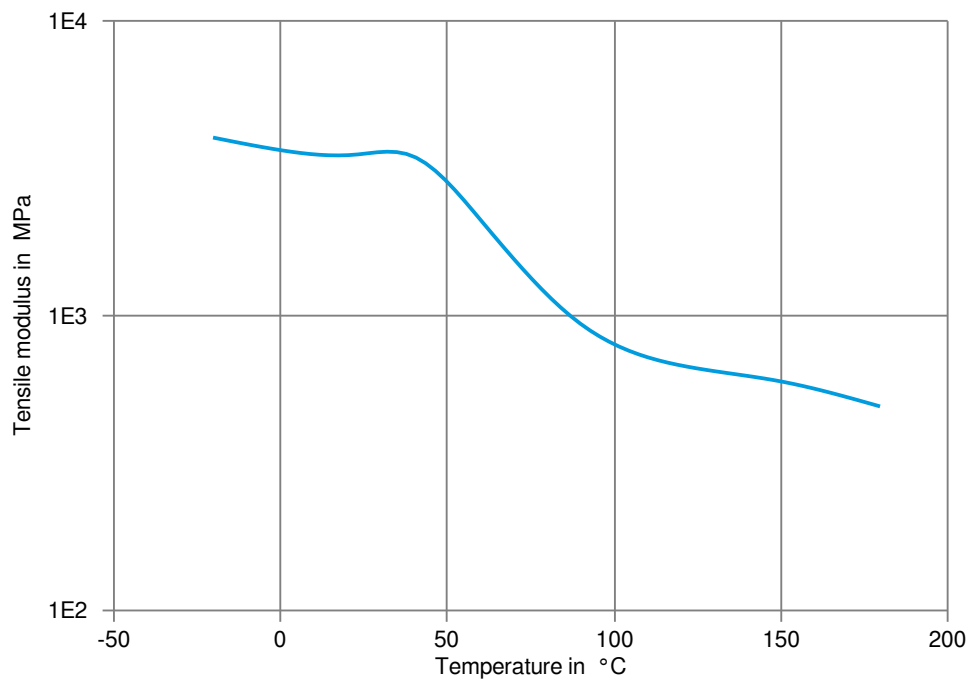
Creep modulus-time 23°C (cond.)



Zytel® 135F NC010

NYLON RESIN

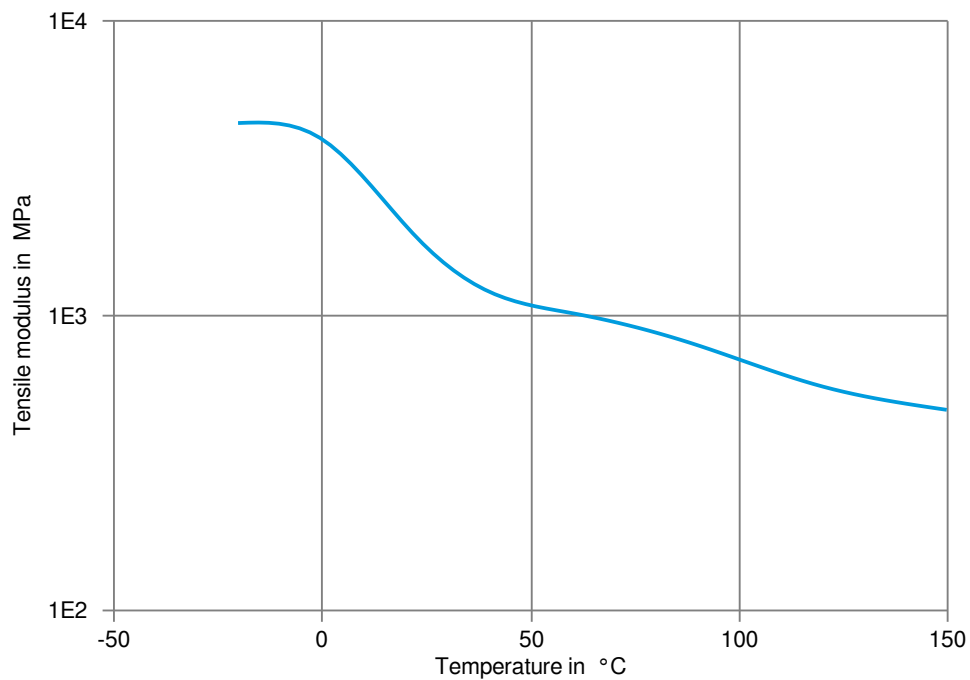
Tensile modulus-temperature (dry)



Zytel® 135F NC010

NYLON RESIN

Tensile modulus-temperature (cond.)



Zytel® 135F NC010

NYLON RESIN

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



Zytel® 135F NC010

NYLON RESIN

Salt solutions

- ✓ Sodium Chloride solution (10% by mass), 23°C
- ✗ Sodium Hypochlorite solution (10% by mass), 23°C
- ✓ 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

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).

