

# INJECTION DATASHEET

## Zytel® 73G15L NC010

### NYLON RESIN

Zytel® 73G15L NC010 is a 15% glass fiber reinforced polyamide 6 resin for injection moulding.

#### General Information

Resin Identification ISO 1043

Density ISO 1183

PA6-GF15

1230/- kg/m<sup>3</sup>

#### Drying

Drying Recommended

yes

Drying Temperature\*\*

80 °C

Drying Time\*

2 - 4 h

Processing Moisture Content - Optimum\*\*

0.1 %

Processing Moisture Content

≤0.2 %

#### Temperature settings

Melt Temperature Optimum Internal

270 °C

Min. melt temperature\*\*\*

260 °C

Max. melt temperature

280 °C

Mold Temperature Optimum

100 °C

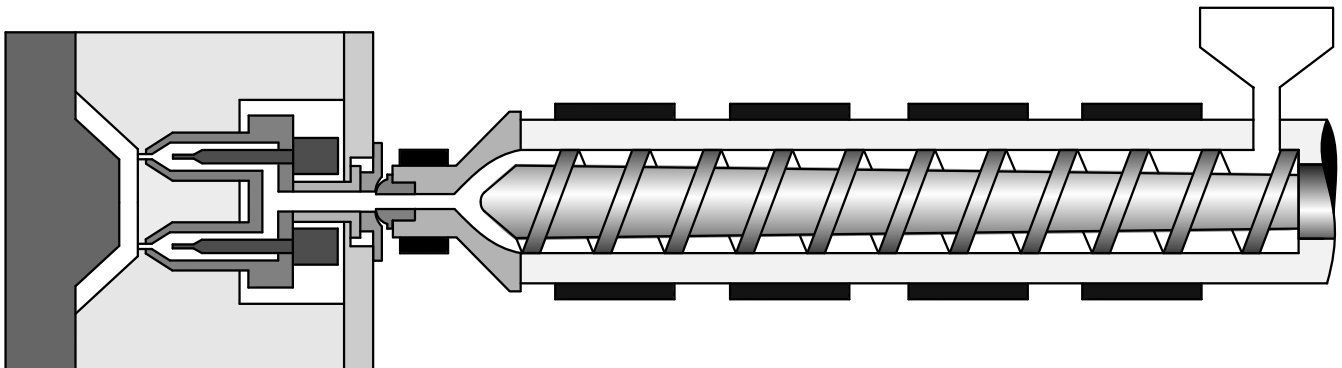
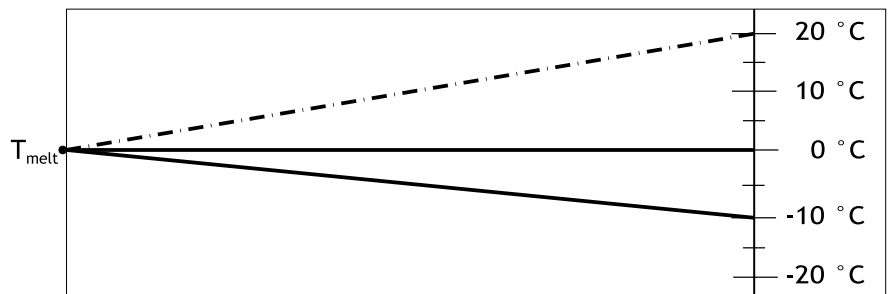
Min. mould temperature

70 °C

Max. mould temperature

120 °C

|               |     |
|---------------|-----|
| 3 D (< 3 min) | --- |
| 2 D (3-5 min) | ==  |
| 1 D (> 5 min) | ==  |



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### Recommended general settings

|                                                                        |                |
|------------------------------------------------------------------------|----------------|
| Residence time - optimum range                                         | 3 - 5 min      |
| Residence time - maximum                                               | 10 min         |
| Hold pressure range                                                    | 50 - 100 MPa   |
| Hold Pressure Time<br>(h is the max. wall thickness of the part in mm) | $h^2 + 2$ s    |
| Max. screw tangential speed                                            | $\leq 0.2$ m/s |

$$\text{Residence time} = \frac{8 \cdot \text{screw } \varnothing [\text{mm}] \cdot \text{cycle time [s]}}{60 \cdot \text{dosing stroke [mm]}}$$

*Hot runner residence time not included in calculation*

### Special precautions

During molding, use proper protective equipment and adequate ventilation. Avoid fumes and limit the residence time and temperature of the resin in the machine.

### Links for further information

#### Trouble Shooting Guide

For further information e.g. on Shrinkage, Hot runner systems, Venting, Gating, Drying and moisture measurement, Regrind, Purging, please refer to the detailed Molding Guide.

#### Footnotes:

- \* Improper storage may lead to longer drying times
- \*\* Excessive drying may lead to viscosity increase during processing. A discoloration of natural colored materials is possible.
- \*\*\* Using melt temperature lower than recommended could create unmelt, leading to weak parts