

DuPont™ Zytel® FE4200 BK136

NYLON RESIN

Product Information

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, DuPont recommends, 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® FE4200 BK136 is a low die deposit polyamide 66 extrusion resin.

General information	Value	Unit	Test Standard
Resin Identification	PA66-HI	-	ISO 1043
Part Marking Code	PA66-HI	-	ISO 11469
Rheological properties	dry / cond	Unit	Test Standard
Molding shrinkage, parallel	1.7 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / -	%	ISO 294-4, 2577
Mechanical properties	dry / cond	Unit	Test Standard
Tensile Modulus	1900 / -	MPa	ISO 527-1/-2
Yield stress	49 / -	MPa	ISO 527-1/-2
Yield strain	4.9 / -	%	ISO 527-1/-2
Flexural Modulus	1790 / -	MPa	ISO 178
Charpy notched impact strength, 73 °F	74 / -	kJ/m ²	ISO 179/1eA
Thermal properties	dry / cond	Unit	Test Standard
Melting temperature, 18 °F/min	261 / *	°C	ISO 11357-1/-3
Temp. of deflection under load			ISO 75-1/-2
260 psi	62 / *	°C	
65 psi	98 / *	°C	
Flammability	Value	Unit	Test Standard
FMVSS Class	B	-	ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	<100	mm/min	ISO 3795 (FMVSS 302)
Other properties	dry / cond	Unit	Test Standard
Density	1060 / -	kg/m ³	ISO 1183
Injection	dry / cond	Unit	Test Standard
Drying Recommended	yes	-	-
Drying Temperature	80	°C	-
Drying Time, Dehumidified Dryer	2 - 4	h	-
Processing Moisture Content	≤0.2	%	-
Melt Temperature Optimum	290	°C	-
Min. melt temperature	280	°C	-
Max. melt temperature	300	°C	-
Max. screw tangential speed	0.3 / *	m/s	-
Mold Temperature Optimum	80	°C	-
Min. mold temperature	50	°C	-
Max. mold temperature	100	°C	-
Hold pressure range	50 - 100	MPa	-
Hold pressure time	4	s/mm	-
Ejection temperature	190	°C	-

Characteristics

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Page: 1 of 2

To find out more, visit [DuPont Performance Polymers](#) or contact nearest DuPont location.

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Processing	<ul style="list-style-type: none">• Injection Molding• Film Extrusion• Profile Extrusion	<ul style="list-style-type: none">• Sheet Extrusion• Other Extrusion• Coating	<ul style="list-style-type: none">• Casting
Delivery form	<ul style="list-style-type: none">• Pellets		
Regional Availability	<ul style="list-style-type: none">• North America	<ul style="list-style-type: none">• South and Central America	

Contact DuPont for Material Safety Data Sheet, general guides and/or additional information about ventilation, handling, purging, drying, etc. ISO Mechanical properties measured at 160 mil (Hytrel® measured at 80 mil), IEC Electrical properties measured at 80 mil, all ASTM properties measured at 120 mil, and test temperatures are 73°F unless otherwise stated.

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