

# Zytel® 70G30HSLR ECO-R 312 BK099

## NYLON RESIN

Zytel® 70G30HSLR ECO-R BK099 is a 30% glass fibre reinforced, heat stabilised, hydrolysis resistant polyamide 66 resin for injection molding. It has same performance and processing properties as Zytel® 70G30HSLR BK099.

### General Information

Density ISO 1183 1370/- kg/m<sup>3</sup>

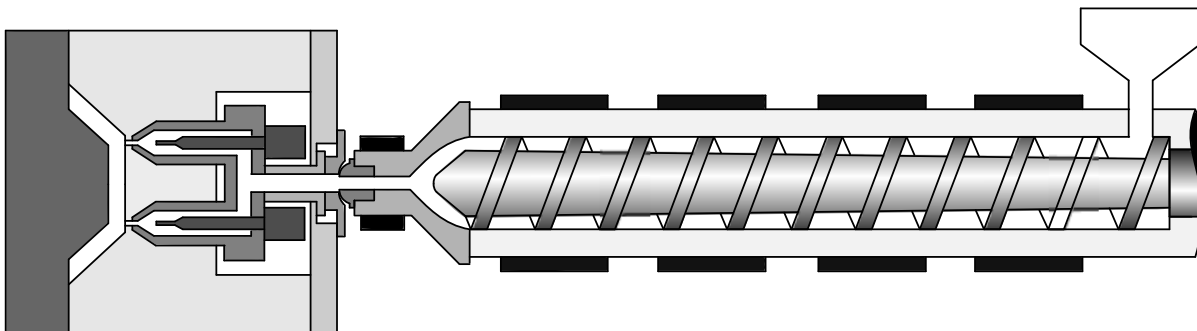
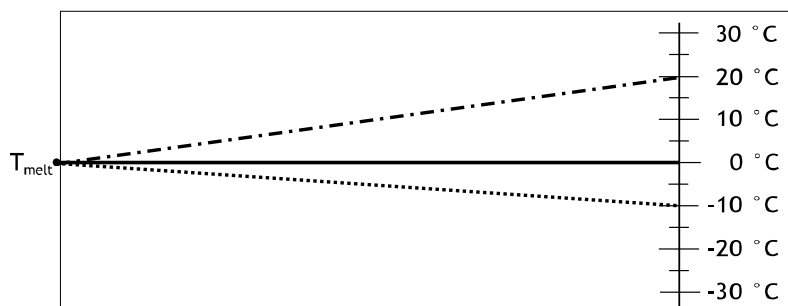
### Drying

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 295 °C  
 Min. melt temperature\*\*\* 285 °C  
 Max. melt temperature 305 °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) .....  
 D = Drying



# INJECTION DATASHEET

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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	$h^2+2$ s
(h is the max. wall thickness of the part in mm)	
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.
- \*\*\* Use melt temperature lower than recommended could create unmelt, leading to weak parts

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