

DuPont™ Zytel®

nylon resin

Zytel® 7304 NC010

Zytel® 7304 NC010 is a medium viscosity, unlubricated polyamide 6 resin for extrusion applications.

Property	Test Method	Units	Value	
			DAM	50%RH
Identification				
Resin Identification	ISO 1043		PA6	
Part Marking Code	ISO 11469		>PA6<	
Mechanical				
Tensile Strength at Yield	ASTM D 638	MPa (kpsi)	80 (11.6)	50 (7.2)
Tensile Modulus	ASTM D 638	MPa (kpsi)	3000 (435)	1500 (218)
Izod Impact	ASTM D 256	J/m (ft lb/in)		
-40°C (-40°F)			48 (0.9)	
23°C (73°F)			133 (2.5)	640 (12)
Thermal				
Heat Deflection Temperature	ASTM D 648	°C (°F)		
0.45MPa (66psi)			160 (320)	
1.8MPa (264psi)			65 (149)	
Melting Point	ASTM D 3418	°C (°F)	220 (428)	
Other				
Specific Gravity	ASTM D 792		1.13	
Water Absorption	ASTM D 570	%		
Equilibrium 50%RH			3.0	
Mold Shrinkage		%		
Flow, 3.2mm (0.125in)			1.2	

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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Property	Test Method	Units	Value	
			DAM	50%RH
Processing - Injection Molding				
Melt Temperature Range		°C (°F)	260-280 (500-535)	
Melt Temperature Optimum		°C (°F)	270 (520)	
Mold Temperature Range		°C (°F)	50-90 (120-190)	
Mold Temperature Optimum		°C (°F)	70 (160)	
Drying Time, Dehumidified Dryer		h	2-4	
Drying Temperature		°C (°F)	80 (175)	
Processing Moisture Content		%	<0.05	
Processing - Extrusion				
Melt Temperature Range		°C (°F)	230-240 (445-465)	
Melt Temperature Optimum		°C (°F)	235 (455)	
Drying Time, Dehumidified Dryer		h	4-6	
Drying Temperature		°C (°F)	80 (175)	
Processing Moisture Content		%	<0.05	

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